



## Product Group

Polyurethane Topcoats

## Characteristics



Product  
Information

Aerodur<sup>®</sup> HS 67348 is a 3-component, semi gloss polyurethane finish for interior use.

- Resistant to aircraft hydraulic fluids and chemicals.
- High Solids.
- Compatible with Aerodur<sup>®</sup> HS Primer 37092 and Epoxy Primer 37035A.

## Components



Hardener Thinner  
or  
Activator

Hardener 90150  
Activator 99302

## Specifications



Qualified Product  
List

Airbus UK	ABP 4-2130
Airbus	AIMS 04-04-003 / 040 / 041
Hawker Beechcraft	BAEP3528-4PSD2

For most recent up-date or missing specifications please check the qualified product list (QPL) on [www.akzonobel.com/aerospace](http://www.akzonobel.com/aerospace)

## Surface Conditions



Cleaning

- Observe the recoatability limits of the relevant primer.
- Remove oil, grease and other contaminants prior to application of the finish.
- Recondition aged primers or topcoats with e.g. Scotch-Brite<sup>®</sup> type A very fine till a uniform matt surface.
- Remove dust with e.g. tack rags prior to application of the finish.

## Instruction for Use



Mixing Ratio  
(volume)

100 parts	Aerodur <sup>®</sup> HS 67348
33 parts	Hardener 90150
33 parts	Activator 99302

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur<sup>®</sup> HS 67348 till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 90150 and stir the catalyzed mixture thoroughly.
- Add Activator 99302 and stir again till a homogeneous mixture.



Induction Time

Not applicable. Product can be used directly after mixing.



Initial Spraying  
Viscosity  
(21°C/70°F)

30 – 40 seconds ISO-Cup 4  
15 – 17 seconds Gardner Signature Zahn-Cup #2.



Note

Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



Pot Life  
(21°C/70°F)

3 hours.



Dry Film  
Thickness  
(DFT)

25 – 30 µm  
1.0 – 1.2 mils



Note

The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build up.

### Application Recommendations



Conditions

Temperature: 15 – 35°C  
59 – 95°F  
Relative Humidity: 35 – 75%



Note

Aerodur® HS 67348 topcoat may be applied in conditions outside of the the limits shown above. Care must be excerciesed to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.



Equipment

Air 1.4 – 1.8 mm nozzle orifice  
HVLP 1.4 – 1.8 mm nozzle orifice  
Airless / Air assist 6.11 – 6.13, (.011 - .013 inch) angle 60°



Number of Coats

Apply one cross coat.



Cleaning of  
Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068



Note

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.



## Physical Properties



Drying Times  
(21°C/70°F)

Dust free  
Dry to tape  
Dry to handle

2 – 3 hours  
6 – 8 hours  
12 minutes flash off time, followed by 40 minutes at 75°C.  
30 minutes flash off time, followed by 2 hrs at 60°C.  
7 hours  
72 hours.  
If a drying time of 72 hours is exceeded, condition surface with e.g. Scotch-Brite<sup>®</sup> type A very fine.



Theoretical Coverage

33 m<sup>2</sup> per liter base material at 25 µm dry film thickness  
1325 ft<sup>2</sup> per US gallon base material at 1.0 mils dry film thickness



Dry Film Weight

1.60 g/m<sup>2</sup>/µm



Semi-Gloss (60°)

15 – 50 GU.



Color

Grey color 054569 (M9001)



Flash-point

Aerodur<sup>®</sup> HS 67348 <21°C / 70°F  
Hardener 90150 <21°C / 70°F  
Activator 99302 <21°C / 70°F



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F.  
Stored in the original unopened containers.

Aerodur<sup>®</sup> HS 67348 24 months  
Hardener 90150 24 months  
Activator 99302 36 months

## Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDS's are available on request.

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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Scotch-Brite<sup>®</sup> is a trademark of 3M.