



## Product Group

Polyurethane Topcoats

## Characteristics



Product  
Information

Aviox® SGL Aluminium is a 3 component durable semi gloss aluminum finish for exterior use.

- Low VOC (high solid technology)
- Resistance to aircraft hydraulic fluids and chemicals

## Components



Hardener  
Thinner or  
Activator

Hardener 90121  
Activator 99321 or Activator 99330

## Specifications



Qualified Product  
List

Messier-Dowty PCS – 2530

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

- Aviox® SGL Aluminium is compatible with 10P20-13 primer.
- Observe the recoatability times of 10P20-13 primer.
- Apply Aviox® SGL Aluminium preferably on clean primer. Remove oil, grease and other contamination prior to application.
- Recondition aged primer with e.g. Scotch-Brite® type A very fine to a uniform matt surface.
- Remove dust with e.g. tack rags just prior to application of Aviox® SGL Aluminium

## Instruction for Use



Mixing Ratio  
(volume)

100 parts	Aviox® SGL Aluminium
50 parts	Hardener 90121
50 parts	Activator 99321 or Activator 99330

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aviox® SGL Aluminium till all pigment is uniformly dispersed before adding hardener.
- Add Hardener 90121 and stir the catalyzed mixture thoroughly.
- Add the Activator 99321 or Activator 99330 and stir the catalyzed mixture again thoroughly.



Induction Time

Not applicable. The product is ready for use directly after mixing



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

25 – 40 seconds ISO-Cup 4.  
13 – 20 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)

Activator 99321: 2 hours  
Activator 99330: 1 hour



Dry Film  
Thickness  
(DFT)

40 – 60 micron (µm)  
1,6 – 2,4 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

Aviox® SGL Aluminium may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques and choice of activators when environmental conditions fall outside of the recommended range.



Equipment

Air 1.2 – 1.4 mm nozzle orifice  
HVLP 1.2 – 1.4 mm nozzle orifice



Number of Coats

Apply a single closed coat, followed after 30 minutes ambient flash off time by a cross coat. A final mist coat can be applied to achieve superior appearance.

The flash-off time between the coats are influenced by temperature, relative humidity and air movement.



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  
according to  
AITM 2-0011  
(23+/-2°C,  
55+/-5% RH)

Dry to dust  
Forced cure

Activator 99321  
5 hours  
120 minutes flash-off  
followed by 30 min. at  
100°C.  
7 days

Activator 99330  
2,5 hours  
120 minutes flash-off,  
followed by 20 min. at  
100°C.  
7 days



Theoretical  
Coverage

25 m<sup>2</sup> per liter base material at 40 µm dry film thickness  
1003 ft<sup>2</sup> per US gallon base material at 1,6 mil dry film thickness



Dry film weight

1.3 g/m<sup>2</sup>/µm  
0.0068 lbs/ft<sup>2</sup>/mil



Volatile Organic  
Compounds

Maximum 420 g/l  
Maximum 3.5 lb/gal



Gloss (60°)

10 - 45 GU



Color

Aluminum



Flash-point

Aviox® SGL Aluminium	>21°C /70°F
Hardener 90121	>21°C /70°F
Activator 99321	<21°C /70°F
Activator 99330	<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.

Aviox® SGL Aluminium	12 months
Hardener 90121	24 months
Activator 99321	36 months
Activator 99330	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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