

TOPCOAT XS4201 MATT

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information



High solid polyurethane 3K topcoat for external and structural application. XS4201 is also available in high gloss and semi-gloss version (see corresponding TDS).

Components



Base XS4201 MATT
Hardener / Catalyst XS4201
Thinner P2

Physical properties



THEORETICAL COVERAGE

12 m²/ L for 50µm dry - 125 ft²/L for 2 mils dry (base and hardener only). The theoretical consumption value doesn't take into account the transfer efficiency for spray application.

DRY FILM WEIGHT

1.60 for white base

VOC

420 g/l or 3.5 lb/gal (ISO11890-1 and ASTM D 3960)

SHELF LIFE / STORAGE

18 months for the base and hardener and 48 months for thinner stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging. 2 months for the base and 15 days for the hardener between 5°C and 35°C (41°F and 95°F) after opening and properly closed packaging.

GLOSS LEVEL

Bellow 5 GU

NOTES

Flash Point:

XS4201 Matt Base: 24°C (75°F)

XS4201 Hardener: 170°C (338°F)

P2 Thinner: 24°C (75°F)

Gloss levels have been determined using glossmeter with an angle of incidence of 60°C.

Surface preparation



XS4201 must be applied on an appropriate primer according to substrate used and protection required.

XS4201 is compatible with the following primer MSP-1, SP350, P60-LC, P60-A, P65HG, F69 and the PU Isomap P23.

All recommendation mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

Base
Hardener / Catalyst
Thinner

Mixing ratio by volume

4 V (mixing by weight is recommended)
1 V
1 V

MIXING PROCEDURE

Mixing ratio by volume are given for information purpose.

Please contact our customer support for information on mixing ratio by weight because they depends of the colour. Mixing by weight is mandatory in order to obtain a reproducible mat.

Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.

The XS4201 base should be mixed for 5 minutes in a pneumatic or oscillating mixer before use.

Mix the base, hardener and thinner until the mixture is homogenous.

The mixture must be made at a temperature between 15°C and 35°C (59°F and 95°F).

Remark : It is recommended to sieve the mixture using a 125-190 µm (4.9-7.5 mils) filter.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Ford 4	ISO 6	CA 4
1 V Dilution	1 V Dilution	1 V Dilution
30 ± 10s	15 ± 5s	30 ± 10s

POT LIFE

For 1V dilution: 7 hours at 20°C (68°F) and 3 hours at 30°C (86°F)

NOTE

Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

ISO 6 Cup is the reference cup. The others are given for information purposes.

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Application
recommendations



CONDITIONS

Temperature 15°C to 35°C (59°F to 95°F)

Relative humidity 40% to 80%

EQUIPMENT

Gravity compressed air gun Nozzle 1.5 to 1.8 mm

DRY / WET FILM THICKNESS

40-80 µm (1.6 to 3.2 mils) dry / 80-160 µm (4.0 to 7.0 mils) wet

NUMBER OF COATS

The number of coats depends on the size and the shape of the part to which it is being applied.

Application of two coats as crossed coats.

EQUIPMENT CLEANING

Clean the equipment with an appropriate cleaning thinner, such as P2 or Diestone E, Thinner 96100.

NOTE

Spray with dry, oil-free air.

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Drying times



NOTE

For the **Thinner P2**, drying times are :

Dust free

Dry to touch

Dry to handle

Dry to tape

Fully cured

23°C / 73.4°F

40 minutes

3 hours

6 to 8 hours

18 to 20 hours

7 days

50°C / 104°F

Not Applicable

2 hours

4 hours

8 hours

24 hours

60°C / 140°F

Not Applicable

1 hour

2 hours

4 hours

12 hours

Drying times have been determined using test pieces of a thickness < 2 mm and for 50 µm (2.0 mils) of dry film. Leave to flash off for 1 hour at 23°C (73.4°F) before curing.

Defects & corrections



In the event of a defect, contact your Quality Department.

Health & Safety



See the product Safety Data Sheet.

The MSDS are available through our website www.mapaero.com upon request.

Packing



The XS4201 base is available in 1 L and 4 L.

The XS4201 hardener is available in 1 L and 5 L.

The P2 thinner is available in 1L and 5 L.

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.