

Optidur 9300 Series Technical Data Sheet

Product Group

Cabin Coatings

Characteristics



Product
Information

Optidur 9300 Series is a 2-components high quality water based acrylic polyurethane topcoat in four reduced sheen options. The material is specifically formulated to obtain premium performance with respect to hardness, durability, abrasion, scratch and chemical resistance. The Optidur 9300 is available from 5% to 80% sheen.

Product is part of the Optidur Series which utilizes the latest resin technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components



Optidur 93XX Base

Optidur 930-0XXA

Hardener

Optidur 930-001B

Water

Optional

Specifications



Qualified
Product List

AkzoNobel Aerospace

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions



Cleaning

- Product is compatible with other products out of the Optidur Series.
- Remove oil, grease and other contaminations carefully prior to application of the Sealer.
- Remove dust with tack rags prior to application of the Optidur 9300.

Optidur 9300 Series

Low Gloss Acrylic PU

Instruction for Use



Mixing Ratio
(volume)

	<u>Volume (v/v)</u>
Optidur 930-0XX Topcoat	100 parts
Optidur 930-001B Hardener	8%
Reducer water	0-10%

- Allow products to acclimatize to room temperature before use.
- Actively mix part A while pouring part B for 2 minutes.
- Add Water and stir the mixture thoroughly for at least 2 minutes or until homogenous.



Induction Time

5 minutes



Initial Spray
Viscosity
(25°C/77°F)

31-35 seconds with #2 Signature Zahn



Pot life
(25°C/77°F) –
55% RH)

Product must be stirred before use
Pot life is 3-4 hrs.



Dry Film
Thickness
(DFT)

Apply 50 – 100 μm (2 – 4 mils).



Note

Respect described pot life / working window.

Optidur 9300 Series Low Gloss Acrylic PU

Application Recommendations



Conditions

Temperature: 15 - 35°C
59 - 95°F
Relative Humidity: 25 - 85%



Note

Optidur 9300 Topcoat may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.



Equipment

Spray application using industry standard or HVLP spray equipment. Follow equipment manufacturer pressure recommendations with 1.2 – 1.4 mm tip size.



Application

- 2-4 wet mils per coat, with 10-15 minutes flash between coats
- Flash 20 - 30 minutes prior Oven
- Max recommended build is 3 mils DFT

For multiple coats, it is important to allow proper flash off time between coats to avoid solvent entrapment (solvent pop).



Cure Guidelines

	Ambient (68°F)	Forced Cure (140°F)
Tack Free	30 min	15 min
Dry-to-Sand	4 hours	1 hour
Dry-to-Stack	24 hours	1 hour



Cleaning of Equipment

Clean equipment with Acetone. Clean equipment directly after use.

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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 for the product for the first time, it is recommended that test panels be prepared to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties



Dry Film Weight

25 g/m²/25µm



Volatile Organic Compounds

Maximum 158 g/l
Maximum 0.53 lbs/gal



Gloss (60°)

5% - 80% Gloss
Gloss percentage closely aligns to Gloss Units (GU) within +/- 5 GU.



Color

Clear



Flash-point

Not applicable.



Storage

Store the product dry and at a temperature between 5 and 21°C / 41 and 70°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to container label for specific storage life information. Always Rotate Stock.

Optidur 9300 Series Low Gloss Acrylic PU

Shelf life	Optidur 930-0XXA Topcoats	12 Months
5 - 21°C (41 - 70°F) / 55% RH	Optidur 930-001B Hardener	6 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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