

# 8W5

## Technical Data Sheet

### Product Group

Primer Surfacer

### Characteristics



Product  
Information

- A two-component polyurethane primer surfacer providing excellent filling properties.
- May be applied to aerospace aluminum and composite substrates to fill and smooth surface irregularities in combination with AkzoNobel Aerospace Coatings specification primers, conductive coatings and topcoats.

### Components



Curing Solution  
Thinner

Base material	8W5
Curing Solution	50C3
Thinner	66C20 or 66C28

### Specifications



Qualified  
Product List

Avic Aviation	AMMS2514
Boeing	BAC 5837 (Note: BAC 5837 - use as pinhole filler only), BAC 5322, TY I&II, CL 2, BMS 10-143, TY I CL A, GR A
Comac	CMS-CT-904
EADS (CASA)	Z12.216
Lear Fan Corp, (US)	LMS 5002A
MTU Aero Engines AG	MTS 1681
Northrop Grumman	GC130CS1
Pratt & Whitney	PWA36014

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](http://aerospace.akzonobel.com/products).

### Surface Conditions



Cleaning

Surface pretreatment is an essential part of the painting process.

- **Aluminum:** Follow specification requirements for pretreatment and primer application.
- Apply 8W5 surfacer to fill surface irregularities prior to the subsequent steps in the coating process.
- **Laminates:** Clean thoroughly with non-residual solvent.
- Fill laminate "pinholes" with Static Conditioner Filler 28C1 in accordance with directions, before applying 8W5 surfacer.

## 8W5 Off-White Surfacer

### Instruction for Use



Mixing Ratio  
(volume)

8W5	4 parts
50C3	1 part
Thinner	*2 parts

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.

\*Thinner 66C20 or 66C28 for spray consistency. Do not exceed 3 parts thinner maximum by volume.



Induction Time

15 minutes.



Initial Spraying  
Viscosity  
(25°C/77°F)

60 – 74 seconds ISO-Cup 4  
24 – 34 seconds Signature Zahn-Cup #2  
25 – 35 seconds Ford Cup #4



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  
(25°C/77°F)

6 hours.



Dry Film  
Thickness  
(DFT)

As required

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## Off-White Surfacer

### Application Recommendations



Conditions

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



Note

8W5 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 gun type	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet*
Air	1.8 mm nozzle orifice	N/A	N/A
HVLP	1.4 mm nozzle orifice	N/A	N/A
Air Assisted, Electrostatic	.33 mm nozzle orifice	N/A	N/A



Number of Coats

Spray on one or more coats as required for adequate filling of imperfections in substrate. Allow final coat to stand 4-6 hours, sand with fine paper, then topcoat with selected AkzoNobel Aerospace Coatings topcoat.



Cleaning of Equipment

MEK, C28/15

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## Off-White Surfacer

### Physical Properties



Drying Times  
(25°C / 77°F,  
55% RH)

Minimum topcoat re-coat time

6 – 8 hours (depending on film thickness) prior to sanding and application of topcoat.



Theoretical Coverage

14.5m<sup>2</sup> per liter ready to apply at 25 µm dry film thickness  
592 ft<sup>2</sup> per US gallon ready to apply at 1 mil dry film thickness



Dry Film Weight

52.44 g/m<sup>2</sup> at 25.4 micron  
.0107 lbs/ft<sup>2</sup> at 1 mil



Volatile Organic Compounds

Max 570 g/l  
Max 4.8 lbs/gal, reduced with 2 parts 66C20 thinner, per ASTM D3960



Gloss (60°)

Flat



Color

Off-White

Conductivity

Non-conductive



Flash-point

8W5	26°C (78°F)
50C3	28°C (82°F)
66C20	-5°C (23°F)
66C28	15°C (59°F)

## 8W5 Off-White Surfacer



Storage

Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life  
5 - 38°C  
(41 - 100°F)

18 months per AkzoNobel Aerospace Coatings commercial specification. For 8W5 and 50C3. 24 months for 66C20 and 66C28. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

### 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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**Issue date: November 2022 (supersedes October 2020) - FOR PROFESSIONAL USE ONLY**

**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. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.