

TOPCOAT FR18 VELVET

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

AkzoNobel

Product information



Three-component water-based polyurethane mat surfacer for aircraft and helicopter interiors.

Components



Base FR18 VELVET
Hardener / Catalyst FR2-55
Thinner Water

Specifications



Qualified in accordance with :
Airbus Helicopters ECS 2175

Product information mentioned in the technical data sheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties



THEORETICAL COVERAGE
8 m² /L for 60 µm dry (base and hardener unmixed)

DRY FILM WEIGHT
1.3 (approx.)

VOC
140g/L (ISO 11890-1) and 370g/L (ASTM D3960)

SHELF LIFE / STORAGE
12 months for the base and the hardener stored between 5 et 35°C (in sealed original packaging).

GLOSS LEVEL
Less than 2GU below 60°

NOTES
The theoretical consumption value does not take into account the transfer efficiency for spray application. Gloss levels been determined using glossmeter with an angle of incidence of 60°.

Surface preparation



All recommendation mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

Base
Hardener / Catalyst
Water

Mixing ratio by weight

100
20
20 to 30

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C and 25°C during 24 hours before use.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Dilution rate by weight
30%

ISO 6
28s ± 5s
23°C

POT LIFE

3 hours at 23°C

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.

Water based paints show a thixotropic behaviour. This implies that efflux time can vary according different parameters such as : type of mixing, mixing quantity, dilution, temperature, time between mixing and viscosity measurement.

Application recommendations



CONDITIONS

Temperature 15°C to 35°C

Relative humidity Between 20 and 70% HR

EQUIPMENT

Gravity spray gun Nozzle 1,8 to 2,2 mm

DRY / WET FILM THICKNESS

40 to 80 µm dry / 160 to 320 µm wet

NUMBER OF COATS

Apply one crossed coat, then 2 crossed coats, 15 minutes apart.

EQUIPMENT CLEANING

Clean the equipment with an appropriate cleaning thinner, such as Mapaero D770-B.

NOTE

Spray with dry and oil-free air.

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Drying times



Dust free
Dry to handle
Fully Cured

23°C

1 hour
8 hours
7 days

60°C

N.A.*
1 hour
12 hours

NOTE

Drying times have been determined using tests pieces of a thickness < 2mm for 60µm of dry film.
Let it flash off 1 hour at room temperature before drying at 60°C.

*N.A. : Not applicable

Defects & corrections



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

Health & Safety



See the product safety data sheet.
The MSDS are available on our website www.mapaero.com

Packing



The base and the hardener are available in 1 kg and 5 kg.

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.