



Product Group

Cabin Coatings

Characteristics



Product
Information

Aerofine® 8250 Topcoat is a one component low VOC waterborne interior topcoat, using high quality self cross-linking resins that provides the outstanding properties of two component polyurethane. This product can be both air or forced cured.

- Complies with current and proposed VOC legislation
- Fast drying times
- Good hiding power
- Good mar and stain resistance
- Wide range of colors is available.
- Isocyanate free

Aerofine® 8250 Topcoat is a product part of the Aerofine® Series which utilizes the latest resin technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components



Hardener
Thinner or
Activator

Thinner: D.I. water or tap water*

* Quality meets Council Directive 98/83/EC of 3 November 1998 on the quality of water intended for human consumption

Specifications



Flammability	F.A.R. / CS 25.853(a) App.F Pt. I(a)(1)(i) 60s* ¹
Heat Release	F.A.R. / CS 25.853(d) App.F Pt. IV (g) * ¹
Smoke Emission	F.A.R. / CS 25.853(d) App.F Pt. V (b)
Toxic Gas Emission	Airbus ABD0031 / Boeing D6-51377* ¹ (performance)

*¹ Compliance is dependent on substrate and paint layer applied. Please contact your local AkzoNobel Aerospace Coatings representative for more detailed information.

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions



Cleaning

- Observe the recoatability limits of the relevant primer and substrate.
- Recondition aged primers or topcoats with final dry sanding steps P320-P400.
- Remove oil, grease and other contaminants prior to application of the finish.
- Remove dust with e.g. tack rags prior to application of the finish.
- If Aerofine Topcoat is applied directly on plastic or composite substrates, the release coat must be removed prior to coating application. Degrease the surface using an appropriate degreaser.



Instruction for Use



Mixing Ratio
(volume)

100 parts Aerofine® 8250 Topcoat

If desired, reduce the ready to spray viscosity with:

Maximum 5 volume parts D.I. water or tap water*

- Allow products to acclimatize to room temperature before use
- Stir or shake Aerofine Topcoat till all pigment is uniformly dispersed before use.
- If necessary, add maximum 5% water and stir or shake till a homogeneous mixture.



Induction Time

None



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

Aerofine® 8250 topcoat is a one component product. Material is ready for use when is properly stirred or shaken.

Viscosity can not be measured in viscosity cups due to another rheology profile compared to solvent-borne products.



Pot Life
(25°C ±2/77°F±2)

Indefinite.

Avoid exposure of the Aerofine® 8250 base paint to the open air to prevent skinning.

Application Recommendations



Conditions

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



Note

Aerofine® 8250 Topcoat may be applied in conditions outside of the the limits shown above. Care must be excercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.



Equipment

Air 1.4 – 2.0 mm nozzle orifice
HVLP 1.4 – 2.0 mm nozzle orifice
Plastic soft roller (foam roller)



Number of Coats

Smooth surface

Apply one full coat or first a light closed coat in case of a moderate substrate wetting followed after drying with a full coat.

Texture appearance

Apply a smooth surface and let it dry for at least 30 minutes till matt. The texture layer is applied by means of spattering. The texture is defined by air pressure, nozzle orifice and distance to the object.



It is recommended to reduce the air pressure to 0.3 – 0.5 bar in combination with a fluid tip of 1.8 – 2.0 mm. Apply 2-3 coats perpendicular to each other at a distance of approximately 0.3 – 0.4 meter. Coarse texture will be achieved closer to the object, finer texture visa versa.

Rolling or roller application

Use a soft foam roller. Take care that roller is fully soaked with paint and no remaining air is enclosed.

Apply 1 or 2 layers with 30 minutes drying time in between applications.

25 – 40 µm
1.0 – 1.6 mil



Dry Film
Thickness
(DFT)



Cleaning of
Equipment



Note

Cold water followed by final cleaning with Solvent Cleaning C 28/15 or Aerofine Gun Cleaner.

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
(25°C/77°F)

Dust free

15 – 45 minutes



Note

Humidity and airflow will influence the Aerofine® 8250 Topcoat flash-off and drying times. These times can be reduced to a minimum by using air accelerator systems with a minimum distance of 1 meter from the object, thus increasing the airflow over the object. Flash-off until the surface is completely matt, supports to achieve higher film build.



Theoretical
Coverage

14 m² per liter base material at 25 µm dry film thickness
561 ft² per US gallon base material at 1.0 mils dry film thickness



Dry film weight

1.6 g/m²/µm (white colors)
0.0083 lbs/ft²/mil



Volatile Organic
Compounds

42 g/L Max.
98 g/L, Exempt water according ASTM-D-3960



Gloss (60°)

Semi-gloss 15-30 GU
Matt < 10 GU



Color

Available in all semi gloss and flat standards.



Flash-point

Aerofine® 8250 Topcoat

See MSDS



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Keep from freezing. Periodical short time exposure (max. 48 hrs at a time) to higher temperatures (max. 40°C / 104°F) will not negatively influence the shelf life of the products.

Shelf life
(21°C/70°F and
55% RH)

In original, unopened package when stored following the storage conditions mentioned earlier. After the expiry date, contact our Technical Staff for an estimation of usability.

Aerofine Topcoat

24 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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