



Product Group

Fluid resistant finishes

Characteristics



Product
Information

Aeroflex® Finish G 12 E 25 is a one component corrosion inhibiting topcoat for in-spar areas of the wing.

- Fast drying.
- Aluminium pigmented.
- Rain erosion resistant.

Components



Hardener Thinner
or
Activator

Thinner C 25/90 S (normal conditions, flashpoint <21°C)
Thinner 96184 (warm conditions, flashpoint <21°C)

Specifications



Qualified Product
List

Airbus Industries

AIMS 04-04-017 Issue 2, ASN A4287
I.C. TO-37.05, I.P. DA-64.03
PQ 10050 H – 023, TN A.007.10129

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 re-coatability limits of the relevant primer.
- Remove oil, grease and other contaminations prior to application of the finish.
- Clean existing, aged coats of Aeroflex® Finish G 12 E 25 with mild cleaning solvent, e.g. Degreaser C 3/41 or Thinner M600.

Instruction for Use



Mixing Ratio
(volume)

100 parts Aeroflex® Finish G 12 E 25

Reduce to spraying viscosity with:

Max. 20 parts Thinner C 25/90 S or Thinner 96184





- Allow products to acclimatize to room temperature before use.
- Stir or shake Aeroflex® Metallic till all pigment is uniformly dispersed.
- Material is supplied at application viscosity for airless equipment, pressure pot and rollers
- For suction and gravity fed spray guns it is recommended to thin down the material with approx. 20 parts (volume) thinner.

Not applicable









Induction Time



	Initial Spraying Viscosity (21°C/70°F)	85 – 130 seconds ISO-Cup 4 (45 – 60 seconds)*
	Note	*Values for suction and gravity fed spray guns are given between brackets 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 (21°C/70°F)	Not applicable
	Dry Film Thickness (DFT)	70 – 80 micron (µm) 2.8 – 3.1 mils

Application Recommendations

	Conditions	Temperature: 15 – 35°C 59 – 95°F Relative Humidity: 35 – 75%
	Note	Aeroflex® Finish G 12 E 25 may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques and choice of thinner when environmental conditions fall outside of the recommended range.
	Equipment	Airless 1.8 mm nozzle orifice 6.13, (.0013 inch) angle 60°
	Application Scheme	Airless - Apply one cross-coat followed after 10 – 60 minutes solvent flash-off by an other cross-coat Air - Apply 3 to 4 cross-coats with 10 – 60 minutes solvent flash-off between coats.
	Note	- For a uniform appearance apply a final mist coat of Aeroflex® Finish G 12 E 25 diluted with 100 parts (volume) thinner. - To obtain the required rain erosion resistance a minimum dry film thickness of 70 microns (2.8 mils) has to be observed. - By temperatures over 26°C Thinner 96184 is recommended (slower evaporating)
	Cleaning of Equipment	Solvent Cleaning C 28/15 or Solvent Cleaning 98068



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 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
(21°C/70°F, 55% RH)

Dust free	30 minutes
Dry hard	2 hours
Dry through	24 hours



Theoretical Coverage

2 m² per liter base at 70 µm dry film thickness
80 ft² per US gallon base at 2.8 mil dry film thickness



Dry film weight

1.6 g/m²/µm
0.0083 lbs/ft²/mil



Gloss (60°)

10 – 40 GU



Color

Aluminium



Flash-point

Aeroflex® Finish G 12 E 25	<21°C / 70°F
Thinner C 25/90 S	<21°C / 70°F
Thinner 96184	<21°C / 70°F



Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Stored in the original unopened containers.

Aeroflex® Finish G 12 E 25	18 months
Thinner C 25/90 S	36 months
Thinner 96184	36 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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