

SURFACER 03-49

SPECIAL COATINGS

AkzoNobel

Product information



Three components epoxy surfacer applicable with spatula or spray. This surfacer should be used on composite or epoxy primer.

Components



Base 03-49
Hardener / Catalyst 03-49
Thinner E

Specifications



Qualified in accordance with:
Airbus Helicopters : ECS 2047 (blue)
Daher Socata

Product information mentioned in the technical datasheet 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

4 m²/kg (510 ft²/gal) for 100 µm (4 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT

2.5

VOC

270 g/L (ISO 11890-1 and ASTM 3960)

COLOR

RAL5012 blue and gray.

SHELF LIFE / STORAGE

12 months for the base and hardener stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.
48 months for the thinner stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

NOTES

Gloss levels have been determined using glossmeter with an angle of incidence of 60°C.

The theoretical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation



Metallic surface:

Apply an anticorrosion primer as P60-A before applying the primer 03-49. Respect the primary recovery conditions.

Composite surface:

Degrease the surface with a qualified solvent (DLS DIESTONE type).

Sand softly with Scotch-Brite paper.

It should then be blown dried and cleaned with a lint-free cloth wet with isopropyl alcohol.

All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2V
Hardener / Catalyst	50	1V
Thinner	0 to 15	0V to 0.8V

MIXING PROCEDURE

Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.

For a spray application dilute to 15% by weight approximately with thinner E

The mixture by weight is recommended.

The base and the hardener 03-49 should be mixed for 10 minutes before application, using a mixer pneumatic type.

Mix the base and the hardener until the material is homogeneous. Then add thinner and mix.

The mixture must be made at a temperature between 15°C and 35°C (60-95°F).

Remark: It is recommended to sieve the mixture through a 120-150µm (4.7-6mils) filter for spray application.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Dilution rate by weight
15%

AFNOR 4
37s ± 4s

POT LIFE

1 hour undiluted and 1.5 hour at 15%

NOTE

Viscous product for application with a putty spatula.

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.

Instructions for use



BRUSH APPLICATION

MIXING PROCEDURE

Mix the base and hardener with a stick to get an homogeneous mixture and then dilute if necessary.

Be careful, don't incorporate air in the mixture.

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Application recommendations



CONDITIONS

Temperature 15 °C (59°F) to 35 °C (95°F)
Relative humidity 30 % to 75 %

EQUIPMENT

Gravity compressed air gun Nozzle 2.2 mm
Spatula coachbuilder type

DRY / WET FILM THICKNESS

100 µm to 150 µm (3.9 to 6 mils) dry (gun) or up to 2 mm (spatula)

NUMBER OF COATS

Apply with spatula one layer of primer 03-49.
Apply with spray gun one to several layers.
Sand with paper grade 180-240.

EQUIPMENT CLEANING

Clean the equipment with a suitable diluent type E or a diluent for epoxy paint.

NOTE

Spray with dry, oil-free air.

Drying times



Dust free
Recoatable

23°C (73°F)

2 hours
24 hours

60 °C (140°F)

15 minutes
30 minutes to 60 minutes

NOTE

Drying times have been determined using tests pieces of a thickness < 2mm for 125µm (4.9 mils) of dry film.
Drying times for 200µm of dry film:

Dry to Sand

23°C
24 hours

40°C
4 hours

60°C
2 hours

Leave to flash off at room temperature 30 minutes before drying.

*N.A. : Not applicable

Defects & corrections



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

Health & Safety



See the product Safety Data Sheets.
The MSDS are available through our website www.mapaero.com

Packing



The kit base + hardener + diluent is only available in 500g for blue RAL 5012.
The base 03-49 is available in 4kg containers.
The hardener 03-49 is available in 2kg.
The thinner E is available in 1L and 5L.

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.