TOPCOAT FRS40 FLEX

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

AkzoNobel

Product information

Flexible solvent based, three component PU topcoat for aircraft passengers cabins.
The product is available in 2 gloss ranges : 5-10 GU for matt parts and 20-30 GU for other semi-gloss cabin parts.

Components

Base FRS40 FLEX
Hardener / Catalyst FRS
Thinner FRSL

Specifications

Meets the following requirements:
JAR/FAR Part 25 §25.853 (a), (c/d), Change 14 / Amdt 25-83

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
7m²/kg for 50µm (2mils) dry (base and hardener not diluted)

DRY FILM WEIGHT
1.9 (approx.)

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

SHELF LIFE / STORAGE
36 months for base, 24 months for hardener and 48 months for thinner stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL
5-10GU below 60° (mat), 20-30GU below 60° (semi-gloss)

NOTES
Gloss levels have been determined using glossmeter with an angle of incidence of 60°. The theorical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation

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	8 V
Hardener / Catalyst	10	1 V
Thinner	10 to 20	1 to 2 V

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.
The mixture by weight is recommended.
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).

INDUCTION TIME
None

Spraying viscosity at 20°C / 68°F

Dilution rate by weight	ISO 6
10-20%	22 +/- 5s

POT LIFE
6 hours at 23°C (73°F)

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

ISO 6 cup is the reference cup. The others are given for information purposes.

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Application recommendations

CONDITIONS
Temperature 15°C to 35°C (59 to 95°F)
Relative humidity 20 to 80%

EQUIPMENT
Pneumatic Spray gun nozzle 1.3 to 1.8 mm

DRY / WET FILM THICKNESS
20 to 60 µm (0.8 to 2.4mils) dry / 40 to 120µm (1.6 to 4.8 mils) wet

EQUIPMENT CLEANING
Clean the equipment with a suitable thinner such as FRSL

NOTE
Spray with dry and oil-free air.

For a smooth surface :
Spray 1 or 2 crossed coats.
For textured surface :
dilute first coat at approximatively 25%, spray one crossed coat and wait 30 minutes, until the aspect is semi-gloss.
Fine texture : Decrease air pressure by 1.5 to 2 bars and spray at a distance of 50cm from substrate.
Coarse texture : decrease air pressure by 1.0 to 1.5 bars and spray at a distance of 20cm from substrate.

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Drying times

NOTE

	23°C (73.4°F)	60°C (140°F)
Dust free	20 min	N.A*
Dry to handle	7 hours	1 hour
Dry to tape	8 hours	1 hour
Fully cured	7 days	12 hours

Drying times have been determined using tests pieces of a thickness < 2mm for 45µm (1.8mils) of dry film.
*N.A. : Not applicable

Defects & corrections

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

Health & Safety

See the product Safety Data Sheet.

Packing

The FRS40 Flex base is available in 1kg and 5 kg.
The FRS hardener is available in 0.5kg, 1kg and 5kg.
The FRSL thinner is available in 1L and 5L.

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