

PUTTY FR-M1K

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

AkzoNobel

Product information



FR-M1K is a mono-component fire retardant acrylic waterbased putty for filling pinholes and correct small defects on cabin interior composite parts. Recommended application, using a spatula or putty knife.

Components



Base FR-M1K
Thinner Water (if needed)

Specifications



Qualified in accordance with:

Embraer : MEP 10-074
Safran : Cabin CDP490-10

Meets the 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



DRY FILM WEIGHT

2,4

VOC

55 g/L or 0.46 lbs/gal (ISO11890-1) and 115 g/L or 0.97 lbs/gal (ASTM D3960)

SHELF LIFE / STORAGE

12 months between 5°C and 35°C (59°F and 95°F) in full and sealed original packaging. The putty must be used within one month after the first opening. Do not let the tube open.

NOTES

Flash point > 100 °C (212°F).

Surface preparation



Before application, the substrate must be sanded with P120 to P240 sanding paper grade and then wiped with appropriate solvent (IPA type). All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING PROCEDURE

Spraygun application is not the preferential method (see "Application recommendations" section for spatula application).

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

None

Instructions for use



BRUSH APPLICATION

Base

Water

Mixing ratio by weight

100

0 to 5

NOTE

Brush application is not the preferential method (see "Application recommendations" section for spatula application).

Application recommendations



CONDITIONS

Temperature 15 to 35 °C (60°F to 95°F)

Relative humidity 30 to 75 %

EQUIPMENT

Metal or Teflon spatula or putty knife

DRY / WET FILM THICKNESS

15 µm to 600 µm dry (0.6 mils to 24 mils dry)

NUMBER OF COATS

For spatula application :

The FR-M1K putty can be diluted up to 1 to 2% of water in order to adjust viscosity, if needed. Diluted putty can be easier to apply on large surfaces for filling pinholes.

EQUIPMENT CLEANING

Clean the equipment with water, then with a suitable cleaning thinner.

NOTE

After the beginning of the application, undiluted putty can be worked for 5 minutes with spatula application.

The pot life could be shorter if the temperature is superior to 30°C (86°F).

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Drying times



NOTE

Dry film thickness: < 50µm (<2mils)

Dry to sand
Fully cured

23°C (73°F)/55% RH

15 minutes
7 days

Dry film thickness: 50 to 100µm (2 to 4 mils)

Dry to sand
Fully cured

23°C (73°F)/55% RH

30 minutes
7 days

Dry film thickness: 100 to 200 µm (4 to 8 mils)

Dry to sand
Fully cured

23°C (73°F)/55% RH

45 minutes/1 hour
7 days

Dry film thickness: 200 to 600 µm (8 to 16 mils)

Dry to sand
Fully cured

23°C (73°F)/55% RH

1 hour/2 hours
7 days

Sanding process:

After drying, sand with pneumatic sanding machine equipped with appropriate sanding paper grade (P240 to P400) or manually with same grades of sanding papers.
Blow dust away and wipe before recoating.

Defects & corrections



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

Health & Safety



See the Material Safety Data Sheet.
The MSDS are available on our website www.mapaero.com

Packing



The FR-M1K is available in 400 g tube.

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.