

Aerodur Sealer 42240



Technical Data Sheet

Product Group

Intermediate coatings

Characteristics



Product
Information

Aerodur Sealer 42240 is a one component polyamide coating used in selective strippable aircraft exterior surface paint schemes.

- Allows topcoats to be stripped with an appropriate and relatively mild paint remover without removing the primary epoxy primer.
- Compatible with various topcoats and basecoat-clearcoat systems
- When applied in a qualified system it provides resistance to hydraulic fluids and chemicals

Components



Curing Solution
Thinner /
Activator

Thinner 98066

Specifications



Qualified
Product List

Airbus
AIMS 04-04-032
AIMS 04.04.037
AVN 7-004

BAe AVRO

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

Surface Conditions



Cleaning

- Check the overcoat times (overcoat window) of the different HS primers with Aerodur Sealer 42240 before application.
- Remove oil, grease and other contaminations prior to application of the sealer.
- Remove dust with e.g. tack rags prior to application of the sealer.



Note

Aerodur Sealer is compatible with the following primers:

- Aerodur LV 2114
- Aerodur HS 2121 CF

Aerodur Sealer 42240

Instruction for Use



Mixing Ratio
(volume)

100 parts Aerodur Sealer 42240
Reduce to spraying viscosity with:
60 – 80 parts Thinner 98066

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aerodur Sealer 42240 till all pigment is uniformly dispersed before adding thinner.
- Add Thinner 98066 and stir the mixture thoroughly.



Induction Time

Not applicable.



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

18 – 24 seconds ISO-Cup 4
10 – 13 seconds Gardner Signature Zahn-Cup #2



Note

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
(25°C/77°F)

16 hours



Dry Film
Thickness
(DFT)

8 – 12 μm
0.32 – 0.48 mils

Application Recommendations



Conditions

Temperature: 15 – 35°C
 59 – 95°F
Relative Humidity: 20 – 75%



Note

Aerodur Sealer 42240 may be applied in conditions outside of the the limits shown above. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.

Aerodur Sealer 42240



Equipment

Air 1.4 mm nozzle orifice
 HVLP 1.4 mm nozzle orifice
 Airless 6.11 – 6.13, (.011 - .013 inch) angle 60°



Note

Although electrostatic application of Aerodur Sealer 42240 is possible, the electrostatic effect may be minimal because of the high polarity of the mixed material.



Number of Coats

Apply one closed cross coat or two single coats (viscosity 21 – 24 sec. ISO4), or apply one single coat, followed after 10 minutes flash off time by a cross-coat (viscosity 18 – 21 sec. ISO4)



Overcoat window

Overcoat window with Aerodur HS 2121 CF

Temperature / RH	20 – 40%	41 – 60%	61 – 80%
15 – 20°C / 59 – 68°F	1 – 4 hrs	1 – 4 hrs	1 – 4 hrs
21 – 25°C / 69 – 77°F	1 – 3 hrs	1 – 3 hrs	1 – 3 hrs
26 – 30°C / 78 – 86°F	½ – 3 hrs	½ – 2 ½ hrs	½ – 2 ½ hrs
31 – 35°C / 87 – 95°F	½ – 3 hrs	½ – 2 ¼ hrs	½ – 1 ¼ hrs

Overcoat window with Aerodur LV 2114

Temperature / RH	Overcoat time
20°C / 68°F, 30 – 80%	2 – 4 hrs
25°C / 77°F, 20 – 70%	2 – 4 hrs
30°C / 86°F, 20 – 60%	2 – 3 ½ hrs
35°C / 95°F, 20 – 40%	2 – 3 hrs

Overcoat time Aerodur Sealer 42240 – topcoat/basecoat

Temp.	Relative Humidity	Overcoat time
20°C-35°C / 68°F-86°F	20%-80%	4 – 72 hrs*

*) If efficient air movement is applied.

Note: if the recommended overcoat time of the primer is exceeded a fresh layer of the relevant primer must be applied according to the TDS in order to ensure optimal adhesion of the system

Aerodur Sealer 42240



Cleaning of equipment

Thinner 98066 followed by Solvent Cleaning C 28/15 or Solvent Cleaning 98068.



Note

Thinner 98066 is not compatible with polyurethane products and intermix will lead to clogging of equipment.

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 +/- 2°C / 77
+/- 2°F, 55 +/- 5%
RH)

Dry to tape	2 hours
Recoat minimum	4 hours
Recoat maximum	72 hours



Theoretical Coverage

14 m² per liter base at 8 µm dry film thickness
562 ft² per US gallon base at 0.32 mil dry film thickness



Dry Film Density

2.0 g/m²/µm
0.010 lbs/ft²/mil



Gloss (60°)

Maximum 10 GU



Color

Off white



Flash-point

Aerodur Sealer 42240	<21°C / 70°F
Thinner 98066	<21°C / 70°F

Aerodur Sealer 42240



Storage

Store the product dry and at a temperature between 5 and 35°C / 41 and 95°F. Stored in the original unopened containers.

Shelf life

5 - 38°C

(40 - 100°F)

Aerodur Sealer 42240

Thinner 98066

12 months

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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