

# SURFACER FR-P1K

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

**AkzoNobel**

## Product information



FR-P1K is an isocyanate-free mono-component, water based, fire retardant acrylic surfacer designed to fill pinholes and correct defects on cabin interior composite parts.

FR-P1K is compatible with putties FR-M1K and FR-PREPRIME and topcoats such as FR2-55, FR6-55, FRC, Di-tex and FRS40.

## Components



**Base FR-P1K**

## Specifications



### Qualified in accordance with:

AIRBUS AIMS 04-08-001

The product technical data is given for information and can differ from customer requirements as defined in specifications above. In that case, requirements are valid for your application

## Physical properties



### THEORETICAL COVERAGE

7m<sup>2</sup>/kg for 50µm dry (base undiluted)

### DRY FILM WEIGHT

1.9

### VOC

90g/L (ISO11890-1) or 150g/L (ASTM D3960)

### COLOR

Stone grey, Sandy beige, Cream

### SHELF LIFE / STORAGE

12 months stored between 5 and 35°C (41-95°F) in full and sealed original packaging.

### GLOSS LEVEL

Below 10GU under 60°

### NOTES

**Flash Point** : >100°C (212°F).

Gloss levels have been determined thanks to glossmeter with 60° angle of incidence.

The theoretical coverage doesn't take in account the gunspray loss.

## Surface preparation



Before application, the composite panel must be sanded with P120 or P240 sandpaper.

Blow air on the surface and then wiped with appropriate solvent (like isopropanol for instance).

All recommendations mentioned above are given for information.

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Instructions for use



## SPRAY APPLICATION

### MIXING PROCEDURE

Before use, mix carefully the base until you obtain a homogeneous mixture

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

Mixing by weight is recommended the mixture must be made at a temperature between 15°C and 35°C (60-95°F).

### INDUCTION TIME

None

### INITIAL SPRAYING VISCOSITY

The equipment used for application can determine the desired dilution.

The list below is a guide to the optimum viscosity for various types of equipment.

ISO6

20-30s

### 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

ISO6 is the reference cup.

For water-based paints only: Water based paints show a thixotropic behaviour. This implies that efflux time can vary according different parameters such as: mixing quantity, type of mixing, dilution, temperature, time between mixing and viscosity measurement.

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## BRUSH APPLICATION

### MIXING PROCEDURE

Before use, mix carefully the base until you obtain a homogeneous mixture.

Application  
recommendations



## CONDITIONS

**Temperature** 15 to 35°C (60-95°F)

**Relative humidity** 30 to 75%

## EQUIPMENT

**Pneumatic spray gun** nozzle size: 1.4 to 2mm

## DRY / WET FILM THICKNESS

50-100µm dry (2 to 4 mils) / 100-200µm wet (4 to 8mils)

## NUMBER OF COATS

With a pneumatic spray gun, follow the above recommendations and apply 2 to 4 layers (applied in crossed coats) in order to obtain the requested thickness (50 to 70 microns dry – 2 to 3 mils).

For thicknesses above 70µm dry (3 mils), wait for water evaporation for 20 minutes (matte aspect) before applying the next layers)

Dynamic air pressure 1.8 -2.2 bars / 26 – 32 psi

With a brush, apply one layer and if necessary apply a second layer 2 minutes after the first one

## EQUIPMENT CLEANING

Clean the equipment with water then use an appropriate thinner such as Thinner D770-B from MAPAERO

## NOTE

Spray with dry, oil free air.

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## Drying times



	23°C(73°F)	40°C(104°F)	60°C(140°F)
<b>Dust free</b>	10-20minutes	NA	NA
<b>Dry to handle</b>	30-45minutes	20-30minutes	10-15minutes
<b>Dry to tape</b>	2-4hours	30minutes-1hour	15-30minutes
<b>Dry to sand</b>	1h30-2h30	45minutes-1h15	25-35minutes
<b>Fully Cured</b>	7days	3days	12hours

### NOTE

Masking time may vary depending on the tape used.

NA: Not Applicable

Drying times have determined using pieces of a thickness <2mm and for 50µm (2mils) of dry film.

## Defects & corrections



In case of defect, contact your Quality Department

## Health & Safety



See the product Safety Data Sheets.

The MSDS are available through our website [www.mapaero.com](http://www.mapaero.com) upon request

## Packing



1kg; 2.5L; 5kg; 25kg; 200kg.

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.