Optidur 9300 Series
Technical Data Sheet

Product Group

Cabin Coatings

Characteristics

Product Information

Optidur 9300 Series is a 2-components high quality water based acrylic polyurethane topcoat in four reduced sheen options. The material is specifically formulated to obtain premium performance with respect to hardness, durability, abrasion, scratch and chemical resistance. The Optidur 9300 is available from 5% to 80% sheen.

Product is part of the Optidur Series which utilizes the latest resin technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components

Optidur 93XX Base	Optidur 930-0XXA
Hardener	Optidur 930-001B
Water	Optional

Specifications

AkzoNobel Aerospace

Qualified Product List

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions

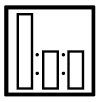
Cleaning

- Product is compatible with other products out of the Optidur Series.
- Remove oil, grease and other contaminations carefully prior to application of the Sealer.
- Remove dust with tack rags prior to application of the Optidur 9300.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905
Mail: aerospace@akzonobel.com / Online: aerospace.akzonobel.com

Optidur 9300 Series
Low Gloss Acrylic PU

Instruction for Use



Mixing Ratio (volume)

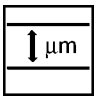
	Volume (v/v)
Optidur 930-0XX Topcoat	100 parts
Optidur 930-001B Hardener	8%
Reducer water	0-10%

- Allow products to acclimatize to room temperature before use.
- Actively mix part A while pouring part B for 2 minutes.
- Add Water and stir the mixture thoroughly for at least 2 minutes or until homogenous.

Induction Time: 5 minutes

Initial Spray Viscosity (25ºC/77ºF): 31-35 seconds with #2 Signature Zahn

Pot life (25ºC/77ºF) – 55% RH): Product must be stirred before use
Pot life is 3-4 hrs.



Dry Film Thickness (DFT): Apply 50 – 100 µm (2 – 4 mils).

Note: Respect described pot life / working window.

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Application Recommendations

Conditions

Temperature:	15 - 35°C 59 - 95°F
Relative Humidity:	25 - 85%

Note

Optidur 9300 Topcoat may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.

Equipment

Spray application using industry standard or HVLP spray equipment.
Follow equipment manufacturer pressure recommendations with 1.2 – 1.4 mm tip size.

Application

- 2-4 wet mils per coat, with 10-15 minutes flash between coats
- Flash 20 - 30 minutes prior Oven
- Max recommended build is 3 mils DFT

For multiple coats, it is important to allow proper flash off time between coats to avoid solvent entrapment (solvent pop).

Cure Guidelines

	Ambient (68ºF)	Forced Cure (140ºF)
Tack Free	30 min	15 min
Dry-to-Sand	4 hours	1 hour
Dry-to-Stack	24 hours	1 hour

Cleaning of Equipment

Clean equipment with Acetone. Clean equipment directly after use.

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Note	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 for the product for the first time, it is recommended that test panels be prepared to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties

Dry Film Weight	25 g/m^2/25µm
Volatile Organic Compounds	Maximum 158 g/l Maximum 0.53 lbs/gal
Gloss (60°)	5% - 80% Gloss Gloss percentage closely aligns to Gloss Units (GU) within +/- 5 GU.
Color	Clear
Flash-point	Not applicable.
Storage	Store the product dry and at a temperature between 5 and 21ºC / 41 and 70ºF per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to container label for specific storage life information. Always Rotate Stock.

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Shelf life 5 - 21°C (41 - 70°F) / 55% RH	Optidur 930-0**XX**A Topcoats	12 Months
	Optidur 930-001B Hardener	12 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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