

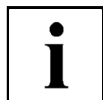
Alumigrip 4450 Clear Coat

Technical Data Sheet

Product Group

High Solids Acrylic Urethane Topcoat

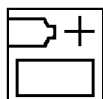
Characteristics



Product Information

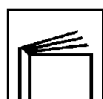
- Alumigrip 4450 Clear Coat is a 3-component, high solids, durable, Acrylic Urethane clear coat that provides exceptional gloss and Distinctness Of Image (DOI).
- Formulated to exceed the performance and appearance requirements of the General Aviation (GA) industry.
- The Alumigrip 4450 Clear Coat should be used with Alumigrip 4400 or Alumigrip 4250 Base Coat as part of a base coat/clearcoat system.
- It may also be used with Alumigrip 4200.
- Designed to meet the rigorous requirements of the MIL-PRF-85285 specification.
- Passes High-Pressure Water Jet simulated erosion test.
- Base coat / clear coat system helps reduce cycle time.
- Low VOC; high solids technology.
- Buffable.
- Extended durability / UV resistance.
- Resistant to military and commercial aircraft fluids.

Components



Base	Alumigrip 4450 Clear Coat
Curing Solution	Curing Solution CS4906
Activator	Activator A4962
Activator	Activator A4961
Activator	Activator A4968
Activator	Activator A4969

Specifications



Qualified Product List

AkzoNobel	Certification
Cessna	CMFS038
Embraer	MEP-10-125 TY I
Gulfstream Aerospace	GMS 5008
Piper Aircraft Inc	PMS-F1010

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

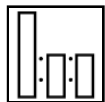


Cleaning

- Alumigrip 4450 Clear Coat is compatible with Alumigrip 4200, Alumigrip 4250, and Alumigrip 4400.
- Please refer to the proper product TDS for overcoat windows in preparing the product prior to Alumigrip 4450 Clear Coat application.
- AkzoNobel Ultra Prep Surface Cleaner or isopropyl alcohol may be used to remove surface contamination prior to Alumigrip 4450 Clear Coat application.
- Remove dust with clean tack rags just prior to application of Alumigrip 4450 Clear Coat.

Alumigrip 4450 Clear Coat

Instruction for Use



Mixing Ratio

	Volume
Alumigrip 4450 Clear Coat	4 parts
Curing Solution CS4906	4 parts
Activator*	1 part

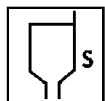
* Activator options: Activator A4962, Activator A4961, Activator A4968, Activator A4969

- Allow products to acclimatize to room temperature before use.
- Stir Alumigrip 4450 Clear Coat thoroughly until the product is uniformly homogenized before adding the curing solution.
- Add the Curing Solution and stir the catalyzed mixture thoroughly.
- Add the activator and stir the catalyzed activated mixture again thoroughly.
- Product SRA-9009 is available to facilitate coating repairs. For instructions using SRA-9009, please see the product TDS.



Induction Time

20 minutes



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

15 – 20 seconds Zahn Cup #2 Signature series
20 – 40 seconds ISO Cup #4



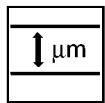
Note

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)

2-2.5 hours



Dry Film Thickness
(DFT)

50 – 62.5 µm
2 – 2.5 mils

Alumigrip 4450 Clear Coat

Application Recommendations



Conditions

Temperature: 15-35°C / 59-95°F
Relative Humidity: 35 - 75%

Activator Guidelines:

A4961 Warm, Humid Activator
80°F-95°F / 27°C-35°C, 65-80% RH

A4962 Cool Weather Activator
70°F - 80°F / 21°- 27°C, 25-85% RH

A4968 Standard Activator
75°F - 90°F / 24°- 32°C, 25-85% RH

A4969 Fast Stripe - Spot Repair Activator
70°F - 80°F / 21°C - 27°C, 15-65% RH



Note

Alumigrip 4450 Clear Coat 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 Recommendation

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.2-1.4 mm	N/A	3-5 bar / 43-73 psi
HVLP / Next Generation	N/A	N/A	1.2-1.4 mm	N/A	2-2.5 bar / 29-36 psi**
Air Atomizing (electrostatic)	N/A	N/A	1.2-1.5 mm	230-280 ml/min	3-4 bar / 43-58 psi
Pressure Atomizing (electrostatic)	N/A	N/A	0.009-0.013 inch / 60°	N/A	N/A

*Measured with an open trigger.

**General advice to meet HVLP / next generation spray gun requirements. Please validate with your local authorities.



Number of Coats

Apply full wet coats (2-3 coats) until desired mils are achieved. Flash times between coats will vary with temperature and activator selection. Recommend 15- 20 minutes between coats.



Note

Clearcoat will feel tacky when its ready for the next coat.



Cleaning of Equipment

TR-19 or MEK



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 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.

Alumigrip 4450 Clear Coat

Physical Properties



Drying Times

	25°C/77°F, 55% RH, Activator A4961	25°C/77°F, 55% RH, Activator A4962	25°C/77°F, 55% RH, Activator A4968	25°C/77°F, 55% RH, Activator A4969
Dust Free	8 hours	6 hours	4 hours	0.5 hour
	3 hours*	2 hours*	2 hours*	NA*
Dry to Tape	24-36 hours	10 hours	12 hours	1-1.5 hours
	6 hours*	4 hours*	4 hours*	NA*
Full Cure	7 days	7 days	7 days	7 days
	7 days*	7 days*	7 days*	NA*

*Force Cure Drying Times - 120°F (flash for 60 minutes prior to bake). Force cure is not recommended for A4969 repair activator.



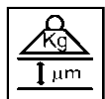
Note

Dry times and recoat times will vary depending on combinations of temperature, humidity and airflow.



Theoretical Coverage

19.29² per liter ready to apply at 25.4 µm dry film thickness.
786 ft² per US gallon ready to apply at 1.0 mil dry film thickness.



Dry Film Weight

29 g/m²/µm
0.0059 lbs/ft²/mil



Volatile Organic Compounds

Maximum 420 g/l
Maximum 3.5 lbs/gal



Gloss (60°)

Minimum 90 GU



Color

Clear



Flash Point

Alumigrip 4450 Clear Coat	25°C/77°F
Curing Solution CS4906	7°C/44°F
Activator A4962	7°C/44°F
Activator A4961	7°C/44°F
Activator A4968	7°C/44°F

Alumigrip 4450 Clear Coat

Activator A4969

7°C/44°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F 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.

Shelf life 5 - 38°C (41 - 100°F)

Alumigrip 4450 Clear Coat	24 months
Curing Solution CS4906	24 months
Activator A4962	24 months
Activator A4961	24 months
Activator A4968	24 months
Activator A4969	24 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.

Revision date: June 2023 (supersedes June 2022) - FOR PROFESSIONAL USE ONLY

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. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel