# 22/23 Series
## High Solids Epoxy Topcoat

AkzoNobel
Tomorrow's Answers Today

**Product Group**

Epoxy topcoat

**Characteristics**

Product Information

- The 22/23 Series product is a chemically cured two-component epoxy topcoat designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol®) fluids and corrosion causing media. This high solids technology meets VOC requirements of SCAQMD Rule 1124.

**Components**

Curing Solution

Gloss Curing Solution X-530
Semi-gloss Curing Solution EC-263
Flat Curing Solution EC-264

**Specifications**

Qualified Product List

| | |
|---|---|
| Boeing | BMS 10-11, Ty II, Cl B, Gr D |
| EADS (CASA) | Z-12.361/BMS 10-11, Ty II, Cl B |
| Goodrich | EMS 93284 C Cl A (AiResearch Los Angeles Div.) (22 series / color specific) |

The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: **www.akzonobel.com/aerospace**

**Surface Conditions**

Cleaning

- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

**Instruction for Use**

Mixing Ratio (volume)

| | |
|---|---|
| | <u>Gloss</u> |
| 3 parts | Base 446-22 Series |
| 1 part | Curing Solution X-530 |
| | <u>Semi-gloss</u> |
| 1 part | Base 456-23 Series |
| 1 part | Curing Solution EC-263 |
| | <u>Flat</u> |
| 1 part | Base 466-23 Series |
| 1 part | Curing Solution EC-264 |

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly



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| | |
|---|---|
| Induction Time | 15 minutes. |
| Initial Spraying Viscosity (25ºC/77ºF) | 17 – 35 seconds 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 (25ºC/77ºF) | 4 hours. |
| Dry Film Thickness (DFT) | 25-37 microns (µm)<br>1.0-1.5 mils |

## Application Recommendations

| | | |
|---|---|---|
| Conditions | Temperature: | 15 – 35°C<br>59 – 95°F |
| | Relative Humidity: | 35 – 75% |
| 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 in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating. | |
| Equipment | Airless | .279 mm 0.011 inch 60° angle<br>.330 mm 0.013 inch 80° angle |
| | Air | |
| | Fluid tip | 1.4 mm (0.055 inch) |
| | Atomizing air pressure | 45-65 psi |
| | Fluid pressure | 6-8 psi |
| Number of coats | Spray a single wet coat. Allow a 15 minute solvent flash and apply a second wet coat. | |



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| | |
|---|---|
| Cleaning of Equipment | Use TR-19 for cleanup. This balanced thinner will minimize the possibility of residue remaining on the equipment. |

## Physical Properties

| | |
|---|---|
| Drying Times according to AITM 2-0011 (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH) | Dry to touch 3 hours<br>Dry to tape 7 hours |
| Theoretical Coverage | 250-400 $ft^2$/gal based on 50% transfer efficiency<br>6-10 $m^2$/l based on 50% transfer efficiency |
| Dry Film Weight | 3.5 lbs/gal (420 g/l) max. per US calculations |
| Volatile Organic Compounds | Max 420 g/l<br>Max 3.5 lb/gal per US calculations |
| Gloss (60º) | 446-22 Series 90 gloss units minimum<br>456-23 Series 20–40 gloss units<br>466-23 Series 14 gloss units maximum |
| Color | As required |
| Flash-point | See MSDS for specific component flash-point. |
| Storage | Store the product dry and at a temperature between 5 and 38ºC / 40 and 100ºF per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information. |
| Shelf life 5 - 38°C (40 - 100°F) | 12 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information. |



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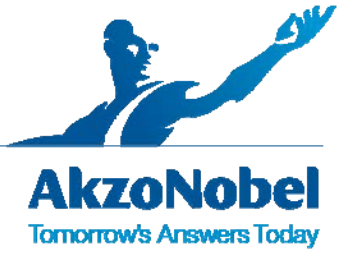


**Safety Precautions**

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 MSDSs are available on request.

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