422X Series
High Solids Topcoat

AkzoNobel
Tomorrow's Answers Today

Product Group

Epoxy topcoat

Characteristics

Product Information

- A two-component, chemically cured epoxy topcoat designed to provide chemical resistance coupled with sufficient flexibility to minimize chipping and flaking. This epoxy topcoat can be used with various primers. Normally military specification primers MIL-P-85582, MIL-P-23377 or MIL-P-53022 are recommended.

Components

Curing Solution

Gloss Curing Solution:	0200T129
Semi-gloss and Flat Curing Solution:	0200T126

Specifications

Qualified Product List

Air France	SMI 70 132-1
Military US	MIL-PRF-22750

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)

Gloss

3 parts	Base 422X Series
1 part	Curing Solution 0200T129

Semi-gloss and Flat

3 parts	Base 422X Series
1 part	Curing Solution 0200T126

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

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Induction Time	30 minutes
Initial Spraying Viscosity (25ºC/77ºF)	50 seconds maximum (#4 Ford) admixed 75 seconds maximum (#4 Ford) at pot life
Note	The uses of Ford Cups for viscosity are requirements of the referenced specifications, and provided only as a reference for field application. They are not provided as quality control values. Actual values will vary when tested outside of standard conditions (25ºC/77ºF) 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)	1.8 – 2.2 mils 46 – 56 microns

Application Recommendations

Conditions	Temperature: 15 – 35°C 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	Standard suction, pressure, HVLP or airless spray
Number of coats	Spray a uniform wet coat. Flash 10-15 minutes, then apply a second wet coat to recommended dry film thickness.

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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
	Dry to tape	8 hours
	Full cure	14 days
	Accelerated Cure	
	Dry to tape / handle	2 hour flash off at ambient, then 20 – 30 minutes at 140°F (60°C)
	Full Cure	24 hour flash off at ambient, then 24 hours @ 150°F (65.5°C)

Note

CAUTION: The accelerated cure for dry to tape / handle may cause a slight variation to color and/or gloss in some topcoats. Light colors, e.g., white and off white, in the semi gloss range could be affected.

NOTE: The cure required will vary due to the efficiency of the oven being used (evacuating the solvent heavy air) and the amount of air movement in the oven. The customer should run tests to verify the required cure schedule.

Theoretical Coverage

20.3 – 22.1 m^2 per liter ready to apply at 25 μm dry film thickness
825 – 900 ft^2 per US gallon ready to apply at 1 mil dry film thickness

Dry Film Weight

Gloss
39.3 ± 3.0 g/m^2/25 μm micron
0.0080 ± 0.0008 lbs/ft^2/mil
Semi-gloss and Flat
46.3 ± 3.0 g/m^2/25 μm micron
0.0094 ± 0.0008 lbs/ft^2/mil

Volatile Organic Compounds

Max 340 g/l
Max. 2.8 lb/gal

Gloss (60º)

Gloss	90+
422XT1XXXXX* / 0200T129	
Semi-gloss	15 to 30
422XT2XXXXX* / 0200T126	
Camouflage	5 maximum (9 maximum 85°)
422XT3XXXXX* / 0200T126	

*Last 5 digits refer to 595B Federal Standard Color

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Color	As required
Flash-point	422X Series -4ºC / 25ºF 0200T126 27ºC / 80ºF 0200T129 36ºC / 97ºF
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)	24 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.

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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