

22/23 Series

Technical Data Sheet

Product Group

Characteristics



Product Information

Epoxy Top Coat

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



Base	446-22 Series
Base	456-23 Series
Base	466-23 Series
Curing Agent	Curing Solution EC-263
Curing Agent	Curing Solution EC-264
Curing Agent	Curing Solution X-530

Specifications



Qualified Product List

Boeing	BMS 10-11, TYII CLB GRD
Honeywell	51180314
Honeywell	MC8045-01
Israel Aerospace Industries	MS100014E
Rohr	RMS 118, TY II, CL L

Surface Conditions



Surface Preparation/
Cleaning

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

22/23 Series

Instruction for Use



Spray Application (Mix Ratio)

Volume

Base*	1-3 parts
CuringAgent*	1 part

* Base options: 446-22 Series, 456-23 Series, 466-23 Series

* CuringAgent options: Curing Solution EC-263, Curing Solution EC-264, Curing Solution X-530

Gloss

Base 446-22 Series	3 parts
Curing Solution X-530	1 part

Semi-gloss

Base 456-23 Series	1 part
Curing Solution EC-263	1 part

Flat

Base 466-23 Series	1 part
Curing Solution EC-264	1 part

- Stir or Shake base component until all pigment is uniformly dispersed. - Once added, Stir the catalyzed mixture again thoroughly

Note : EC-264 requires stirring or agitation itself BEFORE mixing with the base component (due to its composition) in order to achieve a homogenous consistency of dispersion.



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

17 – 35 seconds EZ 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

4 Hours

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 airflow 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.

22/23 Series

	Equipment Recommendation	Airless: 279 mm 0.011 inch 60° angle .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
	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.
	Cleaning of Equipment	Use TR-19 or MEK.

Physical Properties

	Drying Times	25°C/77°F
	Dust Free	30 minutes
	Tack Free	3 hours
	Dry Through	6 hours
	Theoretical Coverage	250-400 ft²/gal based on 50% transfer efficiency 6-10 m²/l based on 50% transfer efficiency
	Dry Film Weight	
	Note	446-22 Series: 1.6700 g/m² /µm 456-23 Series: 2.5300 g/m²/µm 466-23 Series: 2.4700 g/m²/µm
	Volatile Organic Compounds	European guidelines 420 US guidelines 3.5
	Color	As Required
	Flash Point	446-22 Series 456-23 Series 466-23 Series Curing Solution EC-263 Curing Solution EC-264

See MSDS for specific component flash-point.

22/23 Series

	Curing Solution X-530
Shelf life	12 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container labels for specific shelf life information.
Shelf life	446-22 Series 456-23 Series 466-23 Series Curing Solution EC-263 Curing Solution EC-264 Curing Solution X-530

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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Revision date: July 2026 (supersedes January 2023) - 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