

Aeroflex HS 113F03

Technical Data Sheet

Product Group

Characteristics



Product Information

Wing Coating

Aeroflex HS 113F03 is a 3-component polyurethane high gloss wing coating with excellent flexibility for exterior use on the upper surface (in-spar) of the wing box and horizontal stabilizers.

- High solids
- Extremely highly flexible
- Low surface roughness
- Applicable over Aerodur HS 2121 CF Primer and Aviox CF Primer 37124.

To ease the spot repairs, Aeroflex HS 113F03 can be used in combination with SRA9009. See the Technical Data Sheet of SRA9009 for this purpose.

Components



Base	Aeroflex HS 113F03
Hardener	Hardener 90150
Activator	Activator 99322
Activator	Activator 99330

Specifications



Qualified Product List

Airbus	AIMS 04-04-034
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Product specifications change constantly, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions



Surface Preparation/
Cleaning

- Observe the recoatability limits of the relevant primer/topcoat.
- Remove oil, grease and other contaminants prior to the application of Aeroflex HS 113F03.
- Recondition aged primers or topcoats with e.g. Scotch-Brite® type A very fine to a uniform matt surface.
- Remove dust with e.g. tack rags prior to the application of Aeroflex HS 113F03. oxide non-woven abrasive, type very fine.

Instruction for Use



Spray Application (Mix Ratio)

	Volume	Weight
Aeroflex HS 113F03	100 parts	134 parts
Hardener 90150	37 parts	33 parts
Activator*	33 parts	29 parts

* Activator options: Activator 99322, Activator 99330

- Allow products to acclimatize to room temperature before use.
- Stir or shake Aeroflex HS 113F03 till all pigment is uniformly dispersed before adding hardener.
- Add hardener 90150 and stir the catalyzed mixture thoroughly.
- Add activator and stir again to a homogeneous mixture

Note:

The application and mixing characteristics of High Solid products differ from conventional products. Mix base and hardener for at least 2 minutes thoroughly. The high solid content causes a rapid film build-up.



Induction Time

Not applicable. The product is ready for use directly after mixing.

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	Initial Spraying Viscosity (23°C/73°F)	24 – 30 seconds ISO Cup #4 13 – 16 seconds Gardner Signature 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 (23°C/73°F)	2 hours.
	Dry Film Thickness (DFT)	45 – 80 µm 1.8 – 3.2 mils
	Note	Color White G10222 M8006 DTF: 45 - 60 µm Color RAL9003 DTF: 70 - 80 µm

Application Recommendations

	Conditions	Temperature: 15 – 35 °C 59 – 95 °F Relative Humidity: 35 – 75 %
	Note	Aeroflex HS 113F03 may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.
	Equipment Recommendation	Air 1.4 mm nozzle orifice HVLP 1.4 mm nozzle orifice Air Electrostatic 1.2 mm nozzle orifice Airless Electrostatic 6.11 – 6.13, (.011 - .013 inch) angle 60°
	Number of Coats	Horizontal application: apply in one full coat to achieve required DFT. If industrial opacity is not achieved, apply another full coat when dry to step. Vertical application: apply one full coat followed by second full coat after 20 minutes flash-off to achieve required DFT.
	Cleaning of Equipment	Solvent Cleaning C 28/15 or Solvent Cleaning 98068 (slower evaporating).
	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 the appearance of the coating.

Physical Properties

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	Drying Times		23°C/73°F, 55% RH, Activator 99330		23°C/73°F, 55% RH, Activator 99322	
	Dry to Touch	1 hour			2 hours	
	Dry to Tape	3 – 4 hours			6 – 9 hours	
	Dry to Step	3 hours			5 – 7 hours	
	Recoat able	Minimum: 9 – 48 hours			Minimum: 9 – 48 hours	
	Recoat able	Maximum: If drying time of 48 hours is exceeded, condition surface with e.g. Scotch-Brite® type A very fine.				
	Theoretical Coverage		9 m² per liter ready to apply at 60 µm dry film thickness. 362 ft² per US gallon ready to apply at 2.4 mils dry film thickness.			
	Dry Film Weight		1.5 g/m²/µm 0.0078 lbs/ft²/mil			
	Volatile Organic Compounds		Maximum 420 g/l Maximum 3.5 lbs/gal			
	Gloss (60°)		Minimum 88 GU			
	Color		White G10222 M8006 White G10459 RAL9003			
	Flash Point		Aeroflex HS 113F03		> 21°C / 70°F	
			Hardener 90150		>21°C /70°F	
			Activator 99322		<21°C / 70°F	
			Activator 99330		<21°C /70°F	
	Storage		Store the product dry and at a temperature between 5 and 35°C / 41 and 95°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 the container label for specific storage life information.			
	Shelf life		Activator 99330		36 months	
	Shelf life 5 - 35°C (41 - 95°F)		Aeroflex HS 113F03		12 months	
			Hardener 90150		24 months	
			Activator 99322		36 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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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