

Aerodur HS 67348

Technical Data Sheet

Product Group

Epoxy Top Coat

Characteristics



Product Information

Aerodur HS 67348 is a low VOC, isocyanate cured polyurethane finish for interior / structural use.

- Resistant to aircraft hydraulic fluids and chemicals.
- High Solid technology.
- Compatible with most commonly used structural basic primers like Aerodur HS Primer 37092 and Epoxy Primer 37035A.

Components



Base	Aerodur HS 67348
Curing Solution	Curing Solution 90150
Activator	Activator 99302

Specifications



Qualified Product List

Airbus	AIMS 04-04-003
Airbus	AIMS 04-04-040
Airbus	AIMS 04-04-041
British Aerospace Airbus	ABP 4-2130
Hawker Beechcraft	BAEP3528-4PSD2

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



Surface Preparation/
Cleaning

- Observe the recoatability limits of the relevant primer.
- Remove oil, grease and other contaminants prior to application of the finish.
- Clean aged primer or epoxy/polyurethane finishes and sand/abrade to a uniform matt surface using grade P320 sandpaper or an aluminum oxide non-woven abrasive pad grade very fine.
- Remove dust and debris with clean tack rags or equivalent prior to application of the finish.

Instruction for Use



Spray Application (Mix Ratio)

	Volume
Aerodur HS 67348	100 parts
Curing Solution 90150	33 parts
Activator*	33 parts

* Activator options: Activator 99302

- Allow products to acclimate to room temperature before use.
- Stir or shake Aerodur HS 67348 until all pigment is uniformly dispersed before adding curing solution.
- Add Curing Solution 90150 and stir the catalyzed mixture thoroughly.
- Add Activator 99302 and stir the catalyzed mixture again thoroughly to achieve a homogeneous mixture.



Induction Time

Not applicable. Product can be used directly after mixing.

Initial Spraying Viscosity (23°C/73°F)

30 – 40 seconds ISO Cup #4
15 – 17 seconds Gardner Signature Zahn Cup #2

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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)

3 hours



Dry Film Thickness (DFT)

25 – 30 µm
1 – 1.2 mils



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.

Application Recommendations



Conditions

Temperature: 15 – 35 °C
59 – 95 °F

Relative Humidity: 35 – 75 %



Note

Aerodur HS 67348 topcoat may be applied in conditions outside of the 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

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.4-1.8 mm	N/A	3-5 bar / 43-73 psi
HVLP / Next Generation	N/A	N/A	1.4-1.8 mm	N/A	2-2.5 bar / 29-36 psi**
Air Atomizing (electrostatic)	N/A	N/A	N/A	N/A	N/A
Pressure Atomizing (electrostatic)	N/A	55-75 bar / 0.8-1.0k psi	0.011-0.013 inch/60°	260-300 mL/min	4-5 bar / 58-73 psi



Number of Coats

Spray-apply a homogeneous, wet and closed cross-coat in order to achieve a dry film thickness of 25 – 30 µm / 1.0 – 1.2 mils.



Cleaning of Equipment

Solvent Cleaning C 28/15 or Solvent Cleaning 98068.



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.

Physical Properties

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Drying Times

23°C/73°F, 55% RH

Dust Free	2 – 3 hours
Dry to Tape	6 – 8 hours
Dry to Handle	12 minutes flash off time, followed by 40 minutes at 75°C.
Force Cure	30 minutes flash off time, followed by 2 hrs at 60°C.
Recoatable Minimum	7 hours
Recoatable Maximum	72 hours

If a drying time of 72 hours is exceeded, condition surface with grade P320 sandpaper or an aluminum oxide non-woven abrasive pad grade very fine to a uniform and matt surface.



Theoretical Coverage

33 m² per liter base material at 25 µm dry film thickness.
1325 ft² per US gallon base material at 1.0 mil dry film thickness.



Dry Film Weight

1.60 g/m²/µm



Gloss (60°)

15 – 50 GU



Color

Grey color 054569 (M9001)



Flash Point

Aerodur HS 67348	<21°C / 70°F
Curing Solution 90150	<21°C / 70°F
Activator 99302	<21°C / 70°F

Shelf life 5 - 35°C (41 - 95°F)

Aerodur HS 67348	24 months
Curing Solution 90150	24 months
Activator 99302	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.

Revision date: July 2024 (supersedes September 2018) - 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

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