

VARNISH 1500 FR

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

AkzoNobel

Product information



Three-component polyurethane varnish with high solid content, designed to protect aircraft cabin interiors. This varnish provides topcoat ranging from matt to gloss in cabin interiors.

Components



Base 1500 FR
Hardener / Catalyst 1500 FR
Thinner FRSL

Specifications



Qualified in accordance with :

Pilatus : PMS0600-52-02

Meets the following requirements:

JAR / FAR Part 25 §25.853 (a), (c / d) / Change 14/Amdt. 25-83

Product information mentioned in the technical datasheet is given for information purposes and can differ from requirements of specifications above. In that case, customer requirements are valid for your application.

Physical properties



THEORETICAL COVERAGE

9 m²/L (937 sq.ft/gal) for 50 µm (2 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT

1,1

VOC

497 g/L (base+hardener/catalyst)/560 g/L (for a dilution at 24% base+hardener/catalyst+thinner)

SHELF LIFE / STORAGE

48 months for gloss base and the thinner and 12 months for base and hardener stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL

Gloss, semi-gloss, matt

NOTES

Gloss levels have been determined using glossmeter with an angle of incidence of 60°. The theoretical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation



Varnish 1500 FR can be applied on FRS40 polyurethane top coat to give the required effect. FRS40 top coat should be slightly sanded using a P400 grade abrasive.

All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	2 V
Hardener / Catalyst	50	1 V
Thinner	0 to 50	0 V to 1 V

MIXING PROCEDURE

Ideally, unmixed products should be stored between 18°C (64°F) and 25°C (77°F) for 24 hours before use. 1500FR base should be mixed for 10 minutes before use, for semi-gloss and matt, using a pneumatic or oscillating mixer. Mix the base and the hardener until the material is homogeneous. Then add water. The mixture by weight is recommended. The mixture must be made at a temperature between 15°C (59°F) and 35°C (+95°F). Remark : It is recommended to sieve the varnish before application with 80-150µm (3.1-5.9 mils) filter.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Dilution rate	CA 4
0%	22s ± 5s

POT LIFE

3 hours

NOTE

Viscosities mentioned above are corresponding to the recommended range of viscosity to ensure compliant application. The range of dilution must be used to adjust viscosity to reach the recommended one.

Application recommendations



CONDITIONS

Temperature 15°C to 35 °C (59°F and 95°F)

Relative humidity 30% to 75%

EQUIPMENT

Gravity compressed air gun Nozzle 1,2 mm to 1,8 mm

Electrostatic spray gun

DRY / WET FILM THICKNESS

40 to 60 µm (1.6 to 2.4 mils) dry/90 µm to 130 µm (3.5 to 5.1 mils) wet.

NUMBER OF COATS

Apply a crossed coat, let it dry for 30 minutes until solvent flashes off. Apply a crossed coat to get 40 µm to 60 µm (1.6 to 2.4 mils) dry thickness.

EQUIPMENT CLEANING

Clean the equipment with an appropriate solvent, such as Mapaero FRSL.

NOTE

Spray with dry oil-free air.

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Drying times



Dust free
Dry to tape
Recoatable
Fully Cured

23°C (73°F)

1 hours
6 hours
N.A.*
7 days

60°C (140°F)

N.A.
2 hours
N.A.*
12 hours

NOTE

Drying times have been determined using tests pieces of a thickness < 2mm for 50µm (2mils)n of dry film.

*N.A. : Not applicable

Defects & corrections



In the event of a defect, contact your Quality Department.

Health & Safety



See Product Security data sheets.

MSDS are available through our website www.mapaero.com.

Packing



1500 FR bases (Gloss, Semi-gloss, Matt) are available in 1 L and 5 L.
1500 FR hardener is available in 1 L and 5 L.
FRSL thinner is available in 1 L and 5 L.

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.