PRIMER HB230 PTFE

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information

Teflon® Polyamino-amide three components epoxy coating for industrial mold.
High performance in terms of chemical resistance and abrasion.

Components

Base HB230 PTFE
Hardener / Catalyst HB 230 Hardener
Thinner E

Specifications

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
5.2 to 6.5 m²/L for 80 to 100µm dry

DRY FILM WEIGHT
1.8

VOC
440 g/L (Base and Hardener undiluted)

COLOR
White

SHELF LIFE / STORAGE
48 months for base and 24 months for hardener stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL
Semi-Gloss

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

Surface preparation

The surface must be properly cleaned without any trace of grease, oil or other from of corrosion.
On steel : Sandable DS2 + Application of Protective Primer + HB230
On aluminium alloy : Alodine 1200 + HB230
All recommandations mentioned above are given for information purposes.

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Instructions for use

SPRAY APPLICATION

	Mixing ratio by volume
Base	4 V
Hardener / Catalyst	1 V
Thinner	1.3 V

MIXING PROCEDURE
Ideally, the unmixed products should be stored between 18°C and 25°C (64°F and 77°F) for 24 hours before use.
Mix base and hardener until the material is homogeneous. Then add the thinner and mix.
The mixture must be made at a temperature between 15°C and 35°C (59-95°F)

INDUCTION TIME
None

Spraying viscosity at 20°C / 68°F

AFNOR 4	ZAHN 2
25s ± 5s	30s ± 5s

POT LIFE
6 hours at 23°C (73.4°F)

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.

The AFNOR 4 cup is the reference cup. The others are given for information purposes.

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Application recommendations

CONDITIONS
Temperature 15°C to 35°C
Relative humidity 30 % to 75 %

EQUIPMENT
Gravity compressed air gun Nozzle 1.8mm to 2.3mm

DRY / WET FILM THICKNESS
210 to 250 µm Wet / 100 to 120 µm Dry

NUMBER OF COATS
Spray several crossed coats to obtain 100 µm dry to 120 µm dry

EQUIPMENT CLEANING
Clean the equipment with a suitable cleaning solvent such as thinner E.

NOTE
Spray with dry and oil-free air.

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Drying times

	23°C	50°C	60°C	70°C	80°C
Dust free	1h30	30 minutes	20 minutes	15 minutes	10 minutes
Dry to sand	24 hours	2 hours	1 Hour 30 minutes	45 minutes	30 minutes
Fully Cured	7 days	24 hours	12 hours	7 hours	4 hours

NOTE
Drying times have been determined using test pieces of a thickness < 2mm and for 100µm of dry film.
Flash Off time : 1 hour at room temperature
Roughness: 2µm Ra

*N.A. : Not applicable

Defects & corrections

In the event of defects, contact your Quality Department.

Health & Safety

See the product Safety Data Sheets

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

Packing

HB230 PTFE base is available in 4L
HB230 hardener is available in 1L.
Thinner E is available in 5L

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