

## 23T3 Series

### Technical Data Sheet

#### Product Group

#### Abrasion Resistant Or Walkway Coating

#### Characteristics

A two-component, PTFE-filled, anti-chafe, air curing, low VOC-compliant topcoat. This coating is inherently light stable with excellent abrasion resistance and surface lubricity.



Product Information

23T3 Series topcoat is resistant to phosphate ester hydraulic fluid, aircraft fuel, engine oil, solvents, water and cleaning compounds and is used on aircraft control surfaces.

#### Components



Base	23T3-XXX
Curing Agent	Curing Solution: PC-216
Thinner	Thinner 66C28
Thinner	Thinner 66C20
Thinner	Thinner TR-19
Thinner	Thinner TR-20
Thinner	Thinner TR-115

#### Specifications



Qualified Product List

Airbus Canada	A2MS 565-005
Boeing	BMS 10-86, TY I, GR D PERF
Embraer	MEP 10-071
Lockheed Martin Aeronautic	DWG 70193240
Lockheed Martin Aeronautic	FMS 3120, CL 1, TY 1
Lockheed Martin Aeronautic	LMA-MR008, TY I
Northrop Grumman	GC130RJ2
Pratt & Whitney Aircraft	PWA 36514-2

Only 23T3-10 and 23T3-105 are qualified for BMS 10-86.

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](http://aerospace.akzonobel.com/products).

#### Surface Conditions



Surface Preparation/  
Cleaning

- Observe the overcoat window of the primer
- Sand existing topcoats with P220 sandpaper or an aluminum oxide non-woven abrasive pad to a dull mat finish, and solvent clean prior to applying 23T3.

## 23T3 Series

### Instruction for Use



Spray Application (Mix Ratio)

#### Volume

23T3-XXX	3 parts
Curing Solution: PC-216	1 part
Thinner*	1 part

\* Thinner options: Thinner 66C28, Thinner 66C20, Thinner TR-19, Thinner TR-20, Thinner TR-115

-Allow products to acclimatize to ambient conditions before use.  
-Stir or shake the base component thoroughly to a homogeneous state prior to the addition of the curing solution.  
-Add curing solution PC-216 and stir the catalyzed mixture thoroughly prior to application.

Where VOC regulations allow and depending on temperature and humidity conditions, additional thinning may be made with 66C28, 66C20, TR-19, TR-20 or TR-115. Up to 1 part thinner may be used.



Induction Time

Not Applicable.



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

16 – 24 seconds ISO Cup #6



Note

The use of Signature Zahn Cups for viscosity are requirements of the referenced specifications, and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values.

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 (25°C/77°F)

After 1 hour: 72 seconds ISO Cup #6  
After 2 hours: Sprayable



Dry Film Thickness (DFT)

125 – 250 µm  
5 – 10 mils

### Application Recommendations



Conditions











Temperature:	15 – 35 °C 59 – 95 °F
Relative Humidity:	35 – 75 %



Note

23T3 Series may be applied in conditions outside the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the appropriate application techniques when environmental conditions fall outside of the recommended range.

## 23T3 Series

	Equipment Recommendation	<table border="1"> <thead> <tr> <th>Spray gun type</th> <th>Product supply</th> <th>Fluid Pressure</th> <th>Nozzle orifice</th> <th>Product flow</th> <th>Dynamic air pressure at gun-inlet *</th> </tr> </thead> <tbody> <tr> <td>Conventional</td> <td>N/A</td> <td>N/A</td> <td>1.4-1.6 mm</td> <td>N/A</td> <td>3-5 bar / 43-73 psi</td> </tr> <tr> <td>HVLP / Next Generation</td> <td>N/A</td> <td>N/A</td> <td>1.4-1.6 mm</td> <td>N/A</td> <td>2-2.5 bar / 29-36 psi</td> </tr> <tr> <td>Air Atomizing (electrostatic)</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> </tr> <tr> <td>Pressure Atomizing (electrostatic)</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> <td>N/A</td> </tr> </tbody> </table>	Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *	Conventional	N/A	N/A	1.4-1.6 mm	N/A	3-5 bar / 43-73 psi	HVLP / Next Generation	N/A	N/A	1.4-1.6 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	N/A	N/A	N/A	N/A
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	Note	If roller application is desired, use a fine finish for solvent-based products. Rollers will degrade and should be changed every 30 minutes.																														
	Number of Coats	Apply full wet coats, allowing 15 minutes flash off time between coats, to achieve 50-75 µm (2-3 mils) dry per coat.																														
	Cleaning of Equipment	MEK, TR-19, or C28/15																														
	Note	<p>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.</p> <p>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.</p>																														
<b>Physical Properties</b>																																
	Drying Times	<p style="text-align: center;"><b>25°C/77°F, 55% RH</b></p> <table border="1"> <tbody> <tr> <td>Dust Free</td> <td>1.5 - 2 hrs</td> </tr> <tr> <td>Tack Free</td> <td>3.25 - 3.5 hrs</td> </tr> <tr> <td>Dry Through</td> <td>5.25 hrs</td> </tr> </tbody> </table> <p>An accelerated cure schedule may be used. Once the required film thickness has been achieved, allow minimum one hour flash off time at 75°F (24°C), 50% RH. Cure for two hours at 150°F (66°C) with good air movement.</p>	Dust Free	1.5 - 2 hrs	Tack Free	3.25 - 3.5 hrs	Dry Through	5.25 hrs																								
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	Theoretical Coverage	4.24 m <sup>2</sup> /per liter ready to apply (without thinner) at 125 µm dry film thickness 173 ft <sup>2</sup> per US gallon ready to apply (without thinner) at 5 mils dry film thickness																														
	Dry Film Weight	For 23T3-105: 1.31 g/m <sup>2</sup> /µm 0.00684 lbs/ft <sup>2</sup> /mil																														
	Note	Varies slightly with color.																														
	Volatile Organic Compounds	Without thinner: Max. 420 g/l Max. 3.5 lbs/gal																														
Gloss (60°)		Maximum 65 GU																														

## 23T3 Series



Color

As required

Flash Point

23T3-XXX	27°C / 80°F
Curing Solution: PC-216	28°C / 78°F
Thinner 66C28	15°C / 59°F
Thinner 66C20	-4°C / 25°F
Thinner TR-19	-4°C / 25°F
Thinner TR-20	7°C / 45°F
Thinner TR-115	-17°C / 1°F

Shelf life 5 - 38°C (41 - 100°F)

23T3-XXX	12 months
Curing Solution: PC-216	12 months
Thinner 66C28	24 months
Thinner 66C20	24 months
Thinner TR-19	24 months
Thinner TR-20	24 months
Thinner TR-115	24 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: October 2023 (supersedes September 2022) - 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