

Spray2Fix 58 Series

Technical Data Sheet

Product Group

Polyurethane Top Coat

Characteristics



Product Information

- Aerosol Spray Can Application 58 Series Military Aircraft Camouflage Topcoat.
- This two-component high solids polyurethane finish is formulated for application to military aircraft and is designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, and corrosion causing media.
- These components are packaged in 250 ml and 400 ml aerosol containers for ease of use as a touch-up and repair product.
- Available in gloss, semi-gloss, and camouflage appearance. This product line provides excellent performance with regard to cleanability, mar resistance, and surface smoothness in all gloss ranges.

Components



Base	58 Series Aerosol
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Specifications



Qualified Product List

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 recoat time parameters of the relevant primer and applicable specifications.
- Recondition aged primers or topcoats using grade P320 sandpaper or an aluminum oxide non-woven abrasive pad to achieve a uniform matt finish.
- Remove oil, grease, and other contaminants with an approved cleaning solvent prior to the application of the finish.
- Remove dust and debris with a clean tack rag or equivalent.
- The product is compatible with the following primers:
10P20-13, MIL-PRF-23377, TY I, CL C2
10P20-14, MIL-PRF-23377, Ty II, CL C2
10P20-12, DMS 2104 TY 1, COMP C

Instruction for Use



Spray Application (Mix Ratio)

Volume

58 Series Aerosol	See Remarks part
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To Activate:

Remove the red button from the cover of the cap and attach to the plastic pin at the bottom of the aerosol.

Activation Test:

Place aerosol upright on a flat surface and push down to break the inner seal. Remove the red button from the bottom of the aerosol and push a plastic pin with the thumb, the pin should now move easily.

Turn can upside down. Shake the aerosol vigorously for 2 - 3 minutes after activation to thoroughly mix catalyst. Induct for 30 minutes. If the aerosol is left unused, shake vigorously again prior to each use, then apply.



Induction Time

Not Applicable.




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




Pot life (25°C/77°F)


48 hours at 77°F (25°C), and 50 ± 5% RH.


Spray2Fix 58 Series

	Dry Film Thickness (DFT)	45 – 55 μm 1.8 – 2.2 mils
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Application Recommendations


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

 Note
Spray2Fix 58 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.


 Number of Coats
The delivery of material is faster than a normal aerosol and the fan is larger. Both features are designed to make the application similar to that of a spray gun.


Apply a single wet coat. Allow 30-45 minutes flash-off time between coats at ambient conditions. Apply a second wet coat to achieve the required dry film thickness. Some colors may require a higher film thickness to achieve opacity (e.g., certain reds, yellows, and oranges). A base color may need to be applied first before application of the final color. This is to reduce the number of coats necessary for industrial hiding.

 Note
Flash-off time refers to the elapsed time between the start of the first coat application and the start of the second coat application. Paint should have very little transfer when touched to indicate the paint is ready for application of the next coat.


 Cleaning of Equipment
To clean the nozzle, invert the aerosol and spray until clear.

Physical Properties

	Drying Times	25°C/77°F, 55% RH			
		Dry to Touch	4 hours		
		Dry to Tape	Gloss, 10-12 hours	Semi-gloss, 8 hours	Flat, 6 hours

 Note
Spray2Fix 58 Series may be recoated with an additional application of Spray2Fix 58 Series within 48 hours with no reactivation. If a drying time of 48 hours is exceeded, reactivate with P320 grade sandpaper or an aluminum oxide non-woven abrasive pad. Spray2Fix 58 Series may be recoated up to 7 days when reactivated.

Flash-off times, dry times, and recoat times will vary depending on combinations of temperature, humidity, and airflow. Temperature, wet film thickness, and flash-off time can affect gloss readings, so it is recommended to adhere to the application guidelines above.

	Theoretical Coverage	13.2 – 10.8 ft ² / Aerosol @ 1.8 – 2.2 mils
		1.2 - 1.0 m ² / Aerosol @ 46 - 56 micrometer

	Dry Film Weight	0.00664 lbs / ft ² / 1 mil
		32.41 g / m ² / 25.4 micrometer

Volatile Organic Compounds
Regulation for Reducing the Ozone Formed from Aerosol Coating Product Emissions by California Air Resources Board

Spray2Fix 58 Series

VOC

(CARB) - Complies.
Aviation Primer Product-Weighted MIR Limit: 1.25g O₃/g

National Volatile Organic Compound Emission Standards for Aerosol Coatings, EPA - Complies.
Aviation Primer Product-Weighted Reactivity Limit: 2.0g O₃/g

P-WR of product is <0.80g O₃/g



Color

Per SAE AMS-STD-595



Flash Point

58 Series Aerosol

-16°C / 1°F



Storage

Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life 5 - 38°C (41 - 100°F)

58 Series Aerosol

18 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: November 2024 (supersedes : February 2015) - 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