

TOPCOAT XS4201 SEMI-GLOSS AND MATT

COATINGS FOR AIRCRAFT STRUCTURE PROTECTION

AkzoNobel

Product information



High solid polyurethane 2K topcoat for external and structural application. XS4201 is available in high gloss, semi-gloss and matt version (for high gloss version see corresponding TDS)

Components



Base XS4201
Hardener / Catalyst XS4201
Thinner P2

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

12 m²/ L for 50µm dry - 125 ft²/L for 2 mils dry (base and hardener only)

DRY FILM WEIGHT

1.60 for white base

VOC

420 g/l or 3.5 lb/gal (ISO11890-1 and ASTM D 3960)

SHELF LIFE / STORAGE

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

NOTES

Gloss Level:

For semi-gloss : 10 GU < B < 20 GU
 20 GU < B < 45 GU

For mat : B < 5 GU

Flash Point:

XS4201 Base: 24°C (75°F)

XS4201 Hardener: 170°C (338°F) 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



XS4201 must be applied on an appropriate primer according to substrate used and protection required.

XS4201 is compatible with the following primer SP350, P60-LC, P60-A, P65HG, F69 and the PU system Phosmap 11 and Isomap P23.

All recommendations mentioned above are given for information.

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Instructions for use



SPRAY APPLICATION

Base
Hardener / Catalyst
Thinner

Mixing ratio by volume

4 V
1 V
0.5 V to 1 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.

The XS4201 base should be mixed for 5 minutes in a pneumatic or oscillating mixer before use.

Mix the base, hardener and thinner until the mixture is homogenous.

PThe mixture must be made at a temperature between 15°C and 35°C (59°F and 95°F).

Remark : It is recommended to sieve the mixture using a 125-190 µm (4.9-7.5 mils) filter.

For grey and black colors, 0.5v dilution is recommended.

For white and bright colors, 1V dilution is recommended.

INDUCTION TIME

None

Spraying viscosity at 20°C / 68°F

Ford 4	ISO 6	CA 4
1 V Dilution	1 V Dilution	1 V Dilution
30 ± 10s	15 ± 5s	30 ± 10s

POT LIFE

2 hours minimum

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.

ISO 6 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 (59°F to 95°F)

Relative humidity 20% to 70%

EQUIPMENT

Gravity compressed air gun Nozzle 1.5 to 1.8 mm

DRY / WET FILM THICKNESS

40-80 µm (1.6 to 3.2 mils) dry / 80-160 µm (4.0 to 7.0 mils) wet

NUMBER OF COATS

The number of coats depends on the size and the shape of the part to which it is being applied.

Application of two coats as crossed coats. Leave to flash off for 30 minutes at room temperature and apply again two coats as crossed coats to obtain the required thickness.

EQUIPMENT CLEANING

Clean the equipment with an appropriate cleaning thinner, such as Mapaero D713 or P2 or cetonic solvent

NOTE

Spray with dry, oil-free air.

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Drying times



NOTE

For the **Thinner P2**, drying times are :

	23°C / 73.4°F	50°C / 122°F	60°C / 140°F
Dust free	40 minutes	Not Applicable	Not Applicable
Dry to touch	3 hours	2 hours	1 hour
Dry to handle	6 to 8 hours	4 hours	2 hours
Dry to tape	18 to 20 hours	8 hours	4 hours
Fully cured	7 days	24 hours	12 hours

Drying times have been determined using test pieces of a thickness < 2 mm and for 50 µm (2.0 mils) of dry film. Leave to flash off for 1 hour at 23°C (73.4°F) before curing.

*N.A. : Not applicable

Defects & corrections



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

Health & Safety



See the product Safety Data Sheet.

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

Packing



The XS4201 base is available in 1 L and 4 L.
The XS4201 hardener is available in 1 L and 5 L.
The P2 thinner is available in 1L 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.