

# BASE COAT MONO F15

## FINISHES FOR AIRCRAFT EXTERIORS

AkzoNobel

### Product information



Decorative polyurethane topcoat, matt, solvent-based, single component, fast drying for aircraft exteriors. It is recommended to use the base coat Mono F15 on the two-component MAPAER0 F14 topcoat, respecting the recommended recovery time.

### Components



**Base F15**  
**Thinner 714 or 715**

### Specifications



**Qualified in accordance with :**  
Daher-Socata

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**  
7 m<sup>2</sup>/kg (390 sq<sup>2</sup>/gal) for 50 µm (2mils) dry

**DRY FILM WEIGHT**  
1.75

**VOC**  
640 g/L (ISO 11890-1 and ASTM 3960)

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

**GLOSS LEVEL**  
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



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	4V
Thinner	40 to 50	2V to 2.5V

##### 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 mixture by weight is recommended. The mixture must be made at a temperature between 15°C and 35°C (60-95°F).

##### INDUCTION TIME

None

##### Spraying viscosity at 20°C / 68°F

Mixing ratio by Volume	AFNOR 4 Cup
2.5 V	18 ± 4s

##### POT LIFE

N.A.

##### NOTE

The viscosity mentioned above is 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 viscosity mentioned above is 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 to 95°F)

**Relative humidity** 30 % to 70 %

#### EQUIPMENT

**Gravity compressed air gun** Nozzle 1.5 mm to 1.8 mm (39.37 mils to 78.74 mils)

#### DRY / WET FILM THICKNESS

30 µm to 70 µm (1.2 mils to 2.8 mils) dry

#### NUMBER OF COATS

It depends of the coverage power of the applied color.

#### EQUIPMENT CLEANING

Clean the equipment with an appropriate cleaning thinner, such as PU type from MAPAERO.

#### NOTE

Spray with dry, oil free air.

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### Drying times



**Dust free**  
**Dry to handle**  
**Dry to tape**  
**Recoatable**  
**Fully Cured**

#### 23°C / 73.4°F (thinner 714)

5 to 15 minutes  
30 to 45 minutes  
2 to 3 hours  
1 to 72 hours  
7 days

#### 23°C/73.4°F (thinner 715)

10 to 15 minutes  
30 to 60 minutes  
2 to 3 hours  
1 to 72 hours  
7 days

#### NOTE

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

\*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](http://www.mapaero.com)

### Packing



The base is available in 1L and 5L.  
The thinners 714 and 715 are available in 1L and 5L.

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.