

Alumigrip 4603 CI Filler

Technical Data Sheet

Product Group

Characteristics



Product Information

Components



Specifications



Qualified Product List

Surface Conditions



Surface Preparation/
Cleaning

Instruction for Use



Spray Application (Mix Ratio)



Induction Time



Note



Pot life (25°C/77°F)



Dry Film Thickness (DFT)

Putty Fillers

Alumigrip 4603 CI Filler is a 2-component, fast sanding, epoxy filler formulated to provide corrosion inhibition (CI) using chromate free inhibitors for Aluminum substrates.

Provides a durable, smooth surface on composite and aluminum surfaces, sandable filler for rivets, seam areas, and surface defects.

Minimal shrinkage and/or swelling during application and curing process. Pre-packaged in tube dispenser for accurate mixing.

Base Alumigrip 4603 CI Filler

Curing Solution Curing Solution CS6103

AkzoNobel

Certification

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 pretreatment is an essential part of the painting process.

- Light abrasion to composite substrates and aged primer is recommended to enhance adhesion. Use P320 sandpaper or an aluminum oxide non-woven abrasive pad.
- Remove oil, grease and other contamination prior to application.
- If Alumigrip 4603 CI Filler is applied over aluminum or rivet substrates, ensure that recommended pre-treatment has been used.

	Volume
Alumigrip 4603 CI Filler	2 parts
Curing Solution CS6103	1 part

- Allow tubes to become acclimated to room temperature conditions before use.
- Tubes are proportioned to be mixed at the head in the 2:1 ratio.

The product is supplied in tubes, which requires a dispenser. The proper mix ratio is already taken into account by the type of tube.

Not applicable. Product can be used directly after passage through static mixer applicator tip.

Use MCH 10-24 11" length static mixing nozzle to ensure proper mixing of the components.

20 minutes

25- 125 µm
1 - 5 mils prior to sanding.

Alumigrip 4603 CI Filler

Note

Alumigrip 4603 CI Filler may be applied at higher film builds. Please consult your local AkzoNobel Aerospace Coatings representative for recommendations.

Application Recommendations

Conditions

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

Conditions

Alumigrip 4603 CI Filler 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.

Equipment Recommendation

Apply material directly from the tubes through the static mixing nozzle, using either a hand-powered (manual) applicator or a pneumatic dispensing gun. Do not exceed 80 PSI (5.5 Bars) when using a pneumatic dispensing gun for application. Mixed material can be spread with a trowel, filling knife, or similar device.

Number of Coats

Hold dispensing gun in horizontal position when beginning to dispense material to prevent thinner activator from flowing out of mixing nozzle ahead of thicker base material.

Dispense the Alumigrip 4603 CI Filler into a cup, or apply product as needed directly to rivet head, pinholes or other minor defects. Avoid heavy film build.





Use clean spreading device to smooth the dispensed product over the surface defect.

Once dry-to-sand, remove any excess product above the surface level with filler remaining only inside the defect area.

Cleaning of Equipment

Use MEK, MPK or equivalent solvent.

Physical Properties

	Drying Times	<div><div>25°C/77°F, 55% RH</div><table><tr><td>Dry to Sand</td><td>2 hours minimum Dry to sand time depends on applied film thickness.</td></tr><tr><td>Dry Hard</td><td>16 hours maximum</td></tr><tr><td>Full Cure</td><td>21 days</td></tr></table></div>	Dry to Sand	2 hours minimum Dry to sand time depends on applied film thickness.	Dry Hard	16 hours maximum	Full Cure	21 days
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Full Cure	21 days							
	Note	<p>Alumigrip 4603 CI Filler may be force cured for 1 hour @ 120°F (50°C) to accelerate the dry to sand time (1 hour minimum).</p> <p>Dry times will vary depending on combinations of temperature, humidity, airflow, and film thickness.</p>						
	Theoretical Coverage	<p>1025 ft² per US gallon ready to apply at 1.0 mil dry film thickness.</p> <p>54 ft² per US gallon ready to apply at 1.0 mil dry film thickness.</p>						
	Dry Film Weight	<p>2.17 g/m² /µm</p> <p>0.0100 lbs/ft² /mil</p>						

Alumigrip 4603 CI Filler

	Volatile Organic Compounds	Maximum 340 g/l Maximum 2.83 lbs/gal	
	Gloss	Not applicable.	
	Color	Light Blue	
	Flash Point	Alumigrip 4603 CI Filler	25°C / 77°F
		Curing Solution CS6103	32°C / 89.6°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 and shelf life may vary per OEM specification requirements. Refer to the container label for specific storage life information.	
	Shelf life 5 - 38°C (41 - 100°F)	Alumigrip 4603 CI Filler	12 months
		Curing Solution CS6103	12 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.
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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