Aerobase Special Effects

Technical Data Sheet

Product Group

Polyurethane Top Coat

Characteristics



Product Information

Aerobase Special Effects is a VOC compliant isocyanate cured polyurethane special effect coating and is part of the coatings system consisting of Aerobase - Aerobase Special Effects - Aviox Clearcoat UVR system for exterior application of commercial aircraft.

This system provides uniform coverage and appearance in one coat application for most of the colors and effects. When used with Aviox Clearcoat UVR this system provides a durable, long lasting, protective and decorative finish that exceeds typical OEM requirements for exterior aircraft performance.

Aerobase Special Effects

Aerobase Curing Solution Aerobase Standard Activator

Product specifications change constantly, to ensure the most accurate information regarding specifications, please

AIMS 04-04-025

AMS3095

- The main benefits of our leading Aerobase Aerobase Special Effects Aviox Clearcoat UVR system are:
- Unique and uniform sparkling effect appearance on aircraft livery
- Repairability
- Excellent gloss- and color- retention
- Opacity at low film thickness
- Short tape time
- Superior chemical and stain resistance
- Low dirt adhesion

Curing Solution

SAE International

Base

Activator

Airbus

Components



Specifications



Qualified Product List

Surface Preparation/



Surface Conditions

Cleaning



- Aerobase Special Effects is compatible with and applied on top of Aerobase.

- Observe the recoat times of the previous layer of Aerobase.

- Apply Aerobase base color on clean primer, sealer or Aerobase layer. Remove oil,

check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

- grease and other contamination prior to application. - Recondition aged primers or topcoats with grade P320 sanding paper or aluminum oxide
- non-woven abrasive pad to a uniform matt surface.
- Remove dust with clean tack rags just prior to application of Aerobase.

Instruction for Use



Spray Application (Mix Ratio)

	Volume	Weight
Aerobase Special Effects	5 parts	100 parts
Aerobase Curing Solution	1 parts	18 parts
Activator*	1 part	14 parts

* Activator options: Aerobase Standard Activator

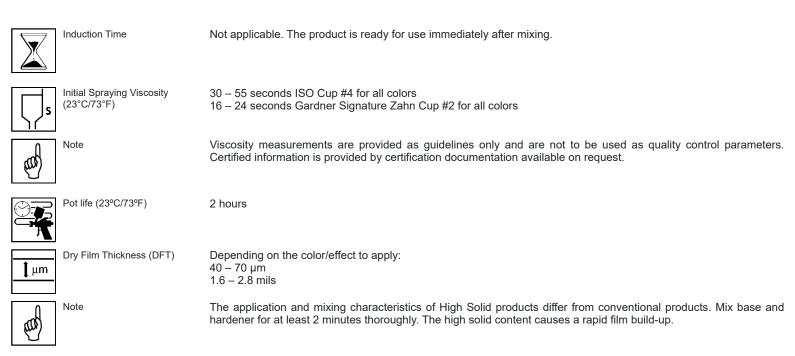
- Allow products to acclimatize to room temperature before use.

- Stir or shake Aerobase Special Effects thoroughly until all pigments are uniformly dispersed before adding the Aerobase Curing Solution.
- Add Aerobase Curing Solution and stir the catalyzed mixture thoroughly.
- Add Aerobase Standard Activator and stir the catalyzed mixture again thoroughly.

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AkzoNobel

Aerobase Special Effects



Application Recommendations

Conditions







Recommendation



Note

Application Scheme

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

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

Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *
Conventional	N/A	N/A	1.2 - 1.5mm	340 - 360mL/min¹	4 - 4.5 bar/58 - 65 psi²
HVLP / Next Generation	N/A	N/A	1.2 - 1.5mm	340 - 360mL/min¹	2 - 2.5 bar/29 - 36 psi³
Air Atomizing (electrostatic)	N/A	N/A	1.2 - 1.5mm	340 - 360mL/min	4 - 4.5 bar/58 - 65 psi²

1 Product Flow is not applicable when using gravity/suction feed guns.

2 Dynamic Air Pressure at the gun-inlet measured with an open trigger.

3 General advice to meet the HVLP / next-generation spray gun requirements.

Please validate with your local authorities.

All filters in the application equipment should be removed to avoid clogging. Depending on the type of special effect pigment used, the use of pressure atomizing spray equipment (airless or air assisted) is not advised. Please consult your AkzoNobel representative if you are not sure. Extra attention should be paid when cleaning the equipment.

Step 1: Aerobase (base color)

Observe the recoat limits of the relevant primer.

Apply a homogeneous and wet coat to achieve a dry film thickness of 30 to 50 µm / 1.2 to 2.0 mils depending on the color and effect. For more details check the technical data sheet of Aerobase.

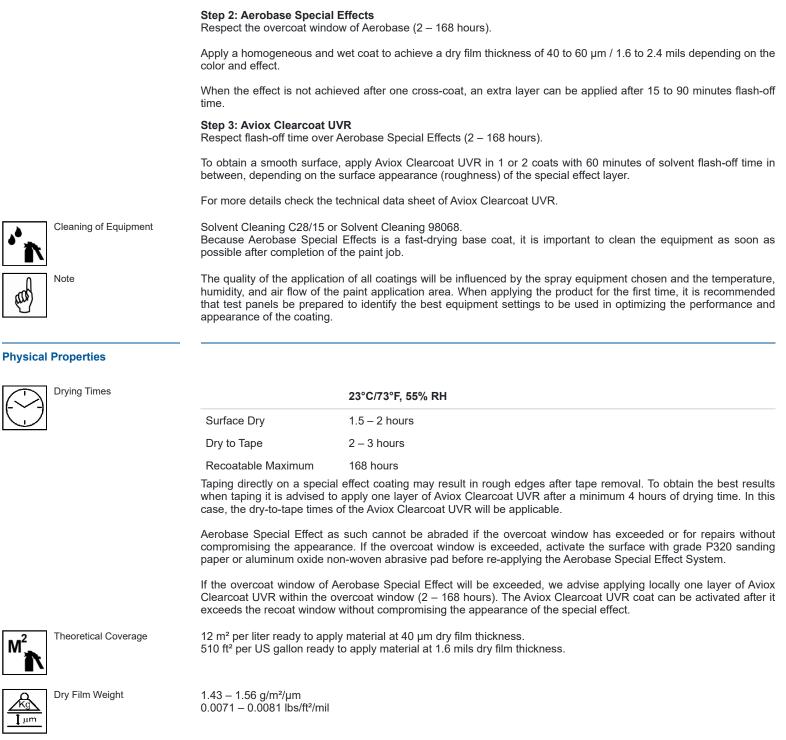
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Aerobase Special Effects



AkzoNobel

/OC

Volatile Organic Compounds

Maximum 420 g/l Maximum 3.5 lbs/gal



Not applicable.

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Aerobase Special Effects

3	Color	Any special effect color for any aircraft livery		
۲	Flash Point	Aerobase Special Effects Aerobase Curing Solution Aerobase Standard Activator	>21°C /70°F >21°C /70°F >21°C /70°F	
	Shelf life 5 - 35°C (41 - 95°F)	Aerobase Special Effects Aerobase Curing Solution Aerobase Standard Activator	18 months 24 months 24 months	
Safety F	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