## 463-3-8

#### **Technical Data Sheet**

#### **Product Group**

### **Epoxy Top Coat**

#### Characteristics



# **Product Information**

- Chemically cured two-component epoxy topcoat

- Exhibits high thermal emittance and low outgassing results when exposed to space environments.

463-3-8

CA-118

TL-29

- For most satisfactory adhesion, 463-3-8 should be applied over 10P4-2NF primed surfaces.

- Primed surface should be coated within 2-48 hours. If the primed surface has dried longer

than 48 hours, the surface should be lightly sanded with #400 grit or equivalent sandpaper, followed by a solvent wash using a clean cotton cloth dampened with MEK prior to topcoat.

- Commonly used as the protective coating for spacecraft and spacecraft hardware.

- Approved for use by NASA (Spec. 10M01831) and major government subcontractors.

- For use over anodized or conversion coated aluminum surfaces. Can also be used on chemically cleaned copper and grit blasted steel or passivated stainless steel surfaces.

Com	pon	ents
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**Specifications** 





Thinner

Lockheed Martin Aeronautic	LMS 70460
USAFMIS	MIS-34328

- Surface pretreatment is an essential part of the painting process.

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

**Qualified Product List** 

#### Instruction for Use

## Spray Application (Mix Ratio)

	Volume
463-3-8	3 parts
CA-118	1 part
TL-29	See Remarks part

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.

- Stir the catalyzed mixture thoroughly.

14 – 18 seconds Zahn Cup #2 Signature series

- Thinner TL-29: 25% max. of total, to desired spraying viscosity.



60 minutes.

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

Induction Time

Note

12 - 14 seconds ISO Cup #4





Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.



8 hours.

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# 463-3-8

μm

1.3-1.8 mils / 33-46 µm (Specifications HMS, LMS, and MIS). 1.5-2.5 mils / 38-64 µm (Specification SBRC).

#### **Application Recommendations**

Note

Equipment Recommendation

Dry Film Thickness (DFT)

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

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Spray apply a single uniform wet tack coat. Allow to flash for 10 minutes followed by a uniform wet cross coat to a

dry film thickness of 1.3-1.8 mils. For specification SBRC 150063 the dry film thickness requirement is 1.5-2.5 mils.



Any standard suction or pressure spray equipment. Satisfactory atomization is easily accomplished at a line pressure of 40-45 psi on a suction gun, or a line pressure of 35-45 psi on a pressure pot gun with 6-9 psi fluid line pressure.

Number of Coats

Cleaning of Equipment

Use TL-29 or MEK immediately after use.

A third coat may be required to achieve this film thickness.

#### **Physical Properties**

	Drying Times	Dry to handle Dry to water & fluid Resistance	4 ± 2 hours at 24 ± 1 hour @ 6 12 ± 1 hour @ 9 2 ± ½ hour @ 2	65-75°F (18-24°C) 55-75°F (18-24°C) 0-100°F (32-38°C) 295-305°F (146-152°C)
M <sup>2</sup>	Theoretical Coverage	12.46 m² per liter ready to apply at 25 μm dry film thickness. 508 ft² per US gallon ready to apply at 1 mil dry film thickness.		
	Flash Point	463-3-8		-4°C / 25°F
		CA-118		-5°C / 23°F
		TL-29		-4°C / 25°F
$\bigcirc$	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 -	463-3-8		24 months
	1001)	CA-118		24 months
		TL-29		24 months
Safety Precautions		Comply with all local safety, and label of the individual pi	, disposal and tra roducts carefully	ansportation regulations. Check the Material Safety Data Sheet (MSDS) before using the products. The MSDS's are available on request.

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#### Revision date: May 2025 (supersedes January 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