TOPCOAT FR2-55 FLEX

FIRE RETARDANT FINISHES FOR CABIN INTERIORS

AkzoNobel

Product information

Three-component water-based flexible polyurethane topcoat for aircraft interiors.

Components

Base FR2-55 Flex
Hardener / Catalyst FR2-55/A
Thinner Water

Specifications

Meets the following requirements:
JAR/FAR part 25 25.853 (a), (c/d) Change 14/ Amdt. 25-83

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
9 m²/kg (510 ft²/gal) for 40 µm (1.6 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT
1.8

VOC
70 g/l or 0.59 lb/gal (ISO 11890-1) and 145 g/l or 1.21 lb/gal (ASTM D3960)

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

GLOSS LEVEL
4-8 GU at 60° for the mat version, 10-30GU at 60° for semi-gloss version.

NOTES
Gloss levels have been determined using glossmeter with an angle of incidence of 60°. The theorical consumption value doesn't take into account the transfer efficiency for spray application

Surface preparation

All recommendations mentioned above are given for information.

MAPAERO SAS - 10, avenue de la Rijole - CS30098 - 09103 PAMIERS CEDEX - Tel : 33(0)5 34 01 34 01 - Fax : 33(0)5 61 60 23 30
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Instructions for use

SPRAY APPLICATION

MIXING RATIO

	Mixing ratio by weight	Mixing ratio by volume
Base	100	4 V
Hardener / Catalyst	20	1 V
Water	15 to 25	0.8 V to 1.4 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 mixture by weight is recommended.
Mix the base and the hardener until the mixture is homogeneous. Then add water and mix.
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

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.

POT LIFE
1 hour

NOTE

Dilution rate by weight	ISO 6
20%	20s ± 5s

Water based paints show a thixotropic behaviour. This implies that efflux time can vary according different parameters such as: type of mixing, mixing quantity, dilution, temperature, time between mixing and viscosity measurement

Application recommendations

CONDITIONS
Temperature 15°C to 35°C (60°F to 95°F)
Relative humidity 20 % to 80 %

EQUIPMENT
Spray gun Nozzle 1.8 to 2.2 mm

DRY / WET FILM THICKNESS
30 µm to 60 µm (1.2 mils to 2.4 mils) dry / 75 to 150µm (2.95-5.9 mils) wet

NUMBER OF COATS
For a smooth surface:
Apply 1 or 2 crossed coats.

For textured surface:
Dilute the first coat at 25%, wait for 30 minutes until the film becomes semi-gloss.
– Fine texture:decrease the air pressure of 1.5 to 2 bars (21.75 to 29 psi) and apply at 50 cm from the bracket.
– Coarse texture: Decrease the air pressure of 1.0 to 1.5 bars (15 to 22 psi) and apply at 20 cm from the bracket.

EQUIPMENT CLEANING
Clean the equipment with an appropriate cleaning thinner, such as Mapaero D770-B.

NOTE
Spray with dry and oil-free air.

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Drying times

	23°C (73°F)	60°C (140°F)
Dust free	30 minutes	N.A.*
Dry to handle	2 hours to 3 hours	30 minutes
Fully Cured	7 days	6 hours

NOTE
Drying times have been determined using tests pieces of a thickness < 2mm for 45 µm (1.8mils) of dry film.
IMPORTANT: Let it flash off 1 hour at room temperature before drying at 60°C (140°F).

* NA: 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

Packing

The base is available in 1kg and 5kg.
The hardener is available in 1kg and 5kg.

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