

22/23 Series Technical Data Sheet

Product Group

Epoxy topcoat

Characteristics



Product
Information

The 22/23 Series product is a chemically cured two-component epoxy topcoat designed to provide maximum protection from various chemicals, hydraulic fluids, aviation fuels, phosphate ester (Skydrol®) fluids and corrosion causing media. This high solids technology meets VOC requirements of SCAQMD Rule 1124.

Components



Base material	22/23 Series Base
Curing Solution	Gloss Curing Solution X-530 Semi-gloss Curing Solution EC-263 Flat Curing Solution EC-264

Specifications



Qualified
Product List

Boeing	BMS 10-11, Ty II, CI B, Gr D
EADS (CASA)	Z-12.361/BMS 10-11, Ty II, CI B
Goodrich	EMS 93284 C CI A (AiResearch Los Angeles Div.) (22 series / color specific)

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



Cleaning

- Surface pretreatment is an essential part of the painting process.
- Follow the specification requirements for cleaning and pretreatment application.

22/23 Series High Solids Epoxy Topcoat

Instruction for Use



Mixing Ratio
(volume)

Gloss

Base 446-22 Series	3 parts
Curing Solution X-530	1 part

Semi-gloss

Base 456-23 Series	1 part
Curing Solution EC-263	1 part

Flat

Base 466-23 Series	1 part
Curing Solution EC-264	1 part

- Stir or Shake base component until all pigment is uniformly dispersed.
- Once added, Stir the catalyzed mixture again thoroughly



Note

EC-264 requires stirring or agitation itself BEFORE mixing with the base component (due to its composition) in order to achieve a homogenous consistency of dispersion.



Induction Time

15 minutes.



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

15 – 25 seconds Gardner Signature Zahn-Cup 2
17 - 35 seconds Zahn-Cup 2
22 – 38 seconds ISO-Cup 4
22 ± 6 seconds Ford -Cup 4



Note

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.

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Pot life
(25°C/77°F) 4 Hours



Dry Film
Thickness
(DFT) 25 – 37 μm
1.0 – 1.5 mils

Application Recommendations



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



Note
22/23 Series 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.



Recommended
Equipment
Airless 279 mm 0.011 inch 60° angle
.330 mm 0.013 inch 80° angle
Air Fluid tip 1.4 mm (0.055 inch)
Atomizing air pressure 45-65 psi
Fluid pressure 6-8 psi

*) measured with open trigger

**) measured at the air-cap. General advice to meet the HVLP / next generation spray gun requirements. Please validate with your local authorities.



Number of
Coats
Spray a single wet coat. Allow a 15 minute solvent flash and apply a second wet coat.

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Cleaning of
Equipment

Use TR-19 or MEK.



Note

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 to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.

Physical Properties



Drying Times
(25°C / 77°F,
55% RH)

Dust Free	30 minutes
Tack Free	3 hours
Dry Through	6 hours



Theoretical
Coverage

250-400 ft²/gal based on 50% transfer efficiency.
6-10 m²/l based on 50% transfer efficiency.



Dry Film Weight

3.5 lbs/gal (420 g/l) max. per US calculations.



Volatile Organic
Compounds

Maximum 420 g/l
Maximum 3.5 lbs/gal



Gloss (60°)

446-22 Series	90 gloss units minimum
456-23 Series	20-40 gloss units
466-23 Series	14 gloss units maximum



Color

As Required.

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Flash-point

See MSDS for specific component flash-point.



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 container label for specific storage life information.

Shelf life

5 - 38°C

(41 - 100°F)

12 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information

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.

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