

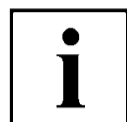
422X Series

Technical Data Sheet

Product Group

Epoxy Top Coat

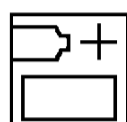
Characteristics



Product Information

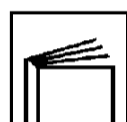
A two-component, chemically cured epoxy topcoat designed to provide chemical resistance coupled with sufficient flexibility to minimize chipping and flaking. This epoxy topcoat can be used with various primers. Normally military specification primers MIL-P-85582, MIL-PRF-23377 or MIL-P-53022 are recommended.

Components



Base	422X Series
Curing Solution	Curing Solution 0200T126
Curing Solution	Curing Solution 0200T129
Curing Solution	Curing Solution 0200T126C

Specifications



Qualified Product List

Air France	SMI 70 043
US Military	MIL-PRF-22750, TYII CLH GRA

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.

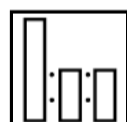
Surface Conditions



Surface Preparation/
Cleaning

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

Instruction for Use



Spray Application

	Volume
422X Series	3 parts
Curing Solution 0200T126	1 part
Curing Solution 0200T129	1 part
Curing Solution 0200T126C	1 part


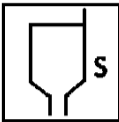



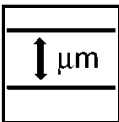
Gloss Curing Solution: 0200T129
Semi-gloss and Flat Curing Solution: 0200T126 & 0200T126C

	Gloss
3 parts	Base 422X Series
1 part	Curing Solution 0200T129
	Semi-gloss and Flat
3 parts	Base 422X Series
1 part	Curing Solution 0200T126 / 0200T126C





- Allow products to acclimatize to room temperature before use.
- Stir or shake the base component until all pigment is uniformly dispersed before adding the curing solution.
- Add the curing solution and stir the catalyzed mixture thoroughly.

With regards to the curing solution, C version means that it is compliant to the MIL spec requirement for HAPS content. The non C version meets the performance requirements for the MIL spec.


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	Induction Time	30 minutes.
	Initial Spraying Viscosity (s)	(25°C/77°F) 50 seconds maximum (#4 Ford) admixed 75 seconds maximum (#4 Ford) at pot life
	Note	The uses of Ford Cups for viscosity are requirements of the referenced specifications, and provided only as a reference for field application. They are not provided as quality control values. Actual values will vary when tested outside of standard conditions (25°C/77°F).
	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.
	Pot life (25°C/77°F)	4 hours
	Dry Film Thickness (DFT)	46 – 56 µm 1.8 – 2.2 mils

Application Recommendations

	Conditions	Temperature: 15 – 35 °C 59 – 95 °F												
		Relative Humidity: 35 – 75 %												
	Note	The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and airflow 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 the appearance of the coating.												
	Equipment Recommendation	<table border="1"> <thead> <tr> <th>Spray gun type</th> <th>Product supply</th> <th>Fluid Pressure</th> <th>Nozzle orifice</th> <th>Product flow</th> <th>Dynamic air pressure at gun-inlet *</th> </tr> </thead> <tbody> <tr> <td colspan="6">Standard suction, pressure, HVLP or airless spray.</td> </tr> </tbody> </table>	Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *	Standard suction, pressure, HVLP or airless spray.					
Spray gun type	Product supply	Fluid Pressure	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet *									
Standard suction, pressure, HVLP or airless spray.														
	Cleaning of Equipment	Use TR-19 for cleanup. This balanced thinner will minimize the possibility of residue remaining on the equipment.												

Physical Properties

	Drying Times	25°C/77°F, 55% RH
	Dry to Touch	3 hours
	Dry to Tape	8 hours
	Full Cure	14 days
	Accelerated Cure:	
	Dry to tape/handle:	2-hour flash off at ambient, then 20 – 30 minutes at 140°F (60°C).

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	Note	<p>Full Cure: 24-hour flash off at ambient, then 24 hours @ 150°F (65.5°C).</p> <p>CAUTION: The accelerated cure for dry to tape/handle may cause a slight variation to color and/or gloss in some topcoats. Light colors, e.g. white and off white, in the semi-gloss range could be affected.</p> <p>The cure required will vary due to the efficiency of the oven being used (evacuating the solvent heavy air) and the amount of air movement in the oven. The customer should run tests to verify the required cure schedule.</p>								
	Theoretical Coverage	<p>20.3 – 22.1 m² per liter ready to apply at 25 µm dry film thickness. 825 – 900 ft² per US gallon ready to apply at 1 mil dry film thickness.</p>								
	Dry Film Weight	<p>Gloss 39.3 ± 3.0 g/m²/25 µm 0.0080 ± 0.0008 lbs/ft²/mil</p> <p>Semi-Gloss and Flat 46.3 ± 3.0 g/m²/25 µm 0.0094 ± 0.0008 lbs/ft²/mil</p>								
	Volatile Organic Compounds	<p>Max 340 g/l Max. 2.8 lbs/gal</p>								
	Color	<p>As required: 595-16492 595-17178 595-36231 595-37038 595-17925</p>								
	Flash Point	<table border="0"> <tr> <td>422X Series</td> <td>-4°C / 25°F</td> </tr> <tr> <td>Curing Solution 0200T126</td> <td>27°C / 80°F</td> </tr> <tr> <td>Curing Solution 0200T129</td> <td>36°C / 97°F</td> </tr> <tr> <td>Curing Solution 0200T126C</td> <td>29°C / 84°F</td> </tr> </table>	422X Series	-4°C / 25°F	Curing Solution 0200T126	27°C / 80°F	Curing Solution 0200T129	36°C / 97°F	Curing Solution 0200T126C	29°C / 84°F
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	Storage	<p>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.</p>								
Shelf life	Curing Solution 0200T126									
Shelf life 5 - 38°C (41 - 100°F)	<table border="0"> <tr> <td>422X Series</td> <td>24 months</td> </tr> <tr> <td>Curing Solution 0200T129</td> <td>24 months</td> </tr> <tr> <td>Curing Solution 0200T126C</td> <td>24 months</td> </tr> </table>	422X Series	24 months	Curing Solution 0200T129	24 months	Curing Solution 0200T126C	24 months			
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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.

Revision date: February 2024 (supersedes August 2016) - 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

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