



AXON PRODUCTS

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AEROSPACE TECHNICAL DATA

PG-6 SERIES / PH-34 HIGH SOLIDS GLOSS POLYURETHANE TOPCOATS

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PRODUCT DESCRIPTION:

This coating series covers High Solid Polyurethane topcoats with low VOC and is designed for use on aircraft and other equipment requiring chemical resistance and color retention. When fully cured these coatings exhibit skydrol and mar resistance and meet the most demanding aerospace specifications for chemical resistance, hardness, flexibility, color and gloss retention. Also showing excellent DOI (distinctness of image appearance).

MEETS OR EXCEEDS THE PERFORMANCE REQUIREMENTS OF THE FOLLOWING SPECIFICATIONS:

Boeing BMS 10-60 Type I and II, Class B, Grade D / Boeing BMS 10-72, Type IX / Boeing DMS 2112 / Bombardier BAMS 565-009 Type II, Class A, Grade B / Lockheed Process 302 Standard / Embraer MEP 10-069 / Boeing DPM 6596 / SAE AMS 3095 / Saab 51-33-00 / Airbus AIMS 04-04-013 / Northrop Grumman GP110AEE.

SURFACE PREPARATION:

Surfaces to be painted should be cleaned with mild alkaline cleaner and then solvent wiped to remove any residue on the surface. Then the area should be lightly abraded with scotch brite and sanding residue removed with a tack cloth. Prime with EP-2 series High Solids Primer or EP-1 series Conventional Primer.

(See Process Standard for Exterior Decorative Paint System)

MIXING / APPLICATION:

Shake or stir color base component well. To one part of PG-6 series base, slowly pour one part of PH-34 catalyst (all mixing is by volume). Agitate to insure complete mixing. Allow to stand 15 minutes prior to application. Pot life is four hours *. Spray apply in wet uniform coats to a recommended dry film thickness of 1.5 to 2.5 mils using siphon cups, pressure pot, electrostatic, air assisted airless, or HVLP spray equipment.

Coating will dry to touch in 3-4 hours and dry to tape in 7-9 hours at 77°F. Full properties are achieved after seven days cure. Reduce 5-15% by volume with SR-420 as needed to maintain VOC compliance, SR-12 or SR-15. This will provide a smooth film appearance.

***For best results, use this product within 2 hours.**

PHYSICAL PROPERTIES:

Appearance:	Gloss, various colors
Gloss:	>90 @ 60°
Admixed Solids by Weight:	65 - 75 theoretical, depending on color
Admixed Solids by Volume:	52 - 55 theoretical, depending on color
Coverage:	600 - 800 sq. ft/mil/gallon @ 100% transfer depending on color
Admixed Viscosity:	16 - 18 seconds, #2 Zahn
Pot Life:	*4 hours @ 77°F Can be accelerated by the use of AX-17 Accelerator.
Dry to Tape:	*7 - 9 hours @ 77°F, 50% R H Can be accelerated by the use of AX-17 Accelerator.
Shelf Life:	2 years from date of manufacture
Storage Temperature:	40 - 95° F (4 - 35° C)

PRECAUTIONS:

Use with adequate ventilation and proper respiratory protection. See MSDS for complete details of composition and precautions.