

## TECHNICAL DATA

**TG-1 SERIES / PH-25  
HIGH SOLIDS, PTFE FILLED,  
ABRASION RESISTANT POLYURETHANE GLOSS TOPCOAT**

July 2010

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**PRODUCT DESCRIPTION:**

This series of polyurethane based PTFE filled enamels are low VOC highly abrasion resistant products for aircraft leading edges, wing flaps, etc. Fully cured films have skydrol resistance and result in very hard and durable films. This series combines good gloss (above 80°) with exceptional abrasion resistance as evidenced by superlative Taber Abrasion test results.

**MEETS OR EXCEEDS THE PERFORMANCE REQUIREMENTS OF SPECIFICATION:**

Bombardier BAMS 565-05 Type II / Boeing BMS 10-86 H, Type III, Grade D

**SURFACE PREPARATION:**

Apply to cleaned, treated aluminum alloy surfaces which have been primed with epoxy primers, BMS 10-11, Type I and BMS 10-79, Type III.

**MIXING / APPLICATION:**

Shake color component well before using. Mix 3 parts TG-1 product with 1 part PH-25 by volume, blending thoroughly. Spray apply in wet, uniform cross coats to a total dry film thickness of 5-10 mils. Can be sprayed by siphon, pressure, air assisted airless, HVLP or electro statically. For flame retardant, add 7.5% by weight of AX-32 or 8 ounces by volume of AX-32 per admixed gallon of TG-1/PH-25. These products will dry dust free in less than 90 minutes and will be tack free in 3 hours. Admixed VOC is under 420 grams/liter.

**PHYSICAL PROPERTIES:**

|                             |  |
|-----------------------------|--|
| Appearance:                 | Various Colors   |
| Gloss:                      | 80 - 90 @ 60°  |
| Admixed Solids by Weight:   | 58 - 70% theoretical, depending on color               |
| Admixed Solids by Volume:   | 45 - 55% theoretical, depending on color               |
| Coverage:                   | 700 - 900 sq. ft/mil/gallon @ 100% transfer efficiency |
| Admixed Viscosity, initial: | 18 - 20 seconds, #4 Ford                               |
| Viscosity, 3 Hour Pot Life: | Under 45 seconds, #4 Ford                              |
| Dry Times:                  | A) Dust free: < 1.5 hours                              |
|                             | B) Tack Free: < 3.25 hours                             |
|                             | C) Dry Through: < 5.25 hours                           |
| Volatile Organic Content:   | Under 420 g/L  |
| Shelf Life:                 | 1 year from date of manufacture                        |

**PRECAUTIONS:**

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