

Technical Data

Product Name PAC33CF (4360/3031) Beige, (4360/2015) Grey

<u>Product Description</u> PAC33CF chromate-free polyurethane primer 4360/3031

Key Features PAC33CF is a two-component, ambient curing,

polyurethane primer, characterized by high chemical resistance and flexibility, and is designed to be used over PAC99 etch primer for the exterior finishing of civil

aircraft.

Specifications – Approval

<u>Specifications – Performance</u> When used over wash primer P99, TN A.007.10113, AIMS

04.04.012 and AMS3095

<u>Catalyst/Hardener/Activator</u> 0736/9000 <u>Thinner/Reducer</u> 0433/9000

Pack Size

Mix Ratio 5:1:4-5 by volume

Recommended Schemes When used over wash primer P99, PAC33CF and under

CA8000 or CA40000 meets the performance requirements of TN A.007.10113 and AIMS 04-04-012

Product Application Parameters

Surface Preparation Ensure that the correct surface pre-treatment has been

carried out and that drying and overcoat times within the

process are strictly adhered to.

Preparation Ensure the surface is clean and sound and free from any

contaminants and that temperature and humidity are

within specified process limits.

Mixing Hand stir or mechanically agitate base material until all

pigment is uniformly dispersed. Add one volume of 0736/9000 to five volumes of base, mix thoroughly and thin to viscosity using approximately 4 to 5 volumes of

thinner 0433/9000.

Viscosity AFNOR2.5 45 – 55 seconds

BSB4 18 – 20 seconds
DIN4 13 – 14 seconds
ISO 3 39 – 54 seconds

Induction Time none required

Pot Life 4 hours

Application Method Apply one wet even coat with 50% overlap from each

stroke or a double track or cross coat to achieve a dry

film thickness of 15 - 25µm

Conditions Temperature 15 – 35°C

Humidity 35 - 70%



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Application Equipment

PAC33CF is compatible with all types of spray equipment. For further information, please consult the relevant Scheme Sheets.

Equipement	Tip size	Flow rate	Air Pressure (Bar)
	\emptyset = 0.28 mm - Angle 60°	320 – 360	50 – 60
Airmix Kremlin	Ref: 06.134	ml/min	bars
HVLP	1,2 mm		1,5 - 2 bars
Conventional Air Spray	1,5 mm		3 – 4 bars
Airless	Not recommended		
Airless Air assisted	609 – 611	360 ml / min	50 - 60 bars
PRO 3500 or Pro XS4	1,2 ou 1,5 mm	360 ml / min	5 - 6 bars

Equipment Cleaning Dry Film Thickness

Cleaners CN20 or CN44 are recommended

 $15 - 25 \mu m$

Drying Times at 23°C 50% RH

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	Dust Free	30 – 40 minutes			
	Dry To Tape	2 – 3 hours			
	Re-coat with self	0.5 – 72 hours			
	Dry to Overcoat	1 – 72 hours			
	Full Cure	7 days			

Flash Off Time Not applicable

Physical Characteristics

Colour Beige or grey

Gloss -

Coverage 15m²/litre @ 20 microns

Dry Film Density

VOC Content 600g/litre

(Ready for use)

Flash Points 4360/3031 (Base) 5°C

0736/9000 (Activator) 40°C 0433/9000 (Thinner) 18°C

Shelf Life 24 months from date of manufacture.

Storage Conditions 5-35°C in the original unopened containers. Partly used containers must

be resealed immediately after use. Once opened, activator 0736/9000

must be resealed immediately.

Health & Safety

This product is safe to use and apply when recommended precautions are observed. Before using this product it is important to read and understand the Material Safety Data Sheet. This provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. Material Safety Data Sheets are available on request.

All recommendations, statements and technical data contained herein are based on tests we reasonably believe to be reliable and correct, but the accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express or implied. The User shall rely on its own information and tests to determine the suitability of any product for its intended use and the User agrees to assume all risks and liability arising in relation to its use of such product (other than death or injury resulting from our negligence) and accordingly we shall not assume any such risks or liability unless we specifically agree to the contrary in writing. If we specifically agree to assume any such risks or liability then (except for death or injury resulting from our negligence) our sole responsibility if any product supplied to the User by us is defective shall be to replace that portion of such product which is defective. Recommendations or statements other than those specifically agreed in writing by us shall not be legally binding on us.

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