



# Product Data

## Aquathane 2K Acrylic Polyurethane (HAPS Free) ACAU Series (3:1)

**Description:** **Aquathane**, patent pending, is a high performance, 2 (two) component water-borne acrylic polyurethane formulated for use on aircraft. This environmentally friendly, low VOC and HAPS free coating is lead and chromate free, yet exhibits exceptional depth of image, abrasion, solvent and chemical resistance including Skydrol™ while maintaining hardness and flexibility. It also offers good buffing characteristics and has remarkable adhesion to aluminum and galvanized metals - both electroplated and hot-dipped. Required film build is easily achieved without foaming or flow problems.

**Recommended Uses:** A superior finishing system for protection on aircraft and aircraft components in environments where outstanding gloss and gloss retention are primary requirements.

### PHYSICAL CONSTANTS

*(Subject to normal manufacturing tolerances)*

**Finish:** High Gloss, Semi-Gloss, Flat (less than 5% gloss)

**Color / Shade:** Various

**Components:** 2 (two)

**Mixing Ratio:** 3:1 Base to Activator

**Volume Solids:** 49% / US Gallon **mixed** (depending on color)

**Dry Time @77° F. and 55% RH:**

To Touch	Tack Free	Dry Hard	Fully Cured
2-3 hours *	5-6 hours *	Overnight *	7 days *

\* Dry times may be significantly reduced with the utilization of plural component equipment and/or the reduction of the pot life.

**Theoretical Coverage:** 393 sq. ft. / US gallon @ 2.0 mils DFT (no loss)

**Recommended DFT:** 1.8 - 2.2 mils or according to specification

**Shelf Life:** 12 months when stored indoors @ 75° F. (24° C.)

**Storage Temp:** 45° - 110° F. (7° - 43° C.)

**Clean Up:** Water

**VOC:** 0.35 lbs. / US gallon **mixed** (depending on color)

**Viscosity:** 108 ku

**POT LIFE:** 4 hours @ 70° - 80° F. @ 50% R.H.



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**Surface Preparation:** It is extremely important that the surface has been coated with an approved primer that is compatible. If the primer is not compatible, it may cause poor intercoat adhesion resulting in a failure. Thorough surface preparation and cleaning is extremely important to obtain a high gloss and smooth surface. If the surface shows any defects such as overspray or particles, sand with 220, 240 or 320 grit sandpaper to remove particles. The final sand should be with 320. After sanding, air-blow the entire aircraft and lightly wipe with a mild solvent to remove dust. **CAUTION:** Soaked rags may cause rag marks in the coating. Air-blow surface again and follow by wiping with a dry, lint-free cloth.

**Application Conditions:** The surface must be dry at the time of application and the temperature must be above the dew point to avoid condensation. The optimum application conditions are between 60° - 80° F. and relative humidity below 70%. DO NOT exceed 6 (six) wet mils per coat.

**Application Equipment:** Compatible with all types of spray equipment.

**Mixing Instructions:** **WARNING ▶▶▶ DO NOT AGITATE - HAND STIR ONLY** each component thoroughly making sure no pigment remains of the bottom of can and color is uniform. Mix Part B with Part A. Stir thoroughly. **DO NOT add water for thinning to the empty container of Part B due to a catalytic reaction!** Allow a sweat-in period of 30 minutes prior to spraying. Do not mix more material than will be used with the pot life time, approx. 4 hours. Mixing a partial kit is not recommended.

**Thinning:** Water - **DO NOT** EXCEED 8% for even flow.

**Compatibility:** If unsure about the compatibility of this product with other commodities, please contact an Excalibur technical service representative at 877-392-2542.

### PRECAUTIONS

\*\*\*\*\* SAFETY \*\*\*\*\* Packings are provided with applicable safety labels which should be observed. In addition, national and local regulations should be followed.

As a general rule, inhalation of solvent vapors or paint mist and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory skin and eye protection are always recommended when painting. See complete Material & Safety Data Sheets for detailed health hazards and safety information.

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