Aerowave 2002

Technical Data Sheet

Product Group

Epoxy Primers.

Characteristics

- Water based technology
- Compatible with all products out of the Aerowave Series
- Designed for optimal mixing properties for both manual and plural mixing application
- For application on composite substrates
- Low VOC emission
- Low dry-film-weight (DFW); reduce operational costs
- Resistance to aircraft hydraulic fluids and chemicals

Aerowave 2002 is a product part of the Aerowave Series which utilizes the latest water based technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components

- Curing Solution 6005

Specifications

- Airbus: AIMS 04.04.002/035/045
- Eurofighter: SP-J-513-A-0013, Type III, Class A
- Bombardier: BAMS 565-014 Rev. NC Grade B
- Embraer: MEP-10-118

For most recent up-date or missing specifications please check the qualified product list (QPL) on www.akzonobel.com/aerospace

Surface Conditions

- Assure that release agents are removed from the composite substrate prior to further surface pretreatments.
- Sand the composite substrate to a uniform matt surface and blow the panels dust free using compressed air.
- Degrease the surface using the wipe on – wipe off method using a non-aggressive cleaner, e.g. water or iso-propyl alcohol (IPA).
- When forced curing is applied to composite substrate, it is strongly advised to de-gas the substrate in an oven prior to primer application.
- Remove dust with e.g. tack rags just prior to application of the primer.
Aerowave 2002

Instruction for Use

Mixing Ratio (volume)

<table>
<thead>
<tr>
<th></th>
<th>Volume (v/v)</th>
<th>Weight (w/w) (&lt;1L)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aerowave 2002</td>
<td>3 parts</td>
<td>100 parts</td>
</tr>
<tr>
<td>Curing Solution 6005</td>
<td>1 part</td>
<td>28 parts</td>
</tr>
</tbody>
</table>

- **When mixing <1L dose by weight.**
- Allow products to acclimatize to room temperature before use.
- Homogenize Aerowave 2002 till all pigment is uniformly dispersed before adding the hardener
- Add Curing Solution 6005 and stir the catalyzed mixture thoroughly for at least 60 seconds. Automated dispensing units in combination with plural mixing devises can be applied for Aerowave 2002.

Induction Time

Not applicable. The product can be used directly after mixing.

Initial Spraying Viscosity (21°C/70°F)

- 35 – 65 seconds ISO Cup #4.
- 17 – 30 seconds Gardner Signature Zahn Cup #2.

**Note:** Stir or shake the mixed components thoroughly shortly before measuring the viscosity.

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

- 21°C / 70°F – 4 hours
- 30°C / 86°F – 3 hours

Dry Film Thickness (DFT)

- 15 – 25 µm
- 0.6 – 1.0 mil

**Note:** The end of Pot Life is not visible by means of viscosity increase. Respect described Pot Life. Pot Life relates to temperature.
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Application Recommendations

**Conditions**

Temperature: 15 – 35°C

59 – 95°F

Relative Humidity: 25 – 80%

Aerowave 2002 may be applied in conditions outside of the limits shown above. Care must be exercised to ensure a satisfactory result. Please contact your local AkzoNobel Aerospace Coatings representative to determine the proper application techniques when environmental conditions fall outside of the recommended range.

**Equipment**

Air 1.2 – 1.6 mm nozzle orifice

HVLP 1.2 – 1.6 mm nozzle orifice

Air Electrostatic* 1.2 – 1.5 mm nozzle orifice

Airless/Air Assist .009 - .013 inch, angle 40° – 60°

*) Use Electrostatic spray equipment designed for application of water based products.

To avoid contamination of water based – solvent based coating products it is advised to use dedicated water- / solvent-based spray equipment. For application of water based products use non corrosive spray equipment (e.g. stainless steel).

**Number of Coats**

Spray-apply a homogeneous, wet and closed coat.

**Cleaning of Equipment**

Clean the equipment with water directly after use. If necessary, semi-cured material remaining on the equipment can be cleaned with Solvent Cleaning C28/15 or Solvent Cleaning 98068.

The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow 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 appearance of the coating.
### Aerowave 2002

### Physical Properties

<table>
<thead>
<tr>
<th>Drying Times</th>
<th>21°C/70°F -55%</th>
<th>60°C/140°F*</th>
<th>80°C/176°F*</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td>30 min.</td>
<td>15 min.</td>
<td>10 min.</td>
</tr>
<tr>
<td>Dry to handle</td>
<td>2 hours</td>
<td>n.a.</td>
<td>n.a.</td>
</tr>
<tr>
<td>Chemical resistant</td>
<td>48 hours</td>
<td>45 min.</td>
<td>30 min.</td>
</tr>
</tbody>
</table>

*) Substrate surface temperature

When forced cured; allow the paint a 5 minutes ambient flash-off time with sufficient air movement before entering the oven in order to obtain the best results.

Recoat minimum* When surface dry

Recoat maximum* 168 hours. If a drying time of 168 is exceeded recondition the surface with e.g. Scotch-Brite® type A very fine

*) In combination with Aerowave Series products. In combination with solvent based products the minimum recoat time is 8 hours and the maximal recoat time is 48 hours without reconditioning.

### Note

Curing of waterborne products depends on temperature, relative humidity and air flow. Increased temperatures, low RH and efficient airflow can decrease the drying times significantly.

### Theoretical Coverage

- 29 m² per liter base material at 15 µm dry film thickness
- 1163 ft² per US gallon base material at 0.60 mil dry film thickness

### Dry Film Weight

- 1.6 g/m²/µm
- 0.0083 lbs/ft²/mil

### Volatile Organic Compounds

- < 120 g/L (1.0 lb/gal) product ready to apply
- < 250 g/L (2.1 lb/gal) exempt water according to ASTM D-3960

### Gloss (60°)

- Maximum 20 GU.

### Color (visual match)

- Beige RAL 1014.
Aerowave 2002

Flash-point

Aerowave 2002  >21°C / 70°F
Curing Solution 6005  >21°C / 70°F

Storage

Store the product dry and at a temperature between 5 and 25°C / 41 and 77°F. Stored in the original unopened containers. Periodical short time exposure (max. 48 hrs at a time) to higher temperatures (max. 40°C / 104°F) will not negatively influence the shelf life of the products.

Shelf life

Aerowave 2002  12 months
Curing Solution 6005  12 months

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.

Issue date: December 2018 (supersedes February 2018) - 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 product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user’s responsibility to verify that this data sheet is current prior to using the product.

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