



Product Group

Composite Coatings / Primer Surfacer

Characteristics



Product Information

Aerowave® Filler 2501 is a low VOC, shrinkage free, 2-component stopper for several substrate types.

- Fast curing at ambient conditions
- Low VOC emission
- Compatible with a wide range of composite, plastic, metallic substrates and primers
- Does not shrink or swell during application and curing
- Remains flexible after curing
- Low odor level
- Low dry-film-weight (DFW); reduce operational costs

Aerowave® Filler is 2501 a product part of the Aerowave® Series which utilizes the latest resin technology and sets the standard for minimum process times, reduced process cycle costs and environmental care.

Components



Hardener
Thinner or
Activator

Curing Solution 6009

Specifications



Qualified
Product List

Ilyushin	I756.18.608
Eurocopter	LMP-DDLD-09-012, ECS-L-2047, ECS -L-2327
Gulfstream Aerospace	GMS 5008, GAR110VK
Irkut	741.140/21-00-00-0036-0T040-0, 741.140/21-00-00-0038-0T04/0A
Sukhoi	RRJ-0000-RE-314-14

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



Surface Conditions



Cleaning

- Aerowave® Filler 2501 can be applied directly on composite substrate or primer.
- If applied over metallic substrates, assure the metallic substrate is primed with the applicable primer.
- Aerowave Filler 2501 is compatible with most commonly used primers, e.g.:
Aerowave 2002
Aerodur Barrier Primer 37045
Aviox CF Primer 37124
- Assure that release agents are removed from the composite substrate prior to further surface pretreatments.
- Sand composite panels to a uniform matt surface and blow panels dust free with pressured air.
- Degrease surface with the wipe-on-wipe-off method using a non-substrate aggressive cleaner.
- When forced curing is applied to composite substrate, it is strongly advised to de-gas the substrate in an oven prior to primer application.
- Clean aged primer and sand with Scotch-Brite® type A very fine to a uniform matt surface.
- Remove dust with e.g. tack rags just prior to application.

Instruction for Use



Mixing Ratio
(volume)

100 parts Aerowave® Filler 2501
100 parts Curing Solution 6009

- Allow products to acclimatize to room temperature before use.
- Mix the components thoroughly using e.g. a spatula until a homogeneous color is achieved.
- Mix enough volume you can process during the pot life cycle.



Induction Time

Not applicable. Products can be used directly after mixing.



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

Not applicable



Pot Life

30 min at 20°C / 68°F

Application Recommendations



Conditions

Temperature: 5 – 35°C
 41 – 95°F
Relative Humidity: 25 – 85%



Note

Aerowave® Filler 2501 may be applied in conditions outside of the the limits shown above. Care must be excercised 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

Filling knife / spatula



Number of Coats

Fill surface flaws, cracks and holes in one coat using the spatula. Aerowave® Filler 2501 does not shrink or swell.



Sanding

The stopper should be completely dry before sanding. The stopper must be sanded back to the substrate completely. Start sanding with grid P240 followed by P320 and end with P400 to obtain a smooth surface without sanding marks.



Cleaning of Equipment

Clean equipment with Solvent Cleaning C28/15 or Solvent Cleaning 98068. Clean equipment directly after use.



Note

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.

Physical Properties



Drying Times

21°C/70°F -55% 80°C/176°F

Dry to sand 45 – 90 minutes 10 minutes

The best overcoat results are obtained when the stopper is lightly sanded before over coating.

Recoatable minimum When dry-to-sand

Recoatable maximum 72 hours.

If a drying time of 72 is exceeded recondition the surface with e.g. Scotch-Brite® type A very fine

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



Note

Curing times depend on layer thickness. Due to the exothermic reaction low layer thicknesses will take longer to cure at ambient conditions.



Volatile Organic Compounds

Max. 50 g/L (0.4 lb/gal)



Color

Beige RAL 1019



Flash-point

Aerowave® Filler 2501	>21°C / 70°F
Curing Solution 6009	>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
(21°C/70°F and
55% RH)

Aerowave® Filler 2501	36 months
Curing Solution 6009	36 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' are available on request.

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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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