

Alumigrip 4602 Filler

Technical Data Sheet

Product Group

Corrosion Inhibiting Primer/ Filler

Characteristics



Product
Information

Alumigrip 4602 is our 2-component epoxy filler for several substrate types.

- Formulated to provide corrosion inhibition using chrome free inhibitors.
- Provides a durable smooth surface on composite and fiberglass surfaces, sandable filler for rivets, seam areas, and surface defects.
- Minimal shrinkage and/or swelling during application and curing process.
- Prepackaged in tube dispenser configuration.

Components



Base
Curing Solution

4602FL003

CS6101

Specifications



Qualified
Product List

Gulfstream

GMS 5007, TY NC1

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

Surface Conditions



Cleaning

Surface pretreatment is an essential part of the painting process.

- Light abrasion to composite substrates is recommended to enhance adhesion
- If applied over metallic substrate, assure that the metallic substrate is primed with the applicable primer.
- Alumigrip 4602 is compatible with most commonly used primers, e.g.:
 - Aerodur 2111 Chrome Free Primer 2111P001
 - Aerodur 2100 MgRP 2100P004
 - Alumigrip 10P8-11 VOC Compliant Epoxy Primer

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Instruction for Use



Mixing Ratio
(volume)

2 parts
1 parts

4602FL003
CS6101

Tubes are proportioned to be mixed at the head in the 2:1 ratio

Allow tubes to become acclimated to room temperature conditions before use



Induction Time

Not applicable. Products can be used directly after passage through “ribbon-like” applicator tip

Use MCH 10-24 11” length mixing nozzle



Pot life
(25°C/77°F)

3 hours



Dry Film
Thickness
(DFT)

25 – 125 micron (μm)

1.0 – 5.0 mils prior to sanding

Application Recommendations



Conditions

Temperature: 15 – 35°C
59 – 95°F
Relative Humidity: 35 – 75%



Equipment

Apply material directly from the tubes, using either a hand-powered (manual) applicator or a pneumatic air gun. Mixed material is to be spread over the primed surface with a trowel, filling knife, or similar device.

Use MCH 10-24 11” length mixing nozzle

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Note

Caution: Do not exceed 80 psi when using a pneumatic dispensing gun for application.

Caution: Hold dispensing gun in horizontal position when beginning to dispense material to prevent thinner activator from flowing out of mixing nozzle ahead of thicker base material.



Number of Coats

Fill rivets, seams, surface defects/flaws in one coat using a trowel or filling knife.



Cleaning of Equipment

Use MEK, MPK or equivalent solvent.

Physical Properties



Drying Times
(25 +/- 2°C / 77
+/- 2°F, 55 +/-
5% RH)

Dry-to-Sand	3 hours minimum
Dry Hard	16 hours maximum
Full cure	21 days

Curing of the Primer/Filler depends on the temperature, relative humidity, air flow, and film thickness.








Note: Primer/Filler may be force cured for 1 hour @ 120°F. The Dry-to-Sand time at this cure cycle is 1 hour minimum.



Theoretical Coverage

988 ft² per US gallon ready to apply at 1.0 mil dry film thickness
52 ft² per 200 ML kit at 1.0 mil dry film thickness

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	Dry Film Weight	2.20 g/m ² /micron 0.0100 lbs/ft ² at 1.0 mil
	Volatile Organic Compounds	Max 348 g/l Max 2.91 lb./gal
	Gloss (60°)	50 units maximum
	Color	Off White
	Flash-point	4602FL003 25°C / 77°F CS6101 32°C / 89.6°F
	Storage	Store the product dry and at a temperature between 5 and 27°C / 40 and 80°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.
Shelf life 5 - 27°C (40 - 80°F)		6 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.
	Note	Recommended storage for the cartridges is in a vertical orientation with the tips of the dispensers downward. The cartridges are packaged in this orientation, therefore leaving the cartridges in the box until use will provide the best results.

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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.

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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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