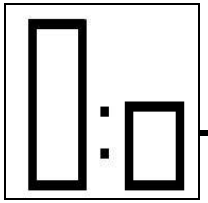
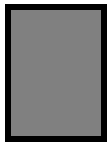
AkzoNobel
Aerospace Coatings

Aerodur® 5000 Military Aircraft Camouflage Topcoat

AkzoNobel





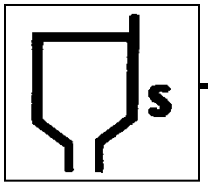
Base:
ECM-F-XXXX

3 parts

Curing Solution:
PC-404

1 part

At low temperatures, the cure rate may be accelerated by adding one fluid ounce (30 ml) of AC-5000 per one mixed gallon of Aerodur® 5000. The use of AC-5000 is not recommended at temperatures of 70ºF and above.



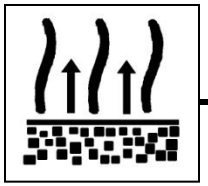
At (21ºC/70ºF):
40 – 80 seconds ISO-Cup 4
24 – 38 seconds Gardener Signature Zahn-Cup #2
22 – 32 seconds Ford Cup #4

At (25ºC/77ºF)
40 – 70 seconds ISO-Cup 4
24 – 32 seconds Gardener Signature Zahn-Cup #2
22 – 27 seconds Ford Cup #4

Pot life: 4 hours Induction Time: 30 minutes

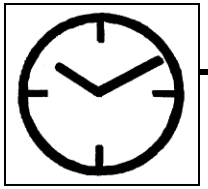
2 coats needed: Apply a single wet coat followed after a minimum of 30 minutes flash-off by a second wet coat.
Dry film thickness: 1.8 – 2.2 mils (45 – 55 microns)

The application characteristics differ from conventional finishes. In application, rapid film build will take place due to the high solid nature of the formulation.

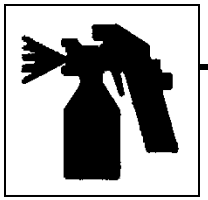


Due to a rapid film build-up with high solid finishes allow a flash-off time between the coats.
65-75°F / 18-24°C 30-50 minutes minimum
75-80°F / 24-32°C 15-30 minutes minimum
80-90°F / 27-32°C 15 minutes minimum

Please note: Volume of airflow can effect surface drying rates.



Dry to Touch: 4 hours
Dry to tape 25ºC / 77ºF ± 4°: 6 hours
Recoat (R.H 35 – 75 %): Maximum recoat time 48 hours. If a drying time of 48 hours is exceeded, reactivate the surface with Scotch-Brite® Type A very fine.
Clean Up Use TR-19, TR-36, or a VOC Compliant Solvent Blend



Type equipment	Tip Size
HVLP	1.4-1.8 mm
Low Pres. Electrostatic	1.2-1.5mm
Air Assisted Electrostatic	.013 to .015 in

We have taken reasonable care in preparing the Mixing Guide and in collecting and preparing material for inclusion in it but do not represent or warrant that it is free from error or that the information content is complete or accurate. The information is advisory only and the use of the Material is solely at your own risk.

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