



MAPCOAT TF

FINISHES FOR AIRCRAFT EXTERIORS



Product information



Solvent based polyurethane coating, used to protect aircraft parts against erosion.
MAPCOAT TF should be applied with Mapaero 9014-B PRIMER (see TDS).

Components



Base MAPCOAT TF
Hardener / Catalyst MAPCOAT
Thinner MAPCOAT

Specifications



Qualified in accordance with:
Embraer : MEP 10-124

Physical properties



THEORETICAL COVERAGE

2.5 m²/kg for 200 µm (7.9 mils) dry (base and hardener undiluted)

DRY FILM WEIGHT

1.25

VOC

460 g/L (3.84 lbs/gal) (ISO11890-1 and ASTM D3960)

COLOR

White FS 37875, Grey FS 36173, Black FS 37038

SHELF LIFE / STORAGE

24 months for the base and hardener, stored between 5°C and 35°C (41°F and 95°F) in full and sealed original packaging.

GLOSS LEVEL

8 ± 3 GU under 60°

Surface preparation



- On carbon composites:

Reactivate then degrease the composite with alcohol or MEK.
Application of PRIMER 9014-B (solvent-based)
Let it flash off 30 minutes to 1 hour at room temperature.

- On steel:

Sand blasting and cleaning with MEK
Application of AEROPRIM 530 primer immediately after sand blasting.
Force-cured for 1 hour at 60°C
Application of PRIMER 9014-B
Let flash-off 30 minutes to 1 hour.

N.B.: For proper adhesion results, MAPCOAT TF should be applied within 30 to 60 minutes after application of the PRIMER 9014-B. It must still be wet.

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Instructions for use



SPRAY APPLICATION

MIXING RATIO

Base
Hardener / Catalyst
Thinner

Mixing ratio by weight

100
45
0 to 15

MIXING PROCEDURE

Ideally, unmixed products should be stored between 18°C (64.4°F) and 25°C (77°F) for 24 hours before use. MAPCOAT TF base should be mixed for 10 minutes with a pneumatic or oscillating mixer. Mix base and hardener until the mixture is consistent before adding the thinner. Mixture must be made at a temperature between 15°C and 35°C (59° and 95°F). Sieve the paint through a 120-190 µm (4.7-7.5 mils) filter.

INDUCTION TIME

5 minutes

Spraying viscosity at 20°C / 68°F

AFNOR CUP N°6

15%

25 ± 5s

POT LIFE

1 hour

Application recommendations



CONDITIONS

Temperature 15°C (59°F) to 35°C (95°F)

Relative humidity 30 % to 75 %

EQUIPMENT

Gravity compressed air gun 1.5 mm to 2 mm

DRY / WET FILM THICKNESS

180 µm to 250 µm (7.1 to 9.8 mils) dry / 360 µm to 500 µm (14.2 to 19.7 mils) wet

NUMBER OF COATS

10 crossed coats with 5 minutes between each coat.

EQUIPMENT CLEANING

MAPCOAT Thinner or MEK

MAPCOAT TF

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Drying times



Dust free
Dry to handle
Fully Cured

23°C (73.4°F)

6 hours
24 hours
7 days

60°C (140°F)

N.A.*

24 hours

NOTE

* NA: Not applicable

Defects & corrections



1) Remove defective areas:

Sand MAPCOAT TF with P150 grade sand paper and finish with P400 on areas affected by the repair to have a smooth surface.

2) Preparation:

- Protect the edges of the area to be repaired by masking tape.
- Reactivate the surface with cleaned lint-free cloth soaked with Methyl Ethyl Ketone.
- After flash-off, apply MAPCOAT TF.
- Remove the masking from surrounding areas within 90 minutes following application of MAPCOAT TF.
- Drying for 24 hours at 23°C (73°F) then 24 hours at 70°C (158°F) for fully cured.

Health & Safety



See the product safety data sheets.

The MSDS are available through our website www.mapaero.com

Packing



The kit of 1kg includes:

- 690g base
- 310g hardener/catalyst

WARRANTY : We guarantee our products against hidden defaults over material and preparation. Our Responsibility is limited to the obligation of freely replacing the defective material without there being a claim for any compensation. The advice we give is based on our experience but it might not be absolutely right. Consequently this does not imply our responsibility in case of inefficiency. Furthermore our company cannot be responsible for any material or corporal damages caused due to a misuse or mishandling of our products. Any concession to these clauses, to be valid, must be an official document issued by our offices and signed by our direction.