

FlyGloss FGBC Base Coat

Acrylic Polyurethane Topcoat



Product FlyGloss FGBC Base Coat

Item Class Base Coat / Clear Coat System

FlyGloss FGBC acrylic polyurethane base coat is intended for use with FGCC clear coat to achieve superior gloss and color retention that outshines and outlasts preceding aerospace market technologies. FGBC is available in both solid and special effect colors. With a solid content of over 50 percent, FGBC offers single coat coverage on almost all colors. In addition, this product has a dry to tape time of 2 hours and a recoat window of 72 hours.

Specifications Product is manufactured to meet the performance requirements of the following specifications:

AMS 3095A* - AIMS 04-04-025 - AIMS 04-04-033 - AIMS 04-04-037 - BAMS 565-018 - MEP 10-125 Type I - BAMS 565-018
(*Listed on QPL)

Activator & Additives

Activator	Additive
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925 (Solid Colors)	PS50 Accelerator
930 (Special Effect Colors)	

Use of Primers 3Chem recommends use of P1019 (High Solid Epoxy Primer) and P-1069 (Surfacing Primer) with this system. Please contact your local 3Chem representative for a complete list of epoxy primers which may be utilized with this system.

Surface Preparation Prepare substrate per OEM requirements. Refer to FlyGloss application guide for detailed instructions or contact your local 3Chem representative for assistance.

Mixing Instructions

Base	Finish	Activator	Mix Ratio
FGBC-2XXX	Solid Colors	925	1:1
FGBC-8XXX	Special Effects	930	1:1
FGCC-XXXX	Required Clear Coat	900	1:1

All Colors:

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B activator to component A paint first. Mix ratio for material is 1-part component A paint, 1-part component B activator.

***All FGBC base coat colors must be top coated with FlyGloss FGCC clear coat to meet specification requirements.

Induction Time Allow 10 minutes induction time prior to use. Once mixed together, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

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Spraying Viscosity Solid Colors: 18-22 Seconds with #2 Zahn cup, Special Effect Colors: 17-21 Seconds with #2 Zahn cup

Pot Life 4 Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness 1-1.5 mils DFT (Only one coat required) Wet film thickness should be 2-3 mils total

Application Instructions

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	45 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

(Dry Times with no PS50 accelerator used)

Temperature	Dry to Recoat	Dry to Tape	Dry to Handle	Clearcoat Window	Full Cure
52-65°F (11-18°C)	2 Hours	8 Hours	12+ Hours	72 Hours	7 Days
66-85°F (19-29°C)	1.5 Hours	6 Hours	10-12 Hours	72 Hours	7 Days
86-95°F (30-35°C)	1 Hour	4 Hours	8-10 Hours	72 Hours	7 Days

(Force dry using PS50 accelerator)

Temperature	PS50 Required	Dry to Recoat	Pot Life	Dry to Tape	Dry to Handle	Clearcoat Window	Full Cure
52-65°F (11-18°C)	0.5oz/14ml per admixed gallon	1-1.5Hours	45-50 Minutes	3-4 Hours	8 Hours	72 Hours	7 Days
66-85°F (19-29°C)	0.25oz/7ml per admixed gallon	1 Hour	30-40 Minutes	2-3 Hours	6 Hours	72 Hours	7 Days
86-95°F (30-35°C)	PS50 not recommended	1 Hour	4 Hours	3 Hours	6 Hours	72 Hours	7 Days

Only mix enough material to be applied on initial coat. Always add component B activator to component A paint. Complete kit of material will yield 2 US Gallons (7.5 liters). 1-gallon component A paint, 1-gallon component B activator. When using PS50 accelerator, add to admixed material.

Apply one even wet coat of material using a uniform spray pattern. Cross coat may be required to achieve 100% coverage in one single coat depending on color. Certain colors may require additional coats.

Application Instructions PS50 Accelerator (Touch Up Application)

PS50 Required	Dry to Recoat	Pot Life	Dry to Tape	Dry to Handle	Clearcoat Window	Full Cure
1oz/29ml per admixed gallon	30 Minutes	15-20 Minutes	1 Hour	3 Hours	18 Hours	7 Days

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<i>Theoretical Coverage</i>	1100-1200 sq. ft / gallon @ 1 mil 27-28 m ² / liter @1 mil *Coverage based on 100% transfer efficiency rate
<i>Dry Film Weight</i>	Per 25 microns: 27-35 g/m ² Per dry mil: .0057-.0082 lbs./ft ²
<i>Color</i>	Available in all gloss color ranges *Special Effects colors include micas and pearlescent
<i>Gloss</i>	Solid colors: 85 minimum @ 60 degrees Special Effects colors: 17-30 @ 60 degrees (Gloss 95 minimum once clear coated with FGCC-100)
<i>Volatile Organic Compound</i>	300 – 380 g/l
<i>Shelf Life</i>	24 Months (When stored in climate-controlled environment between 60-80° F) *Product may be re-certified upon inspection by 3Chem.
<i>Safety Instructions</i>	Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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