

# AA3165 Series

## Gloss Lacquer Coating



**Product** AA3165 Series Gloss Lacquer Coating

**Item Class** General Touch Up Coating

AA3165 Series is a lacquer coating which offers good durability, high gloss, and ease of application. It is formulated for use on both interior and exterior aircraft applications.

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

A-A-3165A

**Additives** Thinner

CM155

**Use of Primers** Please contact your local 3Chem representative for a complete list of zinc and epoxy primers which may be utilized with this system.

**Surface Preparation** Prepare substrate per OEM requirements. Contact your local 3Chem representative for assistance.

**Mixing Instructions**

Base	Thinner (Optional)	Mix Ratio
AA3165-XXXXX	CM155	1:.15 (Max)

**Spraying Viscosity** 17-19 Seconds with #2 Zahn cup

**Film Thickness** 1-1.5 Mils DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 1.5-2 mils total between 2 coats

**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	40 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

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### **Application Instructions**

#### **Dry Times**

Temperature (Min/Max)	Thinner	Dust Free	Dry Hard	Full Cure
52-95°F (11-35°C)	CM155	10 Minutes	30 Minutes	18 Hours

Apply one coat of material using a uniform spray pattern. Take care not to leave any dry areas or spots. Wet these areas again if necessary, to assure a uniform finish. Wait appropriate dry to tape or dry to handle time based on chart above.

**Theoretical Coverage** 300-350 sq. ft / gallon @ 1 mil 8-9m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** Available in most AMS-STD-595 gloss colors

**Gloss** Gloss colors: 90 minimum @ 60 degrees

**Volatile Organic Compound** 290 – 338 g/l

**Shelf Life** 24 Months (When stored in climate-controlled environment between 60-80° F)  
\*Product may be re-certified upon inspection by 3Chem.

**Safety Instructions** Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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