

# P-2065

## Polyurethane Wing Coating



**Product** Polyurethane Wing Coating

**Item Class** Specialty Coating

P-2065 is a two-component polyurethane coating formulated for use on upper area wing surfaces and stabilizers.

**Specifications** Product is manufactured to meet the performance requirements of the following specifications:  
AIMS 04-04-026, AIMS 04-04-034

**Catalyst & Additives** Catalyst/Activator

729

**Use of Primers** 3Chem recommends use of P1019 (High Solid Epoxy 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.

**Mixing Instructions**

Base	Catalyst/Activator	Mix Ratio
P-2065	729	1:1

Shake (Base) for 15 minutes to assure no solid settlement remains in can. Add component B catalyst to component A paint first. Mix ratio for material is 1-part component A paint, 1-part component B catalyst. No thinner should be added to this product. (Kit yield either 2 gallons or 2 quarts).

**Induction Time** Although no induction time is needed. Once mixed together, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

**Spraying Viscosity** 19-24 Seconds with #2 Zahn cup

**Pot Life** 7 Hours @ 21° Celsius, 70° Fahrenheit

**Film Thickness** 2-3 Mils DFT. Wet film thickness should be 4-6 Mils total

**Application Instructions**

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

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### 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

### Dry Times

Temperature	Wet-Edge	Time Between Coats	Dry to Tape	Dry to Handle	Full Cure
52-65°F (11-18°C)	60 Min	45-90 Min	8-9 Hours	10 Hours	6 Days
66-85°F (19-29°C)	45 Min	30-60 Min	7-8 Hours	9 Hours	6 Days
86-95°F (30-35°C)	30 Min	30-40 Min	6-7 Hours	7-8 Hours	6 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. Apply one even wet coat of material using a uniform spray pattern. Cross coat may be used to achieve 100% coverage.

### Application Instructions PS40 Accelerator (Fast dry additive mix options)

PS40 Accelerator	Dry Between Coats	Dry to Handle	Dry Hard	Pot Life	Full Cure
2% By Volume	12 Minutes	2 Hours	4 Hours	4 Hours	6 Days
3% By Volume	10 Minutes	1.5 Hours	3 Hours	3 Hours	6 Days
5% By Volume	5 Minutes	45 Minutes	1 Hour	45 Minutes	6 Days

\*Note: Overuse of PS40 additive may affect product gloss and finish

**Theoretical Coverage** 800-900 sq. ft / gallon @ 1 mil 20-22m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** M9004 Gray

**Gloss** 50-70 @ 60 degrees

**Volatile Organic Compound** 340 – 390 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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