FlyGloss FGCC Clear Coat

Acrylic Polyurethane Topcoat

Product **FlyGloss FGCC Clear Coat**

Item Class Base Coat / Clear Coat System

FlyGloss FGCC acrylic polyurethane clear coat is intended to be applied over FGBC base coat to achieve superior gloss and color retention that outshines and outlasts preceding aerospace market technologies. FGCC clear coat offers a gloss of 95+. It has excellent wetting properties and is buffable for up to 72 hours. This product is also resistant to various aerospace chemicals and solvents including hydraulic fluid.

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
900	PS50 Accelerator

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 Glair application guide for detailed instructions or contact your local 3Chem representative for assistance.

Mixing Instructions

Base	Finish	Activator	Mix Ratio
FGCC-XXXX	Required Clear Coat	900	1:1

Lightly stir (Base) for 3-5 minute. Add component B activator to component A paint first. Mix ratio for material is 1-part component A paint, 1-part component B activator.
*** FGCC must be used in conjunction with FlyGloss FGBC base coat to meet specification requirements.

Induction Time No induction time is necessary for this product. Once mixed, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

Spraying Viscosity 17-21 Seconds with #2 Zahn cup

Pot Life 8 Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness

.75-1.25 mils DFT (Only one coat required) Wet film thickness should be 1.5-2 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

Temperature	Wet-Edge	Touch Dry	Dry to Handle	Full Cure
52-65°F (11-18°C)	1.5 Hours	9 Hours	14 Hours	7 Days
66-85°F (19-29°C)	1 Hour	8 Hours	12 Hours	7 Days
86-95°F (30-35°C)	45 Min	7 Hours	10 Hours	7 Days

Oven Force Dry Instructions 1:1

Flash Time	Oven temperature	Dry to Handle	Full Cure
1 Hour	2 hour @ 120° F (43°C)	3 Hours	7 Days

Ensure that FlyGloss base coat surface is clean from any contaminants. Use industry approved tack clock on all surfaces immediately prior to FlyGloss FGCC clear coat application.

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. Second coat may be applied if desired.

Application Instructions

PS50 Accelerator (Repair Application)

PS50 Required	Pot Life	Dry to Handle	Full Cure
1oz/29ml per admixed gallon	30 Minutes	2.5 Hours	7 Days

Theoretical Coverage

900-1000 sq. ft / gallon @ 1 mil 21-23 m2 / liter @1 mil
*Coverage based on 100% transfer efficiency rate

Dry Film Weight

Per 25 microns: 1.15 g/m2
Per dry mil: .0057 lbs./ft2

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Color	Clear / Transparent
Gloss	95 minimum @ 60 degrees
Volatile Organic Compound	380 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.