Sylka Y3 Series

Waterborne Urethane Interior Coating

Product

Sylka Y3 Series Waterborne Urethane Interior Coating

Item Class

Specialty Coating

Sylka water reducible urethane topcoat is specially formulated for use on aircraft cabin interior surfaces such as polycarbonates, composites, honeycomb, and plastics. It is extremely versatile and may be applied either as a smooth or textured finish. Once cured this product is extremely tough. It is resistant to scratches, certain chemicals and normal passenger wear and tear.

Specifications

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

14 CFR Part 25.853 (a) Appx F Part I - AITM 3.0005 / ABD 0031 (7.4) (Toxicity) - AVP3-008 - BSS 7239 (Toxicity)

Surface Preparation

Proper surface preparation is essential to promote good adhesion. First clean the substrate and dry using a very fine scotch pad. Make sure to remove all dust and debris using a clean lint free cloth. Once complete, use isopropyl alcohol, acetone, naphtha, or other approved OEM solvent to remove remaining contaminants. Perform water break test to make sure no residues remain on the substrate.

Mixing Instructions

Base
Y31-XXXX (Gloss)
Y32-XXXX (Semi-Gloss)
Y33-XXXX (Flat)

Shake single component (Base) for 10-15 minutes. Since Sylka is a single component topcoat, no mixing is required. However, if desired this product can be diluted with distilled water up to 10% by volume. It recommended to filter product before pouring into application equipment.

Spraying Viscosity

Gloss Colors: 17-19 Seconds with #2 Zahn cup, Semi-Gloss/Flat Colors: 19-22 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%

Application Instructions

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 (Min/Max)	Dust Free	Dry Hard	Full Cure
52-95°F (11-35°C)	15 Minutes	45 Minutes	48 Hours

Number of Coats:
Spray 1 -2 coats to achieve desired film thickness.

Reduction Instructions:
For smooth finish product may be reduced 10% utilizing distilled water. However, not required.

For textured surface product should be applied "as is" with no reduction. Spray gun must be regulated to achieve desired textured pattern.

Theoretical Coverage 300-350 sq. ft / gallon @ 1 mil 8-9m2 / liter @1 mil
*Coverage based on 100% transfer efficiency rate

Color Available in all color ranges

Gloss Gloss colors: 80 minimum @ 60 degrees
Semi-Gloss colors: 17-30 @ 60 degrees
Flat/Matt Colors: Less than 5 @ 60 degrees
*Also available in satin and custom match finishes

Volatile Organic Compound 115-120 g/l

Shelf Life 12 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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