

Approvals and conformities

BOEING	52841092, 9M03235/AttachA, BMS10-90, D290-75502-22C, MB0125-080, SCGMS56016, STM0724
Ball Aerospace & Technologies	BMS29.98
COLLINS AEROSPACE	KB0125005
CYTEC SOLVAY	LMS 11953
Cincinatti Electronics	635907-1
HONEYWELL	P8251333
ILC Dover	ST41P1218
ITT, Space Systems	561454
LOCKHEED MARTIN	LAC-37-4462-002, MAP-CK10787-1000, STM40601
NASA	MSFC-PROC-547 Rev E
NORTHROP GRUMMAN	53825TW
Raytheon	HMS15-2135

Aeroglaze A276 is a reflective, moisture-curing polyurethane coating designed for use on substrates in aircraft and aerospace applications. Aeroglaze A276 coating cures to a high gloss white finish.

Features and Benefits

- **Low Outgassing:** exhibits low outgassing properties in high vacuum environments.
- **Chemically Resistance:** cures to a hard surface that is resistant to most acids, alkaline detergents, lubricants, and chemicals.
- **Color Retention:** provides excellent colorfast, non-chalking finish that does not degrade with UV exposure.

DIRECTIONS FOR USE

Surface Preparation

Thoroughly clean surfaces to remove all dust, oil, and grease. For most substrates, apply a primer to ensure proper adhesion and performance of the coating. Contact your Socomore representative for an appropriate primer recommendation.

Mixing

Before opening container, thoroughly mix coating for 5 minutes using a paint shaker. Open the lid

Carefully as the container may be under slight pressure. Stir the coating with a clean paint stick to check for any settled material and ensure mixture is homogeneous. If material has settled, return closed container to the paint shaker and mix for an additional 5 minutes or until no settling is apparent.

Application

Aeroglaze A276 coating is best applied at 13-35°C (55-95°F), with substrate temperatures at least 2.8°C (5°F) above the dew point.

Spraying

Dilute coating with 10-25% Aeroglaze 9958 thinner by volume. Apply coating using HVLP spray equipment with a 1.4 mm spray tip and a dry air feed with less than 500 ppm moisture. Hold the gun at right angles to the surface, approximately 20.3-30.5 cm (8-12 in) away, and apply with a 50% overlap between passes.

Brushing

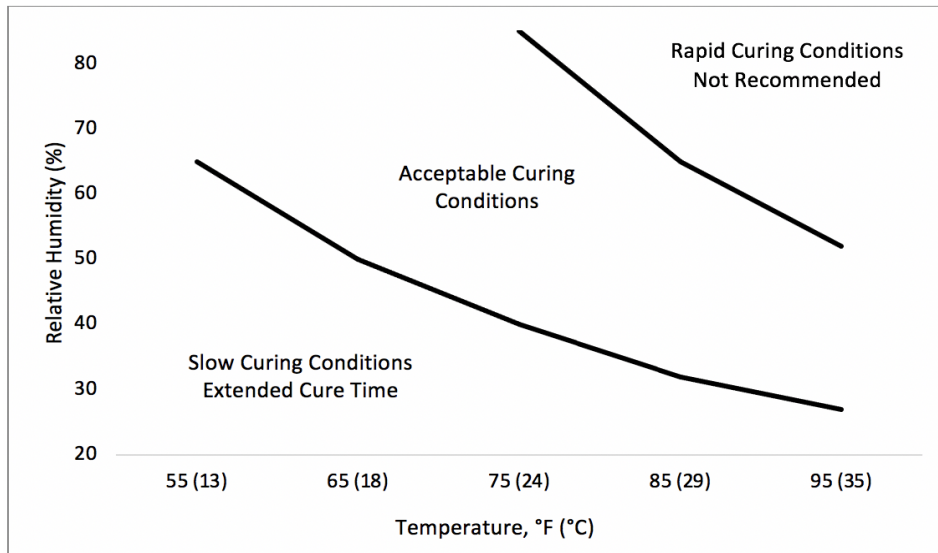
Application by brush is only recommended to touch-up small areas. Add up to 5% by volume of Aeroglaze 9958 thinner to control the application properties.

The optimum dry film thickness of Aeroglaze A276 coating is 38-51 micron (1.5-2.0 mil). Apply a maximum of 127 micron (5 mil) wet film thickness per coat as excessively thick coats can cause bubbling and sagging. The coverage rate is approximately 7.4-9.8 m²/L (300-400 ft²/gal).

Curing

Aeroglaze A276 coating cures by reacting with moisture in the air. The cure rate is dependent on the temperature, relative humidity, and amount of air circulation required to remove the solvent.

Under the acceptable curing conditions, the coating will develop its ultimate properties in approximately 14 days. Refer to the psychrometric chart below. Lower temperatures and humidities decrease the rate of cure, while higher temperatures and humidities may cause bubbling.



Aeroglaze A276 coating cures to a tack-free surface in 2-3 hours at 25°C (77°F) and 50% relative humidity. Room temperature cure times of 24 hours permit handling.

Aeroglaze A276 may be recoated after the first application within 4 hours minimum and 24 hours

maximum. The recoat time is dependent on temperature and humidity. High temperature and humidity promote fast cure while low temperature and humidity slow down the cure. In high temperature and high humidity conditions, recoat within 8 hours to prevent intercoat adhesion failure. If the maximum recoat time is exceeded, the surface must be roughened by sanding with fine sandpaper prior to application of an additional coat.

The constant operating temperature of Aeroglaze A276 is -150 to 104°C (-238 to 220°F), with excursions to 121°C (250°F) permitted for no longer than four hours at a time.

Clean-Up

Use Aeroglaze 9958 thinner to clean equipment. Do not use lacquer thinners, water, or solvents containing alcohol.

TECHNICAL CHARACTERISTICS

Typical Properties¹

Property	Value
Appearance	White Liquid
Viscosity, cps @ 25°C (77°F), ASTM D 2196-86, Brookfield LVT	100-400
Density, ASTM D 1475-85	1.12-1.17 kg/L (9.37-9.77 lb/gal)
Solids Content by Weight, ASTM D 2369-87 modified	54-58%
Flash Point (Seta), ASTM D 3278-82, Closed Cup	19°C (67°F)
Volatile Organic Content (VOC) ASTM D 3960-87	503 g/L (4.2 lb/gal)
Outgassing ² ASTM E 595-77	0.99% TML3, 0.08% CVCM4
Solar Absorptivity, Gier-Dunkle Integrating Sphere	0.23
Normal Emissivity	0.88-0.91

1) Data is typical and not to be used for specification purposes.

2) 15-day cure at room temperature, 24 hours at 50°C (122°F).

3) Total Mass Loss

4) Collected Volatile Condensable Materials

PRECAUTIONS FOR USE AND STORAGE

The shelf life is one year from date of shipment when stored in the original, unopened container at temperatures between 10-32°C (50-90°F). Store indoors away from heat, sparks, and open flames.

The pot life of Aeroglaze A276 is two hours at 25°C (77°F) and 50% relative humidity. Lower temperatures and humidities increase the pot life, while higher temperatures and humidities decrease the pot life. It is not recommended to use Aeroglaze A276 after the pot life has expired.

Before using this or any SOCOMORE product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use. Not for immersion service. Do not apply to wet or damp substrates. Aeroglaze A276 coating contains aliphatic isocyanate monomer. Spray only in properly

ventilated areas with specified respiratory protection.

Manufactured for SOCOMORE by: LORD Corporation, Saegertown, PA

This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as Socomore deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.