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PRODUCT INFORMATION DATA SHEET

N85VI-36375 SINGLE-COMPONENT (1K) POLYSILOXANE TOPCOAT CAMOUFLAGE GRAY #36375

INTENDED USES

The topcoat is a single component (1K) isocyanate-free and HAP-free system designed for the outer mold line (exterior) of the aircraft. The topcoat does not require the addition of components or a catalyst before application, and thus provides a user-friendly system for applicators and a reduction in waste streams.

PHYSICAL PROPERTIES

Color	Gray Fed. Std. #36375
Gloss	5.0 max @ 60°F, 10.0 max @ 85°F
Volume Solids	43.3 % +/- 1%
Weight Solids	41.4 % +/- 1%
Weight per Gallon	9.4 +/- 0.5 lbs/gallon
Theoretical Coverage	695 sq. ft/gal @ 1 mil dft

VOC	2.4 lbs /gal or 286g/l
Recommended Film Thickness	1.7-2.3 mils DFT
Theoretical Dry Film Weight	0.0055 lbs/sq ft
Viscocity	25-30 sec Ford#4

RESISTANCE DATA

MEK, 25 Double Rubs	Pass 100 rubs after full cure
MILPRF23699	No Blistering or Defects
MILPRF83282	No Blistering or Defects
JP-5/MILDTL5624	No Blistering or Defects
GE Impact Flexibility	>40% Elongation
Cleanability	≥ 75%

Wet Tape Adhesion	24 Hour Immersion ≥ 4A Adhesion
Heat Resistance	Delta E = 0.12
Weather Resistance	Delta E = 0.64 after 3000 Hrs. Xenon
Strip-ability	≥ 90%
Low-Temp Flexibility	≤ 2" Mandrel – No cracking
Storage Stability	≥ 1 year in unopened container stored indoors between 35–135F

APPLICATION CHARACTERISTICS

Mixing	Single Component (1K). Make sure to shake or stir to a homogenous solution. Do not over shake or mix more than 10 minutes with a mechanical shaker or mixer.
Induction Time	None. Ready to spray.
Cleaning Solvent	T-210 or urethane grade thinner

Dry Times	*A function of time and temperature*		
Dry to Touch	< 2 hours	Handle	3 hours
Dry Hard	1-2 hours	Dry Through	3-4 hours
Dry to Tape	≤12 hours	Full Cure	≤14 Days
NOTE	Test Performed @ 72°F, 50% Relative Humidity		

Surface Preparation

Do not apply if the application surface temperature is below 45°F (7°C) or above 110°F (43°C), or if the surface temperature is within 5°F of the dew point. It is highly recommended that sound practices as set forth by SSPC or NACE be followed when preparing a substrate for painting. At a minimum the surface should be clean of all grease, dirt, oil, rust and foreign material that would be detrimental to proper adhesion and desired performance of the coating system being applied.

Safety Precautions

This product is intended for professional use in an industrial environment only! Consult the Material Safety Data Sheet prior to application for detailed information on the health and safety hazards.

Shelf Life & Storage Conditions

Shelf life (protected from atmospheric moisture): 12 months from the date of manufacture. This product must be stored in accordance with local, state, and national regulations. Preferred storage conditions: Keep containers in a dry space with adequate ventilation.

Comments

Mix with a paint shaker prior to use. Agitate material while in use. Ambient application temperature should be between 60°F and 90°F. Best results with relative humidity above 10% and less than 80%.

Note

The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, application and testing requirements for their specific job!

• *Adjust as needed to get the desired/optimal fluid delivery for the spray gun, fluid tip and needle assembly being used.*

RECOMMENDED PRIMERS

SUBSTRATE	RECOMMENDED PRIMER
Aluminum/Galvanized Steel/Stainless Steel	Approved MILPRF85582 or MILPRF23377 or MILPRF32239 aircraft primers. Other primers should be tested and confirmed for compatibility.
Ductile or Grey Iron Castings	N-5751M2 Zinc Rich Epoxy, N-8959 Solvent Based Epoxy, N-8460 Water Based Epoxy
Plastics	Due to the wide variety of plastic/fiberglass substrates, system performance should be tested and confirmed on actual substrate.
Previously Painted Surfaces	Surface should be intact and sound. All loose and flaking material removed or sanded and bare spots primed with an appropriate primer. An area should be tested with the coating to assure compatibility.
Steel	N-5751M2 Zinc Rich Epoxy, N-8959 Solvent Based Epoxy, N-8460 Water Based Epoxy
Wood	Due to the wide variety of wood substrates, system performance should be tested and confirmed on actual substrate.

APPLICATION EQUIPMENT	AIR PRESSURE	FLUID PRESSURE	CAP	TIP
Conventional Electrostatic	N/A	N/A	N/A	—
Conventional Spray	10-50 psi	8–40 psi*		1.7–2.0
HVLP Spray	10 psi	8–40 psi*		1.7–2.0
Air-Assisted Airless	N/A	N/A	N/A	—
Airless	**Pressure:** N/A		**Tip:** N/A	
Brush and Roll	Use for touch up only. The use of natural china chip bristle brushes or ¼" maximum nap mohair type rollers is highly recommended to limit the amount of orange peel.			

Note: These parameters are to be used as a guideline only. Customer specific equipment may require a different set-up.

pending spec update will be MILPRF85285, Type VI