



**WS-3 SERIES
WATER REDUCIBLE POLYURETHANE
INTERIOR TOPCOAT**

FAR 25.853 COMPLIANT

APPLICATION SPECIFICATION



PRODUCT DATA:

SINGLE COMPONENT

SOLVENT RESISTANCE: 20 Double Rubs, MEK
VOC: 1.60 (+/-0.20) pounds per gallon or 192 grams per liter
ODOR: Low Odor (good for confined areas)
DRYING TIMES AT 75°F (24°C) AND LESS THAN 70% RH:
 To Touch: 30-45 minute
 Tack Free: 1 Hour
 Dry Hard: 2-3 Hours
FLASH POINT: 200 degrees F (93°C)
HEAVY METAL FREE / HAPS FREE
VISCOSITY: 20-30 SECONDS, #3 ZAHN
COVERAGE: 449-481 sq. ft (45-48 sq. m.) / Mil / gallon @ 100% transfer
SHELF LIFE: 12 Months from date of MFG.
STORAGE TEMPERATURE: 40 TO 95 Degrees F (4 - 35°C)
GLOSS: 20-30 units at 60°
SOLIDS BY WEIGHT: 40-45% (depending on color)
SOLIDS BY VOLUME: 28-30% (depending on color)

NOTE: For full solvent resistances allow 7 days curing.

PRODUCT DESCRIPTION:

This one component Waterbase Topcoat is VOC compliant and designed for use on Commercial and Corporate aircraft cabins. WS-3 Series products are formulated to be applied over various substrates including Tedlar, ABS, polycarbonate, polysulfone and other plastics and metals common to aircraft interiors. These coatings are characterized by excellent adhesion, along with scratch resistance, stain resistance and cleanability. This series is suitable for use in areas where cabin flammability (smoke emissions and heat release rate for example) requirements must be met. This product can be tinted in a variety of colors and can be applied with a textured effect by adjusting the application technique.



SURFACE PREPARATION:

Surfaces to be painted should be cleaned with one of the following items;

- Isopropyl Alcohol (IPA)
- Acetone
- Ammonia type cleaners'
- Alkaline cleaner

NOTE: IPA and Acetone can be cut with water 10% to 20%. This procedure will add to the wetting of the surface and minimize the quick flash off that these two products normally have.

All residues need to be clean from substrate prior to applying coating. Substrates can be lightly abraded with Scotchbrite or sandpaper to insure adhesion, remove residue with tack cloth.

Primers that can be used with waterborne material are EP-2-Y1, EP-3-GN1, and zinc primers.

APPLICATION EQUIPMENT:

Any standard suction, pressure pot, HVLP or airless spray equipment may be used. The product can also be rolled. The proper roller is a 1/8" foam roller.

APPLICATION PROCEDURES:

Mix the paint well by stirring. Do not use a paint shaker as foaming may result. Spray apply the topcoat in 2 or 3 wet coats to a wet film thickness of 3 to 4 mils. This topcoat lends itself very well to achieve a textured effect when desired.

WS-3 can be reduced with water if needed, 5-8% volume Max, and stir material to insure a good mix.

NOTE: Always secure lids when product is not being used.

APPLICATION PROCEDURES: CONT'D

The application of this Waterbase coating is normally done in a two coat or three-coat process.

A two-coat process consists of a base coat with a textured coat or two smooth base coats.

The three-coat system consists of a base coat with a textured coat followed by a spatter coat (possibly more than one color).

Both of these systems can be cleared coated with the WS-3-C1 clear or the two components PS-3-C1, if desired.

- 1) Repair damaged surfaces, as required.
- 2) Mask all surfaces not to be painted.
- 3) Thoroughly clean all areas to be finished.
- 4) Apply texture / smooth coating, as required.

NOTE: Allow 10 to 20 minutes between coats depending on temperature and Humidity.

Be aware that if you are applying these coatings in a very high humidity environment, (over 70% RH) they will take longer to dry.

- 5) Apply decorative finish (3-coat system).
- 6) Apply clear coat, as required.
- 7) Remove masking materials.



EQUIPMENT CLEAN UP:

Use warm water, followed with SR-12 solvent / reducer.

NOTE: Never clean your equipment with solvents first. Use warm water, then solvent.

POST MAINTENANCE:

Parts / Interiors that have been coated need 7 days to reach full cure. Do not apply any cleaning solutions during this period of time.

Cleaning solutions that are used on Parts / Interiors that have been coated with the WS-3 product need to be evaluated prior to being used. Certain products can damage the look or cause coatings to lift.

PRECAUTION:

Use products with proper ventilation, respiratory and skin protection. See MSDS for complete instructions and precautions.