AEROSPACE SURE-COAT
TECHNICAL DATA SHEET

Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Aerospace Sure-Coat is a waterborne coating system offering excellent flexibility and outstanding adhesion for a variety of interior and exterior applications.

FEATURES

- Excellent for leather, vinyl and plastic
- Meets FAR's 23.853, 25.853(a) and (c), 27.853 and 29.853
- VOC compliant * Can be brushed or sprayed
- Mixing system = endless colors
- Superior resins provide great adhesion, flexibility and durability
- Easy to use
- Quick drying

SUITABLE SUBSTRATES

- Vinyl
- Leather
- Plastic

TYPICAL PROPERTIES

A16749 PINT KIT

Part:	Product Name:	Color:	Container:
16004	Sure-Coat Cross Linker	N/A	4 oz. Dropper Bottle
A16018	Aerospace Sure-Coat	Black	Pint
A16088	Aerospace Sure-Coat	Silver	Pint
A16508	Aerospace Sure-Coat	Red Oxide	Pint
A16518	Aerospace Sure-Coat	Indo Yellow	Pint
A16528	Aerospace Sure-Coat	Quindo Red	Pint
A16538	Aerospace Sure-Coat	Thalo Blue	Pint
A16548	Aerospace Sure-Coat	White	Pint
A16568	Aerospace Sure-Coat	Thalo Green	Pint
A16598	Aerospace Sure-Coat	Yellow Oxide	Pint
A16708	Aerospace Sure-Coat	High Gloss Clear	Pint
A16718	Aerospace Sure-Coat	Satin Gloss Clear	Pint
A16728	Aerospace Sure-Coat	Low Luster Clear	Pint

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A16739 HALF GALLON KIT

Part:	Product Name:	Color:	Container:
16004	Sure-Coat Cross Linker	N/A	4 oz. Dropper Bottle
A16015	Aerospace Sure-Coat	Black	Half Gallon
A16085	Aerospace Sure-Coat	Silver	Half Gallon
A16505	Aerospace Sure-Coat	Red Oxide	Half Gallon
A16515	Aerospace Sure-Coat	Indo Yellow	Half Gallon
A16525	Aerospace Sure-Coat	Quindo Red	Half Gallon
A16535	Aerospace Sure-Coat	Thalo Blue	Half Gallon
A16545	Aerospace Sure-Coat	White	Half Gallon
A16565	Aerospace Sure-Coat	Thalo Green	Half Gallon
A16595	Aerospace Sure-Coat	Yellow Oxide	Half Gallon
A16705	Aerospace Sure-Coat	High Gloss Clear	Half Gallon
A16715	Aerospace Sure-Coat	Satin Gloss Clear	Half Gallon
A16725	Aerospace Sure-Coat	Low Luster Clear	Half Gallon
A70034	Aerospace Color Selector	N/A	N/A
70400	Aerospace Sure-Coat	Sure-Coat Dauber Bottle	4 oz. Bottle

ADDITIONAL COLORS (TO ADD VERSITILITY TO MIXING SYSTEM)

Part:	Product Name:	Color:	Container:
A16578	Aerospace Sure-Coat	Magenta	Pint
A16588	Aerospace Sure-Coat	Bright Red	Pint
A16585	Aerospace Sure-Coat	Bright Red	Half Gallon

Containers:	Pint and 1/2 gallon
Coverage of toners @ 1 mil DFT:	390-470 sq.ft./gl
Coverage of clears @ 1 mil DFT:	360-500 sq.ft./gl
Average weight solids % of toners:	26-36%
Average weight solids % of clears:	23-34%
Regulatory VOC:	2.07-2.50 #/gl (248-340 g/l)
Actual VOC:	0.8-1.35 #/gl (96-162 g/l)
Taber abrasion wear index average:	41 with 16004
Cross cut adhesion test:	100% adhesion on leather, vinyl and plastic
Dry film build:	0.8-1.2 mils
Freeze thaw stability:	3 cycles
Drying time:	@ 70ºF (21°C) and 50% R.H.(Airflow improves these times.)

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Dust free:	20 minutes
Tack free:	40 minutes
Tape time:	60 minutes

Please refer to www.semproducts.com for physical properties and VOC information. Use VOC calculator to determine VOC of mixtures. Check local VOC regulations to ensure compliance of all products in your area.

HANDLING AND APPLICATION

PREPARATION:

VINYL:

1. Clean first with **Aerospace SEM Soap** and a gray scuff pad.
2. Rinse with water or wipe soap residue with a clean damp cloth and allow to dry.
3. Clean thoroughly with **Vinyl Prep** or **Zero VOC Surface Cleaner** using a clean, damp lint free towel and wiping in one direction.
4. If contamination still exists, water will bead on the surface. Repeat this step until beading no longer occurs.

PLASTIC:

1. Clean first with **Aerospace SEM Soap** and a gray scuff pad.
2. Rinse with water or wipe soap residue with a clean damp cloth and allow to dry.
3. Clean with Aerospace **Plastic & Leather Prep** or **Zero VOC Surface Cleaner**. If contamination still exists, water will bead on the surface. Repeat this step until beading no longer occurs.
4. To promote adhesion on TPO, EPDM, PP and other similar thermoplastics, use **Plastic Adhesion Promoter** or **XXX Adhesion Promoter**.

LEATHER:

1. Clean first with **Aerospace SEM Soap** and a gray scuff pad, paying close attention to textured or recessed areas. Wipe with a clean damp towel to remove all residue and allow surface to dry.
2. Clean with **Aerospace Plastic & Leather Prep** or **Zero VOC Surface Cleaner**.
3. Scuff the leather with a clean, gray scuff pad or 400-600 grit sandpaper.
4. Clean again with **Aerospace Plastic & Leather Prep** or **Zero VOC Surface Cleaner**.

MIXING:

Aerospace Sure-Coat is ready to spray. Hand stir or shake well to make sure color is consistent. **Aerospace Sure-Coat** may appear foamy; however, bubbles will dissipate during application.

Note: Sure-Coat Cross Linker is available to increase the resistance of **Aerospace Sure-Coat** to the effects of most industrial and household chemicals which commonly affect waterborne coatings. Please refer to product label for instructions.

Sure-Coat Reducer may be added to give the user more versatility when applying **Aerospace Sure-Coat**. Please

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refer to product label for instructions.

APPLYING:

WHEN SPRAYING

Always flush gun with acetone followed by deionized water prior to application. During application hold gun 6-8 inches from the surface. Using 25-30 psi from non-HVLP equipment or 8-10 psi at the cap with HVLP equipment, apply light coats, allowing 5-10 minutes flash time between coats. Apply sufficient coats to achieve hiding.

WHEN BRUSHING

Use a **Poly Brush** and apply one light coat followed by two medium wet coats allowing 5-10 minutes flash time between coats. You can also use the **Sure-Coat Dauber Bottle**. Apply sufficient coats to achieve hiding.

Note: Dry time is dependent on relative humidity and air circulation. Allow 10 minutes flash time before baking. Curing can be accelerated with a fan or an infrared curing system placed 3-4 feet from the surface. DO NOT EXCEED 140ºF (60°C) OR BAKE FOR LONGER THAN 30 MINUTES. Allow 24-36 hours before placing substrate back into service.

CLEANUP:

Flush spray equipment with warm water until clean. Follow with acetone until all water has been removed.

STORAGE:

Aerospace Sure-Coat should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Aerospace Sure-Coat** is 5 years when stored under normal conditions.

RELATED PRODUCTS:

Part:	Product Name:	Size:
A39362	Aerospace SEM Soap	Pint
38343	Vinyl Prep	Aerosol
38344	Vinyl Prep	Quart
40401	Zero VOC Surface Cleaner	Gallon
40404	Zero VOC Surface Cleaner	Quart
A38353	Aerospace Plastic & Leather Prep	Aerosol
39861	Plastic Adhesion Promoter	Gallon
39863	Plastic Adhesion Promoter	Aerosol
39864	Plastic Adhesion Promoter	Quart
77721	XXX Adhesion Promoter	Gallon
77723	XXX Adhesion Promoter	Aerosol
77724	XXX Adhesion Promoter	Quart

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16004	Sure-Coat Cross Linker	4 oz.
16754	Sure-Coat Reducer	Quart
A16808	Aerospace Sure-Coat Flattener	Pint
05500	Poly Brush Applicator	Each
70040	Sure-Coat Dauber Bottle	Each

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.