

23T3 Series Technical Data Sheet

Product Group	VOC compliant abrasion resistant coating. A two-component, PTFE-filled, anti-chafe, air curing, low VOC compliant topcoat. This coating is inherently light stable with excellent abrasion resistance and surface lubricity.		
Characteristics Product			
	23T3 Series topcoat is resistant engine oil, solvents, water and cle surfaces.	copcoat is resistant to phosphate ester hydraulic fluid, aircraft fuel, vents, water and cleaning compounds and is used on aircraft control	
Components	Base material	23T3-XXX	
1	Curing Solution	PC-216	
	Thinner	66C28, 66C20, TR-19, TR-20 or TR-115	
Specifications	Airbus Canada	A2MS 565-005, TYII A2MS 565-005, TYIII	
Qualified Product List	Boeing (BAC 700 and BAC 707 only)	BMS 10-86, Type I, Grade D	
	Boeing Mesa	HMS 15-1218	
	Bombardier	BAMS 565-005, Type II	
		BAMS 565-005, Type III	
	Bombardier/deHavilland	DHMS C4.08, Amend. 2	
	Embraer	MEP 10-071	
	Lockheed Martin	FMS 3120, Type I	
		5PTMRL40, Type I	
		LMA –MR008, Type I	
	Northrop Grumman	GC130RJ	
	Pratt & Whitney	PWA 36514	
	Shorts Brothers	SMS 93, Ty I	
	Ilyushin	ТИ756.18.618	

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Only 23T3-10 and 23T3-105 are qualified for BMS 10-86.

Product specifications are constantly changing, to ensure the most accurate information regarding specifications, please check our online qualified product list (QPL) at aerospace.akzonobel.com/products.

Surface Conditions

Cleaning

Sand pre-existing topcoats with 220 grit or equivalent sandpaper to a dull mat finish, and solvent clean prior to applying 23T3.

Instruction for Use

Π	Mixing Ratio	23T3-XXX	3 parts
!:n:n	(volume)	PC-216	1 part
<u> </u>		Thinner	*1 part

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.

Observe the overcoat window of the primer.

*Where VOC regulations allow and depending on temperature and humidity conditions, additional thinning may be made with 66C28, 66C20, TR-19, TR-20 or TR-115. Up to 1 part thinner may be used.



None.



Initial Spraying Viscosity (25°C/77°F)

Induction Time

16-24 seconds ISO Cup #6 15-25 seconds Signature Zahn Cup #3

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and the second s	Note	The use of Signature Zahn Cups for viscosity are requirements of the referenced specifications and the ISO Cup measurement is provided only as a reference for field application. They are not provided as quality control values.		
		Viscosity measurements are prov quality control parameters. Cer documentation available on reque	ided as guidelines only and are not to be used as rtified information is provided by certification est.	
	Pot life (25ºC/77ºF)	After 1 hour: 72 seconds ISO Cup After 2 hours: Sprayable	o #6	
1 μm	Dry Film Thickness (DFT)	125-250 μm 5 -10 mils		
Applicat Recomn	ion nendations			
Ő	Conditions	Temperature: Relative Humidity:	15-35°C 59-95°F 35-75%	
and the	Note	23T3 Series may be applied in o must be exercised to ensure a AkzoNobel Aerospace Coatings	conditions outside the limits shown above. Care satisfactory result. Please contact your local representative to determine the appropriate	

application techniques when environmental conditions fall outside of the

recommended range.

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	Equipment	Spray gun type	Nozzle orifice	Product flow	Dynamic air pressure at gun-inlet*
		Conventional	Gravity Feed: 1.4mm6 mm	N/A	Use enough Air Pressure. =100psi or<br (7 bar)
		Pressure Feed:	N/A		
		HVLP/ next generation	Gravity Feed: 1.4mm6 mm	N/A	Maximize and ensure uniform fan pattern, not to exceed regulatory
		Pressure Feed:	N/A		guideline for air pressure at the cap.
	Note	If roller applicatio Rollers will degrac	n is desired, us le and should be	e a fine finishing for changed every 30 mi	solvent-based products. nutes.
	Number of Coats	Apply full wet coat 75 µm (2-3 mils) d	s, allowing 15 mi Iry per coat.	nutes to flash off betw	reen coats, to achieve 50-
5	Cleaning of Equipment	MEK, TR-19, or C	28/15.		
	Note	The quality of the equipment chose application area. When applying the prepared to ident performance and a	e application of n and the temp e product for the f ify the best equ appearance of th	all coatings will be berature, humidity, an first time, it is recomm ipment settings to be e coating.	influenced by the spray nd air flow of the paint ended that test panels be e used in optimizing the

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Physical Properties

	Drying Times	Dust free	1.5-2 hrs	
	(23 C777 1, 55% RH)	Tack free	3.25-3.5 hrs	
		Dry through	5.25 hrs	
		An accelerated cu been achieved, fla 50% RH. Cure for	re schedule may be used. Once the required film thickness dry the applied coating a minimum of one hour at 75°F two hours at 150°F (66°C), with good air movement.	ess has (24°C),
M ²	Theoretical Coverage	4.24 m ² per liter re 173 ft ² per US gall	eady to apply (without thinner) at 125 µm dry film thickne Ion ready to apply (without thinner) at 5 mils dry film thicl	⊧ss. kness.
	Dry Film Weight	For 23T3-105: 1.31 g/m²/µm 0.00684 lbs/ft²/mil		
and the	Note	Varies slightly with	n color.	
VOC	Volatile Organic Compounds	Without thinner: Max. 420 g/l Max. 3.5 lbs/gal		
GU	Gloss (60°)	Maximum 65		
٩	Color	As required.		
			D	ana E af C

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	Flash-point	23T3-XXX	27°C / 80°F	
		PC-216	28°C / 78°F	
1		66C28	13°C / 55°F	
		66C20	-4°C / 25°F	
		TR-19	-4°C / 25°F	
		TR-20	7°C / 45°F	
		TR-115	-17°C / 1°F	
	Storage	Store the product dry and at a temperature between 5 and 38°C / 41 and 100°F per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature and shelf life may vary per OEM specification requirements. Refer to container label for specific storage life information.		
	Shelf life	23T3-XXX	12 months	
	5 - 38°C	PC-216	12 months	
	(41 - 100°F)	66C28	24 months	
	· · · · ·	66C20	24 months	
		TR-19	24 months	
		TR-20	24 months	
		TR-115	24 month	
Safety P	recautions	Comply with all I	ocal safety, disposal and transportation regulations. Check the	
-		Material Safety Data Sheet (MSDS) and label of the individual products carefully		

Issue date: October 2023 (supersedes September 2022) - FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is current prior to using the product. Brand names mentioned in this data sheet are trademarks of or are licensed to AkzoNobel.

before using the products. The MSDS's are available on request.

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