

A-A-3164

Flat Lacquer

A durable, pigmented, low gloss lead and chromate free lacquer for spray or brush application. It has good exterior durability. A-A-3164 features a "HAPS" free, low VOC formulation that conforms to air pollution regulations. This lacquer is specifically formulated as an aircraft finishing coating. The clear may be aluminized (12 ounces of TT-P-320D Aluminum Paste per gallon of clear) to obtain an excellent aluminum lacquer.

PHYSICAL DATA

Colour:	All 595 Colours
Gloss (60 degrees):	3 - 5
V.O.C.	420 g/L
Weight Solids:	40-50% Minimum
Dry to Touch:	Within 10 minutes
Dry Hard:	Within 40 minutes

ADVANTAGES:

- Fast dry
- Full colour Range, 595 Colours

Note: all physical and chemical resistance tests conducted after one week cure time at 20-25°C (70-75°F) on properly cleaned substrate.



SURFACE PREPARATION

Surface must be clean, dry and free of all contamination before application of gloss lacquer. Prime per specification requirements. Steel - Surface must be clean and free of all oil, grease and foreign material. Badly rusted or pitted steel should be cleaned by commercial sandblasting and primed the same day.



INSTRUCTIONS FOR Use

A-A-3164 should only be applied by spray application due to its fast dry properties. Thin up to one pint per gallon with MIL-T-81772B Ty. III thinner, or as needed for proper atomization with spray equipment. Do not reduce to a viscosity (#4 Ford Cup) of over 20 seconds. Spray one tack coat followed by one full wet coat. The use of MIL-C-8514C and TT-P-1757B Primers or other recommended lacquer resistant primers are normally required for use under this lacquer topcoat.



SAFETY PRECAUTIONS

Contents are FLAMMABLE.
Keep away from heat and open flame.
KEEP OUT OF THE REACH OF CHILDREN.
Do not take internally.
Avoid breathing vapor or mist.
Do not use in tank or pit without proper protection.
Read Material Safety Data Sheet before use of this product.



APPLICATION METHOD

Application Temp:	15°C - 35°C
Humidity:	10 - 75%
Induction Time:	N/A
Flash Off:	5 - 10 minutes
Force Curing:	140°F - 150°F (15 - 30 minutes)
Pot Life:	N/A
Spray Viscosity:	13 - 20 #4 Ford Cup



STORAGE & SHIPPING

Shelf Life:	12 months (unopened)
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