

63GN011G Low VOC Alkali Strippable Coating

TECHNICAL DATA SHEET

Product Description

63GN011G alkali strippable coating is a water-borne, single component temporary protective coating for use on aircraft and ground support equipment. 63GN011G can be applied on aluminum and metal substrates to protect aerospace parts during the manufacturing process or during transit. The service life of 63GN011G is 6 months for indoor or outdoor storage.

- Water-borne
- 0 VOC
- May be applied direct to aluminum
- Strips easily with BMS 15-12 Type II alkaline cleaner and water rinse

Components



Mix ratio (by volume):

- 63GN011G is a 1-component, ready to use product.

Note: Formulated to be applied as supplied, but may be reduced with de-ionized or distilled water. See mixing section for more details.

Specifications



63GN011G is qualified to:

- BMS 15-12 Type I Class 1

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Product Compatibility:

63GN011G can be removed with the following removers:

- Ardrex 6489A
- Ardrex 7050W
- Alkasol 27
- BMS 15-12 Type II removers
- SC-1101S

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Surface Preparation and Pretreatments



Substrate shall be solvent cleaned in accordance with BAC 5750 or water washed provided the substrate is free of dust, foreign particles, polish or oil.

Instructions for Use



Mixing Instructions:

Thoroughly stir the component. Do not use paint shaker. Hand mix material for no longer than 5 minutes.

63GN011G can be applied as is. If thinning is required, reduce with de-ionized or distilled water at a maximum of 3% by volume. Caution: Reduction may cause rapid viscosity drop, start by adding 0.5 to 1% by volume.

Note: It is important to condition coating for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 10° to 29°C (50° to 85°F). The minimum temperature of the paint components should be 16°C (60°F) prior to mixing.



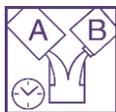
Induction Time:

Not Required



Viscosity: (23°C/73°F)

Not Applicable



Pot Life:

Not Applicable

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Application Guidelines

Recommended Application Conditions:

Temperature	10 - 29°C (50 - 85°F)
Relative Humidity	40 - 60%

Application:

Coating may be applied over properly cleaned and treated aluminum substrates as specified in the specification to meet all the requirements.

These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.



Theoretical coverage:

43 square meters/liter at 25 microns dry film (467 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 20 to 38 microns (0.8 to 1.5 mils)



Dry Film Density:

1.18 grams/cubic centimeter (9.84 pounds/gallon)

Dry Film Weight:

2.77 grams/square meter at 25 microns dry film (0.000567 pounds/square feet at 1 mil dry film)



Equipment:

63GN011G is compatible many types of spray equipment. See application section for equipment recommendations.

Equipment Cleaning:

Wash the spray equipment immediately with water. If any residue remains, flush with a water-soluble alcohol or ether.

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Physical Properties (product)



Color Green



Gloss Not Applicable



Dry Times	21 - 27°C (70 - 80°F)
Set to touch	20 minutes
Tack Free	45 - 60 minutes
Full Cure	7 days

Note: Dry times above were established at room (ambient) temperatures, 70° ± 10°F and 50% ± 10% relative humidity.

For dry to stack conditions only. Allow a minimum of 15 minutes flash off time at ambient temperatures prior to exposing painted parts to high temperatures. Complete testing should be done prior to use. Below are suggested starting points. Other variables may affect these cure schedules.

Temperature	Time
49°C (120°F)	45 minutes
60°C (140°F)	30 minutes

Note: Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% relative humidity.



VOC (EPA method 24):

63GN011G 0 grams/liter

Physical Constants:

Weight/gallon	8.72 pounds/gallon
% Solids by weight	32.6 %
% Solids by volume	29.5 %

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Flash Point closed cup:

Not Applicable

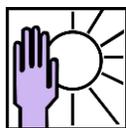
Shelf Life:

6 months from date of manufacture.

Note: Shelf life is provided for original, unopened containers

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored indoors at temperatures between 13°C to 32°C (55°F to 90°F) to ensure shelf life. This is a water-base compound and should be protected from freezing. Never allow this product to freeze. Do not expose to temperatures at or below 4°C (40°F) Once frozen, application and protective properties are unstable and not warranted.

Note: When procuring to a qualified material specification, follow those storage instructions.

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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

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ASC – Australia

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