

TT30 Exterior Acrylic Gloss Finish

Product Description

TT30 is a single pack, acrylic topcoat, suitable for aerospace applications. If required, TT30 can be removed using a suitable paint remover without detriment to the underlying primer.

- Quick drying
- Applicable directly to epoxy primed surfaces
- Designed for use on exterior surfaces of aircraft
- Suitable for use as touch up for damaged areas of aircraft paint systems
- Available in a wide range of colours

Components



Mix Ratio (by volume)

- Base: TT30 1 part
- Thinner: T142 (general use) 1 part (approx.)
or
- Thinner: T615 (Def Stan specified thinner) 1 part (approx.)

Specifications



TT30 is qualified to:

- Def Stan 80-214

Product Compatibility

TT30 is compatible with the following primer specification:

- BS 2X33A+B

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

Surface Preparation and Pretreatment



Ensure surface to be coated is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended. Observe recommended overcoating windows for primers.

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Instructions for Use



Thoroughly stir or shake the base to ensure all components are adequately dispersed. Add the required volume of appropriate recommended thinner type to the base and stir thoroughly.

The amount of thinner may be varied to suit local conditions and equipment.

Note: All products and components should be placed in ambient conditions of 15 -30°C (59-86°F) for at least 24 hours prior to mixing and application.



Induction Time:

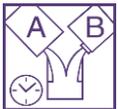
Not Required



Viscosity: (thinned ready for use 23°C/73°F)

• AFNOR4	15 - 24 seconds
• BSB3	26 - 43 seconds
• BSB4	15 - 25 seconds
• FORD4	12 - 21 seconds
• ISO4	18 - 43 seconds
• ZAHN2	16 - 28 seconds

Note: Viscosities quoted are typical ranges obtained when using specified mix ratio.



Pot Life:

Not Applicable

Application Guidelines

Recommended Application Conditions:

Temperature	10 - 35°C (50 - 95°F)
Relative Humidity	20 - 85%

Application:

Apply 2 double track coats to achieve the recommended dry film thickness of 20 - 30 µm allowing a minimum of 15 minutes between coats..



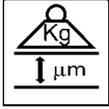
Theoretical Coverage: (ready for use)

4 m²/Lt @ 25 µm dry film thickness
160 ft²/US gal @ 1.0 mil dry film thickness

Recommended Dry Film Thickness:

20 - 30 µm
0.8 - 1.2 mil

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Dry Film Density:

Black: 1.17 g/cm³ (9.77 lbs/US gal)
White: 1.50 g/cm³ (12.5 lbs/US gal)

Dry Film Weight:

29 - 38 g/m² @ 25 μm dry film thickness
0.006 - 0.008 lbs/ft² @ 1.0 mil dry film thickness

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

Equipment:



Equipment Type	Tip Size	Air Pressure
Conventional Air Spray	1.5mm	40 to 60 psi (2.7 to 4.1 bar)



TT30 can also be brush applied (no thinner required)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto[®] CN20 or Desoclean 45[™] solvent cleaners are recommended.

Physical Properties



Colour:

Wide range of colours available



Gloss:

> = 45 units with a 60° gloss meter

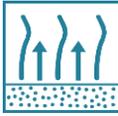


Drying Times:

Drying Times 50% R.H.	23°C (73°F)	70°C (158°F)
Dry to Overcoat	15 minutes	
Hard Dry	2 hours	
Full Cure	7 days	1 hour

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

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**Flash Off Time:**

15 - 30 minutes prior to force dry.

**VOC: (ASTM)**

Mixed (1:1 by volume mix)	775 - 785 g/Lt
TT30 Base Component	670 - 680 g/Lt
T142 Thinner	890 g/Lt
T615 Thinner	875 g/Lt

**Flash Point:**

TT30 Base Component	-18°C (-0.4°F)
T142 Thinner	4°C (39°F)
T615 Thinner	-4°C (25°F)

Shelf Life:

TT30 Base Component	24 months in original unopened container
T142 Thinner	10 years in original unopened container
T615 Thinner	10 years in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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 at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

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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