

RECC™ 3021 Chrome-Free Conversion Coating

Product description

RECC™ 3021 is a patented, chrome-free, conversion coating for aluminum alloy surfaces. It provides corrosion protection and a surface for paint film adhesion.

- Free of chromates and other chromium compounds
- Single package, aqueous solution designed for spray application to aluminum alloy surfaces
- Used with RECC™ 1015 Chrome-free Deoxidizer

Components



Mix ratio (by volume):

RECC 3021

Single component

Specifications



RECC 3021 is listed on the following:

- F-15 Technical Order 1F-15A-23
Rev 28

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

Surface preparation and pretreatments



Refer to application guidelines section of this document.

Instructions for use



Mixing instructions:

Single component. Stir before use.

Note: It is important to condition the product for 24 hours prior to use by placing in the shop or hangar, with ambient temperatures between 13° and 35°C (55° to 95°F). The minimum temperature of the product should be 13°C (55°F) prior to using.

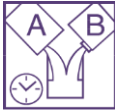
RECC™ 3021 Chrome-Free Conversion Coating

**Induction time:**

Not applicable

**Viscosity:** (23°C/73°F)

Not applicable.

**Pot life:**

Not applicable

Application guidelines

Optimum recommended application conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

Application:

- Clean and deoxidize the aluminum alloy surface with *RECC 1015*. Refer to the respective product information sheets.
- Adequately rinse surface using room temperature DI, RO, or Tap water.
- Apply *RECC 3021* in a well-ventilated area with adequate airflow.
- Spray apply *RECC 3021* to a break-free, clean and deoxidized surface (deoxidized using *RECC 1015*) until surface is adequately saturated.
- Keep surface saturated with *RECC 3021* for five minutes, reapplying as needed to keep treated surface wet.
- After application, do not rinse.
- Allow treated surface to air dry in a well-ventilated area with adequate airflow.
- Apply primer to the *RECC 3021* conversion coating treated surface following the appropriate dry-to-prime window.
- Apply topcoat to the primer following the appropriate dry-to-topcoat window.

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

**Equipment:**

RECC 3021 can be applied with a plastic spray wand.

Equipment cleaning:

Clean equipment and tools with water.

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Physical Properties (product)



Color Clear



Gloss Not applicable



Dry times:

- Refer to application guidelines section of this document.



VOC:

RECC 3021

0 grams/liter



Flash Point closed cup:

RECC 3021

Not applicable

Shelf Life:

12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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 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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ASC – Australia

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Fax 81 561 35 5201

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Fax 65 6861 6162

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1 (818) 362-6711 or 1-800-AEROMIX

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This document has been reviewed by the PPG Aerospace Export Control Department and has been determined to contain only EAR99 controlled data

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