

DuPont Aviation Finishes Product System

Products	Components	Mix Ratio	VOC	Additives	HVLP Gun Setup & Fluid Delivery	Flash / Dry Times
Epoxy Pre-Treatment	DuPont™ 13238S™ Epoxy Pre-Treatment DuPont™ 13138S™ Pre-Treatment Activator	1 Part Primer 1 Part Activator	5.0	None	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	10 min. to touch 30 min. to prime 1 med wet coat
	DuPont™ Corlar® 13550S™ Corrosion-Resistant Epoxy Primer DuPont™ 13150S™ Activator DuPont™ 13756S™ VOC Exempt Reducer	3 Parts Primer 1 Part Activator 2 Parts Reducer	2.8	Up to 1 oz 13813S™ per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	30 min induction time 10 hour pot life 30 min to touch; 2 hrs to topcoat 1 med coat
Primers	DuPont™ Corlar® 13580S™ Non-Chromate Epoxy Primer DuPont™ 13180S™ Activator DuPont™ 13756S™ VOC Exempt Reducer	4 Parts Primer 1 Part Activator 1 Parts Reducer	2.7	Up to 1 oz 13813S™ per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	30 min induction time 10 hour pot life 30 min to touch; 2 hrs to topcoat 1 med coat
	DuPont™ Corlar® 13580S™ Epoxy Surfacer DuPont™ 13180S™ Activator DuPont™ 13756S™ VOC Exempt Reducer	4 Parts Primer 1 Part Activator 0.5 Part Reducer	2.1	Up to 1 oz 13813S™ per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 14-18 oz/min	30 min induction time 8 hour pot life 30 min to touch; 2 hrs to topcoat 2 coats w/ 45 min flash
Surfacers	DuPont™ URO® 13520S™ Urethane Surfacer DuPont™ 13100S™ Activator	4 Parts Primer 1 Part Activator	2.4	2 oz of 13803S™ per RTS gal. 1 oz of 13808S™ per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.5 mm 8-10 oz/min	No induction; 1 hour pot life 30 min to touch w/13803S 1 hour to sand w/ 13803S 1 cross coat
	DuPont™ Imron® AF3500™ (solid colors only) DuPont™ 13110S™ Activator DuPont™ 1386xS™ Pot life Extenders DuPont™ 1376xS™ VOC Exempt Reducers	2 Parts Topcoat 1 Part Activator .25 Part Pot life Ext. .25 Part Reducer	3.5	1 oz of 13803S™ or 13808S™ per RTS gal. 1 oz of 13813S™ or 13814S™ anti crater per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 10-12 oz/min.	8 hour pot life 1 med wet coat 15-45 min flash 2nd coat is a wet cross coat
Single Stage	DuPont™ Imron® AF400™ (solid and metallic colors) DuPont™ 13100S™ Activator (solid or metallic colors) DuPont™ 13110S™ Activator (solid colors)	3 Part Color 1 Part Activator	3.4	2 oz of 13801S™ or 13803S™ per RTS gal. 1 oz of 13808S™ per RTS gal. 1 oz of 13813S™ or 13814S™ anti crater per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 8-10 oz/min.	2 hour pot life 1 med wet coat 5- 15 min flash 2nd coat is a wet cross coat
	DuPont™ Imron® AF700™ (solid, metallic & pearlescent colors) DuPont™ 13100S™ Activator After Activation, check viscosity using Zahn #2. 17-21 seconds Add 13775S™ reducer as needed	3 Part Color 1 Part Activator	3.4	2 oz of 13801S™ or 13803S™ per RTS gal. 1 oz of 13808S™ per RTS gal. 1 oz of 13813S™ or 13814S™ anti crater per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 10-12 oz/min.	2 hour pot life 1 cross coat Tape 7 hours w/ 2 oz 13803S™ Tape 3 hours w/ 1 oz 13808S™
Basecoat Clearcoat	DuPont™ Imron® AF740® Skydrol Resistant Clearcoat DuPont™ 13110S™ Activators DuPont™ 13930S™ Reducer	3 Part Clearcoat 2 Parts Activator 0.5 Reducer	3.4	2 oz of 13801S™ per RTS gal. 1 oz of 13803S™ per RTS gal. 1 oz of 13813S™ or 13814S™ anti crater per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 8-10 oz/min.	2 hour pot life 1 cross coat Tape 8 hours w/ 2 oz 13803S™
	DuPont™ Imron® AF740® Non-Skydrol Resistant Clearcoat DuPont™ 13100S™ Activators	3 Part Clearcoat 1 Parts Activator	3.4	2 oz of 13801S™ or 13803S™ per RTS gal. 1 oz of 13813S™ or 13814S™ anti crater per RTS gal.	Pressure- 1.0 to 1.4 mm Siphon - 1.0 to 1.4 mm Gravity - 1.2 to 1.6 mm 8-10 oz/min.	2 hour pot life 1 cross coat Tape 8 hours w/ 2 oz 13803S™
Clearcoat	DuPont™ 13225S™ Clear Filler-Sealer DuPont™ 13125S™ or 13127S™ Activator	4 Part Clearcoat 1 Parts Activator	4.8	Flame retardant is typically added at 4-7% by volume. Burn test part or surface to determine appropriate amount of flame retardant. Flame retardant will increase dry times.	Pressure- 1.2 to 1.6 mm Siphon - 1.2 to 1.6 mm Gravity - 1.2 to 1.6 mm 10-12 oz/min.	30 min pot life 3 coat process is recommended 1 med coat; 3- 5 min flash Repeat for coats 2 and 3
	DuPont™ 13225S™ Clearcoat DuPont™ 13125S™ or 13127S™ Activator	4 Part Clearcoat 1 Parts Activator	4.2	Flame retardant is typically added at 4-7% by volume. Burn test part or surface to determine appropriate amount of flame retardant. Flame retardant will increase dry times.	Pressure- 1.2 to 1.6 mm Siphon - 1.2 to 1.6 mm Gravity - 1.2 to 1.6 mm 10-12 oz/min.	2 hour pot life Recommend 3 coat process 1 med coat; 3- 5 min flash Repeat for coats 2 and 3
Cabin Finishes						

