

Approvals and conformities

LOCKHEED MARTIN	STMK794, 1425PD0207, 1854157, LAC-37-4462-001, MAP-CK10787-2000
ADCOLE	A26364
ATK	COMS-0008
BAE SYSTEMS	8357819
BEI	6430006102
BOEING	52841092, BMS10-90, SCGMS56016
CMC Electronics	635907-2
Cobham	8536-9617
DDES Corp	AM400000-450
Delco Systems	7570403
EDO Corp	55-118
Fairchild	501C7528
GOODRICH	HPA0200C
Harris	2003693, 2011362
HONEYWELL	FMC8362-01, P8251333
ITT, Space Systems	1138681, 400-3093, 561414
Kearfott	Y122A013
L3 Communications	B185239, N500045
L3 Telemetry West	16130052
Loral	020054, LMS 70412
Motorola	11P34023D
NORTHROP GRUMMAN	53825EL
Raytheon	HMS 2363, HMS15-2135, SM80004
REMEC	500470
Collins Aerospace (formerly Rockwell Collins)	KBO 125-001, SP275
Swales Aerospace	SAI-SPEC-936
Teledyne Systems	7508031
TRW	C600191-1

Aeroglaze® Z306 coating is an absorptive polyurethane coating designed for application on substrates used in aerospace operations. These operations include those where coatings must exhibit low outgassing characteristics while providing high thermal absorptivity properties. Aeroglaze Z306 coating cures to a flat black finish.

Features & Benefits

- **Low Outgassing:** exhibits low gassing properties in high vacuum environments.
- **Durable:** provides mechanical properties required for rigorous durations in space; provides excellent performance on rigid or flexible substrates.
- **High Thermal Absorptivity:** provides thermal absorptivity for applications where superior heat absorption is required.

DIRECTIONS FOR USE

Surface Preparation

Thoroughly clean surfaces to remove all dust, oil and grease. For most substrates, apply primer to ensure proper adhesion and performance of the coating. Contact your SOCOMORE representative for recommended Aeroglaze primer required for your application.

Mixing

Before opening container, thoroughly mix coating using a paint shaker for 5 minutes. Open the lid carefully as the container may be under slight pressure. Stir coating with a clean paint stick to check for any settled material and ensure mixture is homogeneous. If material has settled, return closed container to the paint shaker and shake an additional 5 minutes or until no settling is apparent.

Dilute coating with 15-20% Aeroglaze 9958 thinner, by volume, to a Zahn Cup #2 viscosity of 18-22 seconds.

Application

Apply coating by HVLP or airless spray equipment. Aeroglaze Z306 coating is best applied at 13-35°C (55-95°F), with substrate temperatures at least 2.8°C (5°F) above the dew point.

Apply Aeroglaze Z306 coating at a maximum thickness of 25 dry micron or 100 wet micron (1 dry mil or 4 wet mil) per coat. Typical dry film thickness of Aeroglaze Z306 coating should be approximately 38.1-50.8 micron (1.5-2.0 mil).

Hold the gun at right angles to the surface, approximately 20.3-30.5 cm (8-12 in) away, and apply with a 50% overlap. A light mist coat should be applied, followed by a full wet coat of 76.2-101.6 wet micron (3-4 wet mil). Coverage rate is 9.3 m²/L (368 ft²/gal).

Curing

Aeroglaze Z306 coating cures by reacting with moisture in the air. Cure rate is dependent on the temperature, relative humidity and amount of air circulation needed to remove the solvent.

Under the acceptable curing conditions, the coating will develop its ultimate properties in approximately 7 days. Lower temperatures and humidities will retard cure, while higher temperatures

and humidities may cause bubbling.

Aeroglaze Z306 coating cures to a tack-free surface in 2-3 hours at 25°C (77°F) and 50% relative humidity. Room temperature cure times of 12 hours permit handling; 36-48 hours permit normal usage.

Aeroglaze Z306 coating may be recoated after the first application within 3 hours minimum and 24 hours maximum. Recoat time is dependent on temperature and humidity. High temperature and humidity promote fast cure while low temperature and humidity slow down the cure. In high temperature and high humidity conditions, recoat within 8 hours to prevent intercoat adhesion failure.

If the maximum recoat time is exceeded, the surface must be roughened by sanding with fine sandpaper before recoating.

Cleanup

Use Aeroglaze 9958 thinner to clean equipment. Do not use lacquer thinners, water or solvents containing alcohols.

TECHNICAL CHARACTERISTICS

Typical Properties*

Property	Value
Appearance	Black Liquid
Viscosity, cps @ 25°C (77°F), ASTM D 2196-86, Brookfield LVT	50-250
Density, ASTM D 1475-85	0.92-0.97 g/L (7.7-8.1 lb/gal)
Solids Content by Weight, ASTM D 2369-87 modified	26-29%
Flash Point (Seta), ASTM D 3278-82, Closed Cup	19°C (67°F)
Volatile Organic Content (VOC), ASTM D 3960-87	677 g/L (5.65 lb/gal)
Outgassing**, ASTM E 595-77	1.0% TML***, 0.02% CVCM****
Gloss @ 85°	15 maximum

**Data is typical and not to be used for specification purposes*

*** 40 day cure at room temperature*

****Total Mass Loss*

*****Collected Volatile Condensable Materials*

PRECAUTIONS FOR USE AND STORAGE

Shelf life is one year from date of shipment when stored in original, unopened container. Store indoors away from heat, sparks and open flames. To maintain product freshness, keep container closed when not in use and nitrogen purge after opening if possible.

Before using this or any SOCOMORE product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Limitations

Not for immersion service. Do not apply to wet or damp substrates.

Manufactured for SOCOMORE by: LORD Corporation, Saegertown, PA

This technical data sheet replaces and cancels the previous one.

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