

#### Approvals and conformities

Dept of Navy

6237219, JCM-14352-003

Aeroglaze® Z3480 coating is a single-component polyurethane coating designed for use on properly prepared and primed metal surfaces in regions requiring a VOC below 335.8 g/L (2.8 lb/gal).

#### Features & Benefits

- **Environmentally Preferred:** provides VOC less than 335.8 g/L (2.8 lb/gal).
- **Easy to Apply:** can be applied by airless or HVLP spray equipment.
- **Durable:** provides good flexibility with excellent resistance to abrasion and impact.

### 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

Thoroughly mix Aeroglaze Z3480 coating prior to application using a paint shaker or air-driven hand mixer. Due to varied VOC limitations in regions, thinning is not recommended. Consult local VOC regulations to determine if limitations apply. If thinning is necessary and not restricted by VOC limitations, use Aeroglaze 9958 thinner.

Since Aeroglaze Z3480 coating cures by reacting with moisture in the air, remove only the amount of coating to be used at one time from the original container. While applying the coating, spray container should not be exposed to the atmosphere for any length of time.

#### Application

Apply coating by airless or HVLP spray equipment. Aeroglaze Z3480 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 a light mist (tack) coat followed by a full wet coat. Wet film thicknesses exceeding 76.2 micron (3 mil) [dry film exceeding 45.7 micron (1.8 mil)] should be avoided, as bubbling may result.

#### Curing

Aeroglaze Z3480 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. Aeroglaze Z3480 coating cures to a tack-free surface in 2-4 hours at 25°C (77°F) and 50% relative humidity.

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 Z3480 coating may be recoated after the first application has cured to a tack-free surface. For maximum intercoat adhesion, recoat 18-24 hours after initial application. High temperature and humidity conditions will shorten the maximum recoat time. 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	Gray Liquid
Viscosity, cps @ 25°C (77°F), Brookfield LVT, Spindle #2, 30 rpm, ASTM D 2196-86	130-300
Density, ASTM D 1475-85	1.19-1.22 kg/L (9.9-10.2 lb/gal)
Solids Content by Weight, ASTM D 2369-87 modified	72.6-75.6%
Flash Point (Seta), ASTM D 3278-82, Closed Cup	33°C (92°F)
Volatile Organic Content (VOC), ASTM D 3960-87	310 g/L (2.58 lb/gal)

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

## 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. After opening and while removing contents, protect coating from excessive exposure to moisture by using dry nitrogen as an inert cover. Do not leave container open.

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.
- Coating may discolor on exposure to UV light; may chalk on long term exterior exposure.
- Aeroglaze Z3480 coating contains aromatic isocyanate monomer. Spray only in properly ventilated areas with recommended respiratory protection.

Manufactured for SOCOMORE by: LORD Corporation, Saegertown, PA

**This technical data sheet replaces and cancels the previous one.**

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as Socomore deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.

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