AkzoNobel
Aerospace Coatings

Eclipse®
ECL-G-857
Polyurethane Diamond Ice Mica Base

AkzoNobel
Tomorrow's Answers Today

Product Group

VOC compliant polyurethane Mica Intermediate coat for three coat application of:
ECL-G-11XXX
ECL-G-857
ECL-G-2 or ECL-G-7

Characteristics

Product Information

- A chemically cured, long life mica base coat designed to provide a uniform metallic appearance. This coating has a balanced formulation to provide superior chemical and stain resistance, flexibility and weathering performance. When used with AkzoNobel Aerospace Coatings primers 10P20-44MNF (BMS 10-72 Type IX) or 10P20-12 (DMS 2104), the corresponding base coat for the required color and Eclipse Clear, ECL-G-2 or ECL-G-7 this system provides a durable long lasting, protective and decorative finish that exceeds typical OEM requirements for exterior aircraft performance.

Components

Curing Solution

Curing Solution PC-233

Specifications

Qualified Product List

Boeing	BMS 10-72, TY IX
Bombardier	BAMS 565-009, TY I, GR B
Bombardier/deHavilland	DHMS C4.04, TY 6, CL B, GR B
Embraer	MEP 10-069

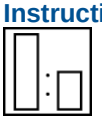
The complete AkzoNobel Aerospace Coatings qualified product list (QPL) can be found at: **www.akzonobel.com/aerospace**

Surface Conditions

Cleaning

Surface pretreatment is an essential part of the painting process.

Instruction for Use



Mixing Ratio (volume)

2 parts	Base ECL-G-857
1 part	Curing Solution PC-233

- Stir or Shake until all pigment is uniformly dispersed before adding curing solution.
- Stir the catalyzed mixture thoroughly.

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

Internet: www.akzonobel.com/aerospace

Eclipse®
ECL-G-857
Polyurethane Diamond Ice Mica Base

Induction Time	15 minutes
Initial Spraying Viscosity (25°C/77°F)	17 – 23 seconds Zahn-Cup 2
Note	Viscosity measurements are provided as guidelines only and are not to be used as quality control parameters. Certified information is provided by certification documentation available on request.
Pot Life (25°C/77°F)	3 hours.
Dry Film Thickness (DFT)	**Solid base coat only** 25 – 46 microns (µm) 1.0 – 1.8 mils **Intermediate mica coat only** 38 – 46 microns (µm) 1.5 – 1.8 mils

Application Recommendations

Conditions	Temperature:	15 – 35°C 59 – 95°F
	Relative Humidity:	35 – 75%
Note	The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.	
Equipment	Air	055-.072 mm nozzle orifice
	HVLP	1.4-1.8 mm nozzle orifice
	Air spray Electrostatic	1.4-1.8 mm nozzle orifice
	Airless Electrostatic	Not recommended
Number of coats	Apply in a cross coat pattern (2- 3 coats) of material to a wet film thickness of 3.0-3.5 mils to result in a dry film of 1.5-1.8 mils	

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

Internet: www.akzonobel.com/aerospace

Cleaning of Equipment	Solvent Cleaning C28/15 or TR-15 (electrostatic equipment) Solvent Cleaning C28/15 or TR-19 for other spray equipment.

Physical Properties

Drying Times (25 +/- 2ºC / 77 +/- 2ºF, 55 +/- 5% RH)	Dry to dust	4-5 hours
	Dry to tape	N/A
	Full cure	This coating must be clear coated before full cure is established
	Recoatable minimum	1 hour
	Recoatable maximum	24 hour
Note Drying Times	Time between basecoat and mica coat: 2 hours or dry to touch (no transfer) Flash time between Coats: 30-45 minutes	
Theoretical Coverage	20.7 m^2 per liter ready to apply at 25 µm dry film thickness 844 ft^2 per US gallon ready to apply at 1 mil dry film thickness	
Dry Film Weight	30.9 g/m^2/25 micron 0.006 lbs/ft^2/1 mil	
Volatile Organic Compounds	Max 420 g/l Max 3.5 lb/gal	
Gloss (60º)	Gloss can only be measured once the clear coat is applied to the material, using a conventional 60 degree gloss meter will not give consistent accurate readings	
Color	Diamond Ice Mica BAC 51470	

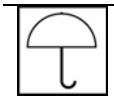
AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

Internet: www.akzonobel.com/aerospace

Eclipse®
ECL-G-857
Polyurethane Diamond Ice Mica Base

Flash-point

ECL-G-857	12ºC / 54ºF
PC-233	166ºC / 330ºF



Storage

Store the product dry and at a temperature between 5 and 38ºC / 40 and 100ºF per AkzoNobel Aerospace Coatings specification. Store in the original unopened containers. Storage temperature may vary per OEM specification requirements. Refer to container label for specific storage life information.

Shelf life
5 - 38°C
(40 - 100°F)

24 months per AkzoNobel Aerospace Coatings commercial specification. Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.

Issue date: June 2012 (supersedes November 2009) - FOR PROFESSIONAL USE ONLY

AkzoNobel Aerospace Coatings
1 East Water Street, Waukegan, IL 60085, USA - Phone (847) 623 4200, Fax (847) 625 3200
Rijksstraatweg 31, 2171 AJ Sassenheim, The Netherlands - Phone (31) 71 308 2905, Fax (31) 71 308 2056

Internet: www.akzonobel.com/aerospace