

**MIL-PRF-85285E Polyurethane Topcoat – Type 4, Class H - Gloss**

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component high solids polyurethane topcoat with a maximum VOC of 3.5 lbs/gallon (420 grams/liter). This product is specifically formulated for aircraft applications requiring extended weatherability.</p> <p>Qualified under MIL-PRF-85285E.</p> <p>This product may be used as a topcoat over MIL-PRF-23377 or MIL-DTL-53022 primer depending on substrate.</p> <p>Randolph Products Co. warrants that its Products meet its internal specifications and are of merchantable quality. However, the purchaser is solely responsible for the suitability of the product for any particular application. The purchaser should thoroughly test or qualify the product for serviceability, environmental compliance and health and safety factors prior to use. Further, our total liability is limited to the price of the product or replacement in kind.</p> <p>Randolph Products Company  33 Haynes Circle  Chicopee, MA 01020  Phone: 413-592-4191  Fax: 413-594-7321  www.randolphproducts.com</p>	<ol style="list-style-type: none"> <li><b>1. Color:</b> SAE-AMS-STD-595/Fed. Std 595 Colors 1XXXX</li> <li><b>2. Volume Solids:</b> 55 - 59% (varies by color)</li> <li><b>3. Solids by Weight:</b> 72 - 74% (varies by color)</li> <li><b>4. Viscosity:</b> 30 seconds max. #4 Ford Cup</li> <li><b>5. DFT:</b> 1.7 – 2.3 mils</li> <li><b>6. Theoretical Coverage @ 1 mil dft:</b> 882 - 946 ft<sup>2</sup>/gallon (varies by color)</li> <li><b>7. Gloss @ 60°</b> 90 minimum</li> <li><b>8. Dry Time</b> Set to Touch: 6 hours max. Dry Hard: 12 hours max. Complete Cure: 14 days</li> <li><b>9. Pot Life</b> 4 hours minimum</li> <li><b>10. Mix Ratio</b> 3:1 by volume 3 parts Component A 1 part Component B (852854-1CBGL)</li> <li><b>11. VOC</b> 2.1 lbs/gallon (208 grams/liter)</li> <li><b>12. Shelf Life</b> One year from date of manufacture</li> </ol>	<p><b>Steel:</b> Apply over MIL-DTL-53022 primer. Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p><b>Aluminum:</b> Apply over MIL-PRF-23377 primer. Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p><b>Galvanized and other metals:</b> Apply over MIL-PRF-23377 primer.</p> <p><b>Reduction:</b> Reduce with MIL-T-81772 Type 1 as required. Do not exceed VOC limits.</p> <p><b>Conventional Spray:</b> Atomizing Pressure: 45 – 55 psi Pot Fluid Pressure: 10 – 20 lbs.</p> <p><b>Airless Spray:</b> Tip Size: 0.011 – 0.015” orifice Atomizing Pressure: 1800 - 2200 psi</p> <p><b>Clean-up:</b> Clean tools and equipment immediately after use with MEK, MAK or MIL-T-81772 Type 1 thinner.</p> <p><b>Safety Precautions:</b> This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>