



## AIROCRIL GREEN

Product Number 989-6601

### **Product Description:**

Airocrl Green is a temporary dissolvable protective coating used for the protection of aluminum aircraft components during assembly and transit. This low VOC water based product has been specially designed for the protection of all types of aircraft surfaces. The acrylic blend allows excellent hardness and slip for protection of abrasion during manufacturing and handling of parts. Airocrl Green also provides excellent exterior weatherability and protects from water spotting and environmental contamination.

### **Application Information:**

Airocrl Green should be spray applied as received with no thinning required. Airocrl Green should be stirred with moderate agitation for several minutes prior to application, or if this has not been done within the past 12 hours. Product should be stirred and not shaken. Do not shake material as this will produce air bubbles in the coating. Airocrl Green should be protected from freezing with applications made at ambient room temperatures no lower than 65° F.

The preferred spray equipment is a Graco Air Pro HVLP compliant spray gun. The spray cap should be a #315 and the internal orifice should be .055 to .070. Air pressure at the gun inlet should be approximately 40 lbs. PSI, in accordance with the Graco Air Pro HVLP compliant spray gun manual. The maximum level is 10 PSI allowable at the air cap for HVLP guns. This PSI requirement should be validated. Fluid pressure should be approximately 35 to 40 lbs. PSI. Recommended wet film build is 5 to 6 mils to achieve approximately 1 mil dry film. The 5 to 6 mils is applied in one smooth application pass. Airocrl Green is approximately 33% volume solids.

The preferred spray equipment for HVLP spray applications is the Graco Air Pro HVLP compliant spray gun, Part #234649. For pressure-feed spray guns, use 70 to 80 pounds of air inlet pressure, 40 pounds fluid pressure, and 40 to 45 pounds gun inlet air pressure. The 40-45 pounds of gun inlet pressure will achieve 10 pounds spraying pressure at the spray tip. Use a #315 spray cap with a .055 internal orifice. To set up this gun, always adjust air pressure inlets first, then adjust fluid and spray pattern. Apply wet film 5 to 7 mils wet.

Airocrl Green will air dry in 30 minutes to 1 hour or may be dried in an oven. Clean up is with soap and water only.

GROCO SPECIALTY COATINGS  
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### Removal of Airocril Green:

The removal of the Airocril Green series is dependent upon conditions, type of removal process and mil thickness of the coating. For **production removal** use TRANSSEAL® HWAS SS Gel Remover with a commercial pressure washer system. Apply HWAS SS Gel Remover to the surface liberally and allow to stand approximately 10 to 15 minutes or until the surface is totally wet, then high pressure wash the entire surface. For **in-house cleaning** wet area with remover wiping off any residue to achieve a clean substrate. This remover may also be used to remove grease, oil grime and dirt from surfaces to be painted. Always wipe surface clean before applying final paint finish. There are no silicone additives in this cleaner that might create problems when painting.

### Technical Information:

Non-Volatile Weight	37 % +/- 2
Non-Volatile Volume	33 % +/- 2
pH	7.25 - 8
Theoretical Coverage	529 sq. ft. @ 1 mil
VOC	1.79 lbs./gal. or 215 grams/liter
Thinning	Water
Clean up	Water and light soap
Spray equipment	Airless or Conventional
Boeing Spec	BMS-15-12, Type 1- Class 1

PRODUCT DATA

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