

Imron® Aviation Finishes Recommended Product System - ROTARY-WING AIRCRAFT

Substrate	Cleaner	Pre-Treatment	Direct to Metal Primer + Surfacer (Optional)	Body Color	Accent Stripes
Aluminum	Detergent Wash + Sontara® Wipe AND 3920S™ + Sontara® Wipe	High Copper Aluminums (2024-T3) 13204S™ Aluminum Cleaner + 13206S™ OR All Other Aluminums 13205S™ Aluminum Cleaner + 13206S™ Aluminum Conversion	Chromate Primer Corlar® 13550S™ Corrosion-Resistant Epoxy Primer + Optional Primer / Surfacer Corlar® 13580S™ Chromate Free Epoxy Primer	Top Coat Imron® AF400™ Polyurethane Topcoat OR Imron® AF700™ Polyurethane Basecoat + Imron® AF740™ Clearcoat	Imron® AF400™ Polyurethane Topcoat OR Imron® AF700™ Polyurethane Basecoat + Imron® AF740™ Clearcoat
Identify the type or grade of Aluminium so that the correct Aluminium cleaner can be selected	Ensure there is no residue or smearing left on the substrate before proceeding to the next step	Make sure the entire surface to be painted is treated and that neither product dries on the surface before being rinsed with clean fresh water	Observe induction times and application windows for both products	Check that the substrate is perfectly clean and free of any contaminants before applying top coats. Check that the spray equipment is as per TDS and adjusted correctly	Make sure the areas to be painted are properly abraded to ensure adhesion of the Accent Stripes
Composite	Sontara® Presaturated Wipes**	N/A	Corlar® 13580S™ Epoxy Surfacer	Same Options As Above	Same Options As Above