

# Sylka Y1 Series

## Waterborne Interior Topcoat



**Product** Sylka Y1 Series Waterborne Interior Topcoat

**Item Class** Specialty Coating

Sylka water reducible acrylic topcoat is specially formulated for use on aircraft cabin interior surfaces such as polycarbonates, composites, honeycomb, and plastics. It may be applied either as a smooth or textured finish. It offers a fast-dry time and is easy to apply. This product may also be used on leather substrates for touch up applications. It is resistant to scratches, certain light chemicals and normal passenger wear and tear.

**Specifications** Product is manufactured to meet the performance requirements of the following specifications:

14 CFR Part 25.853 (a) Amdt 23-62, 25-116 Appx F Part I, IV, V (a)(e) (1)(ii) - BSS 7239 (Toxicity)

**Surface Preparation** Proper surface preparation is essential to promote good adhesion. First clean substrate dry using a very fine scotch pad. Make sure to remove all dust and debris using a clean lint free cloth. Once complete, use isopropyl alcohol, acetone, naphtha, or other approved OEM solvent to remove remaining contaminants. Perform water break test to make sure no residues remain on the substrate.

**Mixing Instructions**

Base
Y11-XXXX (Gloss)
Y12-XXXX (Semi-Gloss)
Y13-XXXX (Flat)

Shake single component (Base) for 10-15 minutes. Since Sylka is a single component topcoat, no mixing is required. However, if desired this product can be diluted with distilled water up to 10% by volume. It recommended to filter product before pouring into application equipment.

**Spraying Viscosity** Gloss Colors: 17-19 Seconds with #2 Zahn cup, Semi-Gloss/Flat Colors: 19-22 Seconds with #2 Zahn cup

**Film Thickness** 1-1.5 MILS DFT (2 Coats @ 1-1.5 DFT) Wet film thickness should be 1.5-2 mils total between 2 coats

**Application Instructions**

Temperature and Humidity	Minimum	Maximum
Temperature Celsius	11°	35°
Temperature Fahrenheit	52°	95°
Humidity	33%	74%

# Sylka Y1 Series

## Waterborne Interior Topcoat



### Application Instructions

#### Spray Equipment

Spray Gun Type	Tip/Nozzle Size	Cap Pressure	Pot Pressure
Conventional Air	1.3 - 1.6 mm	40 to 60 psi	10 to 20 psi
HVLP	1.4 - 1.6mm	10 psi Maximum	10 to 20 psi
Electrostatic	1.2 - 1.5mm	45 to 60 psi	10 to 40 psi

#### Dry Times

Temperature (Min/Max)	Dust Free	Dry Hard	Full Cure
52-95°F (11-35°C)	10 Minutes	30 Minutes	72 Hours

#### Number of Coats:

Spray 2 to 3 coats to achieve desired film thickness. Sylka Y1 Series may also be applied using brush or roller application.

#### Reduction Instructions:

For smooth finish product should be reduced 10% utilizing distilled water.

For textured surface product should be applied "as is" with no reduction. Spray gun must be regulated to achieve desired textured pattern.

**Theoretical Coverage** 300-350 sq. ft / gallon @ 1 mil 8-9m<sup>2</sup> / liter @1 mil  
\*Coverage based on 100% transfer efficiency rate

**Color** Available in all color ranges

**Gloss** Gloss colors: 90 minimum @ 60 degrees  
Semi-Gloss colors: 17-30 @ 60 degrees  
Flat/Matt Colors: Less than 5 @ 60 degrees  
\*Also available in satin and custom match finishes

**Volatile Organic Compound** 290 – 338 g/l

**Shelf Life** 24 Months (When stored in climate-controlled environment between 60-80° F)  
\*Product may be re-certified upon inspection by 3Chem.

**Safety Instructions** Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

#### 3Chem Corporation Disclaimer

All information, recommendations, statements, and technical data contained herein are not intended to be comprehensive or exhaustive, but instead are based on tests utilizing present knowledge and current laws. The accuracy and completeness of said tests are in no way guaranteed, nor should they be construed as an express or implied warranty. We believe such information, recommendations, statements, and technical data to be reliable and accurate, but we have no control over the quality or the condition of the many factors affecting the use and application of the product. The user shall depend upon its/his/her own information, data and testing to determine whether the product is suitable for the user's intended use and the user assumes all risks and liability resulting from its/his/her use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller. All products supplied, and technical advice given is subject to our standard terms and conditions of sale. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

\*Brand names mentioned above are either trademarks of or licensed to 3Chem Corporation.