Tech Data Sheet

SF2200-1, SF2100-1, SF2000-1

Superflite Engine Enamels

Description

SF2200-1, SF2100-1, and SF2000-1 are enamels developed specifically for air cooled aircraft engines used in the light duty aviation industries.

Components

- SF2200-1 Black Engine Enamel
- SF2100-1 Lycoming Grey Engine Enamel
- SF2000-1 Continental Gold Engine Enamel

Mixing Ratio

Mix well before use. May be used as supplied or for best air spray add 10-15% enamel reducer by volume just prior to application.

Pot Life @ 77ºF

When properly covered at 77ºF, SF2200-1, SF2100-1, SF2000-1 will maintain a sprayable viscosity for an indefinite period of time.

Clean Up

Wash thinner with a conductivity in excess of 2000 picosiemens/meter. Thinner or reducers of low conductivity should be avoided as they present an increased risk of combustion via static ignition.

Suitable Substrates

- Properly treated steel or aluminum
- Epoxy Primers
- Etching Primer

Surface Preparation

- Wash surface with mild detergent and rinse with water. Dry surface.
- After drying, sand and featheredge surface where needed.
- Wipe with a post sanding cleaner following manufacturer's directions.

Application

Number of Coats:	1-3	
Application Density	Medium-wet to wet	
Overlap	50%	
Flash:	5- 10 min or until surface is dull	
Film Thickness Range:	*Dry*	1.0 mils - 3.0 mils
Application Conditions	*Minimum Temp*	50˚F (Substrate Temp.)
	Max Temp	100˚F (Substrate Temp.)
	Ambient Humidity	Less than 80% preferred

Manufactured in the U.S.A. exclusively for Aviation Products Systems, Inc./Superflite Division,
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SF2200-1, SF2100-1, SF2000-1
Superflite Engine Enamels

Spray Equipment Recommendations

Conventional Spray Equipment

Gravity Feed	1.4 - 1.8 mm tip
Siphon Feed	1.6 –2.0 mm tip

HVLP (High Volume Low Pressure) Spray Equipment

Anest Iwata LPH 400	1.5 - 1.9 mm tip
Binks MG1	1.5 – 1.9 mm tip
C.A. Technology	1.5 – 1.9 mm tip
Devilbiss GTI	1.5 – 1.9 mm tip
Geo 92 & 97	1.5 – 1.9 mm tip
Sagola 450G	1.5 – 1.9 mm tip
Sata NR 95 & 2000	1.5 – 1.9 mm tip

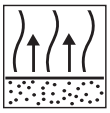
Air Pressures

Conventional (measured at gun)

	Panel Refinishing	*Overall Refinishing*
Gravity Feed	30-40 psi	40-50 psi
Siphon Feed	35-50 psi	50-65 psi

HVLP Spray Equipment (Measured at cap)

	Panel Refinishing	*Overall Refinishing*
HVLP	8-10 psi	10 psi



Flash/Dry Times

Ambient Application (Reported at 77ºF and 80% Humidity)

Flash Between Coats	5-10 minutes (allow to flash dull in gloss)
To Topcoat	30 minutes – 24 hours

Physical Data

		SF2200-1	SF2100-1	SF2000-1
Density (lbs/gal, unreduced)		8.69	8.69	8.61
Solids	*By Weight*	50.9%	51.4%	48.6%
	By Volume	41.1%	41.4%	38.6%
VOC (lbs/gal)		4.3	4.2	4.4
Ready to Spray VOC		4.7	4.7	4.7
Flash Point		45ºF	45ºF	45ºF
Theoretical Coverage (F^2/gal@ 1)		659	663	619
Heat resistant		Up to 450ºF	Up to 450ºF	Up to 450ºF

Safety

Before using any SuperFlite product be sure to read all MSDS, application instructions and warnings. Always wear a properly fitted air purifying respirator with organic cartridges and a particulate filter or a fresh air supplied respirator (depending on product selection), eye protection, gloves and protective clothing while exposed to any chemical.

Warning Statement

This product is intended for use by professionally trained painters only. Use as directed. The data presented herein was determined under our controlled conditions. Since environmental conditions play a large role in performance, variations in the data presented herein may be observed as environmental conditions change. This document does not constitute a warranty or guarantee of any kind. Use at your own risk.

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