



# Super Koropon® 515X333 Fluid Resistant Primer

## TECHNICAL DATA SHEET

### Product Description

Super Koropon® 515X333 fluid resistant primer is a chemical and solvent resistant epoxy coating used in areas exposed to hydraulic fluid.

- Compatible with epoxy topcoats
- Excellent adhesion and corrosion resistance
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

### Components



#### Mix ratio (by volume):

- 515X333 (base component) 1 part
- 910X350 (activator component) 1 part

### Specifications



515X333 primer is qualified to:

- 207-9-470
- GMS 5001

*Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.*

#### Product Compatibility:

515X333 primer is compatible with the following topcoat specifications:

- GAMPS 3205-1
- GMS 5002-1

### Surface Preparation and Pretreatments



Super Koropon® 515X333 primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

### Instructions for Use



#### Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well, maintain constant agitation for 10 minutes to ensure proper mixing.

# Super Koropon® 515X333 Fluid Resistant Primer

*Note: It is important to condition the paint for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 13° and 35°C (55° to 95°F). The minimum temperature of the paint components should be 13°C (55°F) prior to mixing.*



## Induction Time:

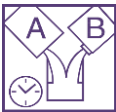
Not Required



## Viscosity: (23°C/73°F)

- |                         |                    |
|-------------------------|--------------------|
| • #2 Signature Zahn cup | 29 seconds maximum |
| • #4 Ford cup           | 22 seconds maximum |
| • ISO 4mm cup           | 45 seconds maximum |
| • BSB3 cup              | 47 seconds maximum |
| • BSB4 cup              | 26 seconds maximum |
| • AFNOR #4 cup          | 25 seconds maximum |

*Note: Viscosities quoted are the typical values obtained when using specified mix ratio.*



## Pot Life:

8 hours @ 21 - 25°C (70 - 77°F)

## Application Guidelines

### Recommended Application conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

### Application:

Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 15 to 23 microns (0.6 to 0.9 mils). This can be accomplished by one medium coat with a 50% overlap.

*These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.*

# Super Koropon® 515X333 Fluid Resistant Primer



**Theoretical Coverage:**

8 square meters/liter at 25 microns dry film (342 square feet/gallon at 1 mil dry film)  
Recommended dry film thickness; 15 to 23 microns (0.6 to 0.9 mils)



**Dry Film Density:**

1.88 grams/cubic centimeter (15.66 pounds/gallon)

**Dry Film Weight:**

47 grams/square meter at 25 microns dry film (0.00961 pounds/square feet at 1 mil dry film)



**Equipment:**

515X333 primer is compatible with all current forms of spray equipment.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm or 1.5 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Electrostatic Air Assisted Airless Spray Gun	#611 or #613 (Graco Nomenclature)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1 bar)
High Volume Low Pressure Spray Gun (HVLP)	1.0 mm to 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)

**Equipment Cleaning:**

Clean spray equipment as soon as possible after use. Flush spray equipment with DeSoto® CN20, DeSoto® CN44, or Desoclean™ 45 high performance solvent cleaner.

**Physical Properties (product)**



**Color:** Green



**Gloss:** Not Applicable



# Super Koropon® 515X333 Fluid Resistant Primer



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Tack Free	45 minutes	30 minutes	20 minutes
Dry to Tape	5 hours	4 hours	3 hours
Overcoat Time	5 - 48 hours	4 - 48 hours	3 - 48 hours
Full Cure	7 days	7 days	7 days

Accelerated cure to dry hard:

Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)  
followed by 30 minutes at 49°C (120°F)



## VOC:

Mixed, ready for use VOC (EPA method 24)	650 grams/liter
Base Component	498 grams/liter
Activator Component	795 grams/liter



## Flash point closed cup:

Base Component	6°C (42°F)
Activator Component	-6°C (22°F)

## Shelf Life:

12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

24 months from date of manufacture for PRC-DeSoto Standard.

*Note: Shelf life is provided for original, unopened containers.*

*Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.*

## Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

*Note: When procuring to a qualified material specification, follow those storage instructions.*



# Super Koropon<sup>®</sup> 515X333 Fluid Resistant Primer

## Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

**For industrial use only. Keep away from children.**

**Additional information can be found at: [www.ppgaerospace.com](http://www.ppgaerospace.com)**

**For sales and ordering information call the local PPG office at the numbers listed below:**

### **Asia Pacific**

#### **ASC – Australia**

Tel 61 (3) 9335 1557  
Fax 61 (3) 9335 3490

#### **ASC – Japan**

Tel 81 561 35 5200  
Fax 81 561 35 5201

#### **ASC – South East Asia**

Tel 65 6861 1119  
Fax 65 6861 6162

#### **ASC – Suzhou**

Tel (86-512) 6661 5858  
Fax (86-512) 6661 6868

#### **ASC – Tianjin**

Tel (86-022) 2482 8625  
Fax (86-022) 2482 8600

### **Americas**

1 (818) 362-6711 or 1-800-AEROMIX

### **Europe and Middle East**

#### **ASC – Central Europe**

Tel 49 (40) 742 193 10  
Fax 49 (40) 742 139 69

#### **ASC – Middle East & India**

Tel (971) 4 883 9666  
Fax (971) 4 883 9665

#### **ASC – North Europe**

Tel 44 (0) 1388 770222  
Fax 44 (0) 1388 770288

#### **ASC – South Europe**

Tel 33 (0) 235 53 43 71  
Fax 33 (0) 235 53 54 44

Desoclean, DeSoto, and Super Koropon are trademarks of PRC-DeSoto International, Inc.

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his 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.

PRC-DeSoto International, Inc.

12780 San Fernando Road  
Sylmar, CA 91342

[www.ppgaerospace.com](http://www.ppgaerospace.com)

Issue Date: 8/15  
Lit: 4168