



4185/3600M Celopox 2000SC Anti Corrosive Primer

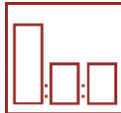
TECHNICAL DATA SHEET

Product Description

Celopox 2000SC is a chromate free epoxy primer of the A21-F61 scheme. Celopox 2000SC provides interior and exterior protection of equipment against corrosion without using W2 type etch primer.

- Chromate free, corrosion protection
- Conventional solids
- Excellent fluid resistance

Components



Mix Ratio (by volume)

- | | |
|--------------------------|--------------|
| • 4185/3600M (Base) | 2 parts |
| • 0646/9000M (Activator) | 1 part |
| • 0476/9000 (Thinner) | 0.5 - 1 part |

Specifications



4185/3600M is qualified with PU88 topcoats to:

- DAT C8010X0003

Product Compatibility

4185/3600M is compatible with the following primer / topcoat specifications:

- DAT C8010X0003
- Normdef 0003-1
- ECS 2261

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

4185/3600M Celopox 2000SC Anti Corrosive Primer

Surface Preparation and Pretreatment



Good surface preparation is essential to ensure full protective properties and maximum adhesion of coating is achieved. Ensure surface is cleaned, dry and intact using high performance solvent cleaner, DeSoto® CN20 or Desoclean™ 45 are recommended.

Instructions for Use



Material should be allowed to reach room temperature before mixing. Thoroughly stir or shake the base to ensure all components are adequately dispersed. Slowly add activator to base and stir. Add required amount of thinner while stirring.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.



Induction Time:

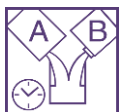
Not required



Viscosity: (23°C/73°F)

- | | |
|----------|-----------------|
| • AFNOR4 | 18 - 23 seconds |
| • BSB4 | 20 - 24 seconds |
| • FORD4 | 16 - 21 seconds |
| • ISO4 | 30 - 41 seconds |
| • ZAHN2 | 21 - 27 seconds |

Note: Viscosities quoted are typical ranges obtained when using specified mix ratio.



Pot Life:

8 hours @ 21-25°C (70-77°F)

Application Guidelines

Recommended Application Conditions:

Temperature	15-35°C (59-95°F)
Relative Humidity	20-70%

Application:

Apply fine cross coats until recommended dry film thickness is achieved.



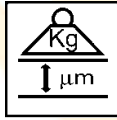
Theoretical Coverage: (unthinned)

15 m²/Lt @ 20 µm dry film thickness
600 ft²/US gal @ 0.8 mil dry film thickness

4185/3600M Celopox 2000SC Anti Corrosive Primer

Recommended Dry Film Thickness:

15 - 25 μm
0.6 - 0.8 (mil)



Dry Film Density:

1.37 g/cm³
11.41 lbs/US gal

Dry Film Weight:

27.4 g/m²
0.006 lbs/ft²

Equipment:



Equipment Type	Tip Size (mm)	Angle	Pressure
Air Assisted Spray Gun	1.4 to 1.8	-	43 to 72 psi (3 to 5 bar)
Airless (High Pressure)	0.33	67° or 80°	1450 to 1885 psi (100 to 130 bar)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use, DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties



Colour:
Green



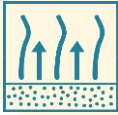
Gloss:
Not Applicable



Drying Times @ 23°C (73°F) 50 % Relative Humidity	
Dry to Touch	1 to 1.5 hours
Dust Free	15 to 20 minutes
Dry to Overcoat	1 to 72 hours
Full Cure	7 to 9 days

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

4185/3600M Celopox 2000SC Anti Corrosive Primer



Flash Off:

10 - 20 minutes at room temperature.



VOC: (ASTM)

Mixed (unthinned)	475 g/Lt
4185/3600M Base	385 g/Lt
0646/9000M Activator	650 g/Lt
0476/9000 Thinner	870 g/Lt



Flash Point:

4185/3600M Base	>25°C (77°F)
0646/9000M Activator	>21°C (70°F)
0476/9000 Thinner	>25°C (77°F)

Shelf Life:

4185/3600M Base	24 months in original unopened container
0646/9000M Activator	24 months in original unopened container
0476/9000 Thinner	10 years in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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.



4185/3600M Celopox 2000SC Anti Corrosive 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

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

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

Americas

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

Desoclean and DeSoto 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.

PPG Aerospace
Sealants and Coatings
Darlington Road
Shildon, Co Durham UK
DL4 2QP

www.ppgaerospace.com

Issue Date: 02/18
Lit: 4282