

Primer 90 Green

Product Description

Primer 90 is a two-component, conventional solids, strontium chromate based epoxy primer. Primer 90 can be applied to suitably pretreated aluminium & Titanium alloys for the internal and external protection of aircraft.

- Excellent fluid resistance
- Excellent corrosion resistance
- Direct adhesion primer

Components



Mix Ratio (by volume)

- 4120/3600 (Base) 1 part
- 0611/9000 (Activator) 1 part
- 0515/9000 (Thinner) 0.1 - 0.2 parts

Specifications



Primer 90 is qualified to:

- AIMS 04-04-001

Primer 90 meets the technical requirements of:

- MIL-PRF-23377

Product Compatibility

Primer 90 is compatible with the following topcoat specifications:

- AIMS 04-04-003
- AIMS 04-04-012
- AIMS 04-04-013
- AIMS 04-04-025
- AIMS 04-04-031
- AIMS 04-04-032
- BS2X34 A&B
- Def Stan 80-161
- Def Stan 80-225

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

Surface Preparation and Pretreatment



Ensure that the correct surface pretreatment has been carried out. Ensure surface to be painted is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

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Instructions for Use



Hand stir or mechanically shake base material until all components are uniformly dispersed. Slowly add activator to base while stirring. Add required 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 15 – 17 seconds
- BSB3 27 - 33 seconds
- FORD4 13 - 16 seconds
- ISO3 41 - 59 seconds
- ZAHN2 16 - 21 seconds

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



Pot Life:

4 hours @ 21 - 25°C (70 - 77°F)

Application Guidelines

Recommended Application Conditions:

Temperature 15 - 35°C (59 - 95°F)
Relative Humidity 30 - 85%

Application:

Apply 1 cross coat to achieve the recommended dry film thickness 15 - 25 µm (0.6 - 1.0 mil).



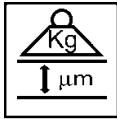
Theoretical Coverage: (mixed unthinned)

14 m²/Lt @ 20 µm dry film thickness
560 ft²/US gal @ 0.8 mil dry film thickness

Recommended Dry Film Thickness:

15 - 25 µm
0.6 - 1 mil

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Dry Film Density:

1.80 g/cm³
15.0 lbs/US gal

Dry Film Weight:

36 g/m² @ 20 µm dry film thickness
0.007 lbs/ft² @ 0.8 mil dry film thickness

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

Equipment:



Equipment	Tip Size	Air Pressure
Conventional Air Spray	1.5 mm	43 to 58 psi (3 to 4 bar)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. Desoto[®] CN20 or Desoclean[™] solvent cleaners are recommended.

Physical Properties



Colour:

Green



Gloss:

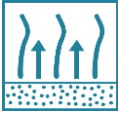
<5 units with a 60° gloss meter



Drying Times @ 50 % R.H.	23°C (73°F)	70°C (158°F)
Dry to Touch	15 minutes	
Dry to Overcoat	2 to 72 hours	30 minutes
Dry to Handle	2 hours	
Dry to Tape	2.5 hours	
Full Cure	7 days	3 hours

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

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**Flash Off:**

15-30 minutes prior to overcoating or force drying

**VOC: (ASTM)**

Mixed unthinned	590 g/Lt
4120/3600 Base	435 g/Lt
0611/9000 Activator	740 g/Lt
0515/9000 Thinner	870 g/Lt

**Flash Point:**

4120/3600 Base	12°C (54°F)
0611/9000 Activator	20°C (68°F)
0515/9000 Thinner	9.5°C (49°F)

Shelf Life:

4120/3600 Base	24 months in original unopened container
0611/9000 Activator	24 months in original unopened container
0515/9000 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.

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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:

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