

## PR143/C4334 Epoxy Primer

### Product Description

PR143/C4334 is a two-pack, ambient curing, chromated epoxy primer developed for the internal and external protection of aircraft.

- Ambient curing
- Excellent resistance to phosphate ester hydraulic oils
- Superior water resistance & adhesion properties
- Excellent corrosion resistance
- Improved adhesion

### Components



#### Mix Ratio (by volume)

- PR143/C4334 (Base) 2 parts
- ACT143/C4334 (Activator) 1 part
- T187 or T17 (Thinner) to viscosity

### Specifications



PR143/C4334 is qualified to:

- BS2X33B

PR143/C4334 meets the performance requirements of:

- MIL-P-23377 Type I
- AIMS 04-04-001
- AIMS 04-04-004

#### Product Compatibility

PR143/C4334 is compatible with the following primer / topcoat specifications:

- BS2X32
- BS2X34 A+B

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

# PR143/C4334 Epoxy Primer

## Surface Preparation and Pretreatment



Ensure correct surface pre-treatment has been carried out and that drying and overcoat times within the process are adhered to. Ensure the surface is clean, dry, and intact using a high performance solvent cleaner - DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

## Instructions for Use



Hand stir or mechanically shake the base material until all the components are uniformly dispersed. Add activator to base material and mix thoroughly. Add thinner to the recommended viscosity (approx. 1 volume).

*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:**

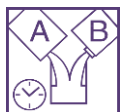
Not required



### **Viscosity:** ( 23°C/73°F)

• AFNOR2.5	45 - 56 seconds
• AFNOR4	15 - 16 seconds
• BSB3	26 - 30 seconds
• DIN4	13 - 14 seconds
• FORD4	12 - 15 seconds
• ISO3	37 - 50 seconds
• ISO4	18 - 22 seconds
• ZAHN2	16 - 20 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 30 - 89%

### **Application:**

Apply one wet even cross-coat to achieve a dry film thickness of 10 - 15 µm

# PR143/C4334 Epoxy Primer

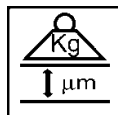


**Theoretical Coverage:** (ready for use)

22 m<sup>2</sup> Lt @ 15 µm dry film thickness  
880 ft<sup>2</sup> US gal @ 0.6 mil dry film thickness

**Recommended Dry Film Thickness:**

10 - 15 µm  
0.4 - 0.6 mil



**Dry Film Density:**

2.22 g/cm<sup>3</sup>  
18.5 lbs/US gal

**Dry Film Weight:**

26 g/m<sup>2</sup> @ 15 µm dry film thickness  
0.005 lbs/ft<sup>2</sup> @ 0.6 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:** PR143/C4334 is compatible with all forms of current spray equipment.



Equipment Type	Tip Size	Pressure
Airmix	9 to 11 thou	725 to 870 psi (50 to 60 bar)
HVLP Air Spray	1.0 to 1.4 mm	22 to 29 psi (1.5 to 2 bar)
Conventional	1.2 to 1.5 mm	43 to 58 psi (3 to 4 bar)
Airless	Not Recommended	
Air-assisted Airless	609 to 611	58 to 73 psi (4 to 5 bar)
Low Pressure Electrostatic	1.2 mm	72 to 87 psi (5 to 6 bar)

**Equipment Cleaning:**

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

# PR143/C4334 Epoxy Primer

## Physical Properties

**Colour:**

Yellow

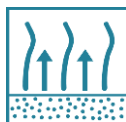
**Gloss:**

&lt;20 units with a 60° gloss meter



DRYING TIMES	23°C (73°F)	70°C(158°F)	125°C (257°F)
Dry to Handle	40 minutes		
Dry to Tape	4 hours		
Dry to Mask	4 hours		
Hard Dry	6 hours	30 minutes	
Re-coat with Self	30 minutes		
Dry to Overcoat	4 to 48 hours		
Full Cure	7 days	3 hours	1 hour

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

**Flash Off Time:**

15 minutes @ 20 - 25°C (68 - 77°F) before force dry.

**VOC: (ASTM) (2:1:1 mix)**

Mixed ready for use	650 g/Lt
PR143/C4334 Base Component	530 g/Lt
ACT143/C4334 Activator	670 g/Lt
T17 Thinner	830 g/Lt
T187 Thinner	870 g/Lt

**Flash Point:**

PR143/C4334 Base Component	20°C (68°F)
ACT143/C4334 Activator	20°C (68°F)
T17 Thinner	16°C (61°F)
T187 Thinner	32°C (90°F)

# PR143/C4334 Epoxy Primer

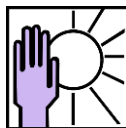
## Shelf Life:

PR143/C4334 Base Component	24 months in original unopened container
ACT/C4334 Activator	24 months in original unopened container
T17 Thinner	24 months in original unopened container
T187 Thinner	24 months 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.*

# PR143/C4334 Epoxy 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

### **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](http://www.ppgaerospace.com)

Issue Date: 01/19

Lit: 4254