

Desothane® HD 9008 Mica Special Effect Basecoat

Product Description

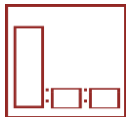
Desothane® HD 9008 Mica special effect basecoat is part of 3 layer Basecoat Clearcoat System.

- High solids, low VOC
- Wide range of mica particle size and surface effects available.
- Can be applied in a wide range of conditions
- Compatible with all current spray equipment

Desothane HD 9008 Mica Basecoat is applied over 9008 Basecoat solid pigmented colors then overcoated with the Desothane® HD 9008B0900D Clearcoat or Desothane® HS CA9005 . Desothane HD 9008 basecoat technology and have been developed to provide customers with greater flexibility in selection of exterior livery systems. The completed (BCCC) basecoat / clearcoat system provides:

- Extended service life
- Improved buffability
- Excellent impact and erosion resistance
- Skydro® resistance
- Gloss and color retention in harsh environments

Components



Mix Ratio (by volume)

- 9008xxxx (Base) 4 parts
- 9008B (Activator) 1 part
- 9008C2 (Reducer) 1 part

Specifications



9008 Mica Basecoat is qualified to the following specifications:

- AIMS 04-04-025
- BAMS 565-018

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

Product Compatibility:

9008 Mica Basecoats are compatible with the following coatings:

- Desothane HD 9008 Basecoat
- Desothane HD 9008B0900D Clearcoat
- Desothane HS CA9005 Clearcoat

Surface Preparation and Pretreatment



9008 Mica basecoat can be applied over clean, intact Desothane HD 9008 Basecoat solid colors. If there is glue residue from masking, finger prints or other contamination, clean with mild solvents such as Desoclean 110 or CN13 or Isopropyl Alcohol.

Instructions for Use



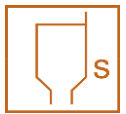
Shake the base component for 10 minutes on a paint shaker or stir thoroughly until there is no solid material on the bottom of the can. While mixing, slowly add one (1) volume of 9008B activator component to four (4) volumes 9008 mica base component. Keep mixing, and add one (1) volume of 9008C series reducer. Mix thoroughly for five (5) minutes to ensure the material is homogeneous. Always add components slowly while agitating. If additional thinning is desired, CA1805CX VOC Compliant Thinner may be added. Start with 5% addition by volume, and add until the desired viscosity is achieved. Do not add more than 20% by volume to the mixed coating.

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:

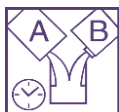
Not required



Viscosity: (23°C/73°F)

- | | |
|-------------------------|-----------------|
| • AFNOR4 cup | 18 - 24 seconds |
| • BSB3 cup | 35 - 46 seconds |
| • BSB4 cup | 20 - 25 seconds |
| • FORD4 cup | 16 - 22 seconds |
| • ISO4 cup | 35 - 50 seconds |
| • #2 Signature ZAHN cup | 18 - 25 seconds |

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



Pot Life:

Pot Life	Using 9008C2
Pot Life @ 23°C (73°F)	2 hours
Pot Life @ 30°C (86°F)	N/A

Application Guidelines

Optimal Recommended Application Conditions:

Relative Humidity 30-75%	Using 9008C2
Temperature	15-30°C (59-86°F)

Application:

Apply over Desothane HD 9008 Basecoat solid colors. For best results, use the same thinner for both the base solid color and base mica.

Depending on the desired effect of the Mica special effect, a second coat may be necessary for some applications. The recommended total dry film thickness per coat is 30-50 microns (1.2 to 2 mil)

1. Remove any inline filters prior to spraying 9008 Mica Basecoat.
2. Apply one cross coat (one medium wet horizontal coat followed by one medium wet vertical coat) to a dry film thickness of 30-50 microns (1.2 to 2 mils). It is important to apply a smooth uniform cross coat to minimize orange peel. The cross coat is important as it will help to produce an even wet coat along with properly dispersing the Mica. This will allow the 9008 clear coat to go on with very little orange peel. Painters need to pay close attention to gun distance overlap, and air pressure, which all play key roles in the appearance and desired effect of the Mica Clear Basecoat.
3. If a second coat of Mica Basecoat is required to achieve the desired effect, apply 15 minutes to 2 hours after application of the first coat. Follow the same application recommendation in step 2.
4. Apply Clearcoat within recommended overcoat times.

Ground the aircraft and the application equipment before topcoating. Stir the basecoat slowly during the application.



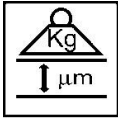
Theoretical Coverage:

22 m²/Lt @ 25 µm dry film (896 ft²/US gal @ 1 mil dry film)

Recommended Dry Film Thickness:

30 - 75 µm depending on color

1.2 - 3.0 mils depending on color

**Dry Film Density:**

1.9 g/cm³ (white)
15.8 lbs./US gal

Dry Film Weight:

38.5 g/m² @ 25 μm dry film thickness
0.0075 lbs./ft² @ 1.0 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 Type	Tip Size	Flow Rate	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12oz./min)	10 to 40 psi (0.69 to 2.8 bar)	58-72 psi (4-5 bar)
Electrostatic Air Assisted Airless Spray Gun	611 through 612 711 through 713	240-350 ml/min (8-12oz./min)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1bar)
High Volume Low Pressure Spray Gun (HVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Low Volume Low Pressure Spray Gun (LVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)		29 psi (2 bar)

Note: Contact your local PPG Technical Service Representative for information on use of alternative application equipment.

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto[®] CN20, CN44, Desoclean[™] 45 or PPG MB28 solvent cleaners are recommended.

Physical Properties



Color:

Available in various particle sizes and surface effects



Gloss:

≥ 90 G.U. at 60° with 9008/B900D or CA9005 Clearcoat



DRYING TIMES	Using 9008C2
Dry to Tape @ 23°C (73°F)	2-3 hours
Dry to Tape @ 30°C (86°F)	1-2 hours
Full Cure	7 days

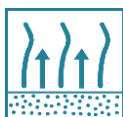
OVERCOAT TIMES 23°C (73°F) 50% R.H.	Using 9008C2
9008 Mica Basecoat over 9008 Basecoat	2 – 3 hours
9008 Mica Basecoat Intercoat Time	15 minutes – 2 hours
9008B900D Clearcoat over 9008 Mica Basecoat	2 – 72 hours

SPOT REPAIR 23°C (73°F) 50% R.H.	Using 9008C2
9008 Mica Basecoat over 9008 Basecoat	2 – 3 hours
9008 Mica Basecoat Intercoat Time	15 minutes – 2 hours
9008B900D Clearcoat over 9008 Mica Basecoat	2 – 48 hours

Note: If the overcoat window has been exceeded, Sur-Prep™ AP-1 Adhesion Promoter may be used between any layers to promote adhesion, see Sur-Prep™ AP-1 TDS for application instructions. When procuring 9008 Mica Basecoat to a material specification, consult the document to verify Sur-Prep™ AP-1 Adhesion Promoter is approved for use.

Note: Wait a minimum of 3 hours prior to applying Pre-mask to prevent solvent entrapment.

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



Flash Off Time:

5 - 15 minutes flash off prior to force dry



VOC: (ASTM)

Mixed ready for use	335 g/Lt
9008 Mica Base Component	350 g/Lt
9008B Activator	110 g/Lt
9008C2 Reducer	870 g/Lt



Flash Point:

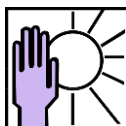
9008 Mica Base Component	33°C (91°F)
9008B Activator	47°C (116°F)
9008C2 Reducer	-1°C (30°F)

Shelf Life:

9008 Mica Base Component	24 months in original unopened container
9008B Activator	24 months in original unopened container
9008C2 Reducer	24 months in original unopened container

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.

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

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Tel 81 561 35 5200
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Tel 65 6861 1119
Fax 65 6861 6162

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

ASC – Tianjin
Tel (86-022) 2482 8625
Fax (86-022) 2482 8600
1 (818) 362-6711 or 1-800-AEROMIX

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Fax 49 (40) 742 139 69

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Fax (971) 4 883 9665

ASC – North Europe
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Fax 44 (0) 1388 770288

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This document has been reviewed by the PPG Aerospace Export Control Department and has been determined to contain only EAR99 controlled data.

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Issue Date: 1/21
Lit: 4592