

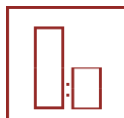
Desoprime™ CA7002 HS Epoxy Primer

Product Description

Desoprime™ CA7002 is a two pack chromated epoxy primer, designed for internal and external aircraft structures.

- High solids, low VOC
- Long term corrosion inhibition
- Excellent fluid resistance & adhesion characteristics
- Compatible with polyurethane, epoxy & acrylic topcoats

Components



Mix Ratio (by volume)

- | | |
|-------------------------|---------|
| • 4012/3600 (Base) | 2 parts |
| • 0612/9000 (Activator) | 1 part |

Specifications



CA7002 is qualified to:

- PPG Standard

Product Compatibility

CA7002 is compatible with the following topcoat specifications:

- | | |
|------------------|------------------|
| • AIMS 04-04-012 | • AIMS 04-04-032 |
| • AIMS 04-04-013 | • BMS 10-60 |
| • AIMS 04-04-025 | • BMS 10-72 |
| • AIMS 04-04-031 | |

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

Surface Preparation and Pretreatment



Ensure that the correct surface pre-treatment has been carried out. Ensure the surface is clean, dry and intact - 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. Add activator to base material and mix thoroughly. **DO NOT ADD ANY SOLVENT.** The mixed material is now ready for use.

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:

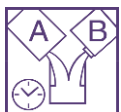
Not required



Viscosity: (23°C/73°F)

- | | |
|------------|-----------------|
| • AFNOR2.5 | 53 - 70 seconds |
| • AFNOR4 | 16 - 19 seconds |
| • BSB3 | 30 - 36 seconds |
| • FORD4 | 15 - 16 seconds |
| • ISO3 | 53 - 72 seconds |
| • ISO4 | 24 - 34 seconds |
| • ZAHN2 | 20 - 22 seconds |

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



Pot Life:

2 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 as an even wet cross coat to achieve the recommended dry film thickness.



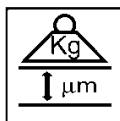
Theoretical Coverage: (ready for use)

30 m²/Lt @ 20 µm dry film thickness
1200 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:

1.89 g/cm³
15.83 lbs/US gal

Dry Film Weight:

38 g/m² @ 20 μm dry film thickness
0.0077 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:

CA7002 is compatible with most forms of current spray equipment



Equipment Type	Tip Size (mm)	Flow Rate (ml/min)	Air Pressure
Airmix Kremlin		Not Recommended	
HVLP Air Spray	1.2		22 to 29 psi (1.5 to 2 bar)
Conventional Airspray	1.5		43 to 72 psi (3 to 5 bar)
Airless		Not Recommended	
Air-assisted Airless Electrostatic		Not Recommended	
Electrostatic Spray PRO Graco	1.2 or 1.5	280 to 320	72 to 87 psi (5 to 6 bar)

Equipment Cleaning:

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

Physical Properties



Colour:

Green (4012/3600)



Gloss:

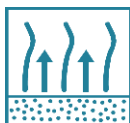
Semi Gloss: <24 units with a 60° gloss meter

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Drying Times 50 % R.H.	23°C (73°F)	70°C (158°F)
Wet Edge Time	15 to 20 minutes	
Dry to Tape	4 to 5 hours	
Dry to Overcoat	4 hours minimum 96 hours maximum	
Full Cure	7 days	3 hours

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



Flash Off Time:

15 minutes before force dry.



VOC: (ASTM)

Mixed ready for use	<350 g/Lt
4012/3600 Base Component	290 g/Lt
0612/9000 Activator	445 g/Lt



Flash Point:

4012/3600 Base Component	10°C (50°F)
0612/9000 Activator	34°C (93°F)

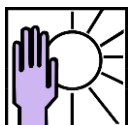
Shelf Life:

4012/3600 Base Component	12 months in original unopened container
0612/9000 Activator	12 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.

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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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ASC – Australia
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