

Desothane[®] CA8660 HS Filler & Build Coat

TECHNICAL DATA SHEET

Product Description

CA8660 is a two component, transparent polyurethane filler & build coat, designed for application on wood and veneer aircraft interiors.

- Fire retardant
- Low density

Components



Mix Ratio (by weight)

- CA8660 (Base)
- CA8660B (Activator)
- CA8660C (Thinner)

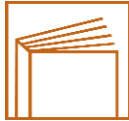
Applied as Filler

100 parts
60 parts
-

Applied as Build Coat

100 parts
60 parts
60 parts

Specifications



CA8660 is qualified to:

- FAR 25.853

Product Compatibility

CA8660 is compatible with the following clearcoat:

- CA8400/B900

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

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using IPA or acetone.

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Instructions for Use



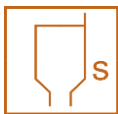
Base component should be manually agitated only. Add the activator to the base and mix well. Add thinner (for build coat) while stirring.

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.



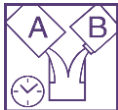
Induction Time:

Not required



Viscosity: (23°C/73°F)

Not applicable



Pot Life:

60 minutes @ 21 - 25°C (70 - 77°F)

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	30 - 80%

Application:

CA8660 is used both as a pore filler and a build coat and the application parameters change according to its use.

Please refer to the relevant application guide for recommended process.

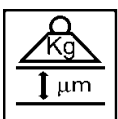


Theoretical Coverage: (ready for use)

Not applicable

Recommended Dry Film Thickness:

Not applicable



Dry Film Density:

Not applicable

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Dry Film Weight:

Not applicable

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:



Product Use	Equipment Type	Tip Size	Maximum Pressure
Filler	Squeegee	N/A	N/A
Build Coat	Conventional Air Spray	1.4 mm	58 psi (4 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:

Colourless



Gloss:

Not applicable



Drying Times @ 23°C (73°F) 50% Relative Humidity

Touch Dry	3 hours
Full Cure	7 days

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



VOC: (ASTM)

Mixed ready for use	380 g/Lt
CA8660 Base Component	180 g/Lt
CA8660B Activator	113 g/Lt
CA8660C Thinner	850 g/Lt



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Flash Point:

CA8660 Base Component	29°C (84°F)
CA8660B Activator	50°C (122°F)
CA8660C Thinner	22°C (72°F)

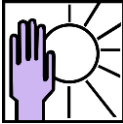
Shelf Life:

CA8660 Base Component	24 months in original unopened container
CA8660B Activator	24 months in original unopened container
CA8660C 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.



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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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