

Desothane[®] HS CA8000R Rollable Flow Additive

TECHNICAL DATA SHEET

Product Description

Desothane[®] HS CA8000R rollable flow additive is used with polyurethane topcoats for roller application. The resulting finish is smooth with minimal orange peel.

- Ideal for touch-ups or areas where spray application isn't advised
- Retains gloss and image reflection of Desothane[®] HS topcoats
- Helps reduce dry times
- Can be used as a fish eye eliminator in Desothane[®] HS topcoats
- Service temperature -54 °C to 177 °C (-65 °F to 350 °F)

Components



Mix ratio (by volume):

- CA8000/XXXXX
or CA8800/XXXXX (base component) 2 parts
- CA8000B
or CA8800Z (activator component) 1 part
- CA8000R (flow additive)
Light colors ¼ part
Dark colors ⅓ part

Product Compatibility:

CA8000R is compatible with the following Desothane[®] Polyurethane Topcoats:

- CA8000 Series
- CA8201 Series
- CA8211 Series
- CA8221 Series
- CA8800 Series
- CA9800 Series

Surface Preparation and Pretreatments



Desothane[®] HS topcoats using the CA8000R roller additive can be used over clean, dry, intact primer or sanded topcoat.

Instructions for Use



Mixing Instructions:

For the best application viscosity, thoroughly mix two parts of Desothane[®] HS base component to one part Desothane[®] HS activator component. Once a uniform consistency is achieved, slowly add CA8000R under constant agitation until the mixture is homogeneous. The amount of CA8000R rollable flow additive to be added to the mixture is dependent upon the usage temperature and color of the base component.

Desothane[®] HS CA8000R Rollable Flow Additive



Fisheye Eliminator/Anti-Cratering:

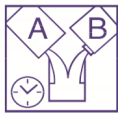
Add 2 ounces of CA8000R to 1 gallon of base. Shake thoroughly. Add one volume of thinner component to two volumes of CA8000 base component. Mix thoroughly. Add one volume of activator component. It is very important to follow the mixing instructions exactly for optimum performance.

Note: It is important to condition the paint for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 13 ° and 35 °C (55 ° to 95 °F). The minimum temperature of the paint components should be 13 °C (55 °F) prior to mixing.



Induction Time:

Not Required



Pot Life at the Suggested Mix Ratio:

Light colors 45 minutes @ 21 - 25 °C (70 - 77 °F)

Dark colors 30 minutes @ 21 - 25 °C (70 - 77 °F)

Application Guidelines

Recommended Application conditions:

Temperature	15 - 30 °C (59 - 86 °F)
Relative Humidity	20 - 90%

Application:

PPG Aerospace recommends using a solvent resistant foam roller. It is important to load the foam roller with paint to displace the air in the foam cells. This will reduce the bubbles. Roll the freshly mixed topcoat with one or two coats to a total dry film thickness of 37.5 to 62.5 microns (1.5 to 2.5 mils). If two coats are needed for full hide, wait until the first coat is tack free before applying the second coat.

Equipment Cleaning:

Clean application equipment as soon as possible after use. Flush spray equipment with DeSoto[®] CN20, DeSoto[®] CN44, or Desoclean[™] 45 high performance solvent cleaner.

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



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Physical Properties (product)



Color: Clear Liquid



Gloss: Not Applicable



Dry Times at Various Temperatures:

20 °C (68 °F)				
Thinners	Dry to Tape	Wet Edge	Time Between Coats	Dry to Fly
CA8000 All Other Colors	3 - 4 hours	15 minutes	15 - 20 minutes	12 hours
CA8000 White and Gray	4 - 5 hours	20 minutes	20 - 30 minutes	36 hours
25 °C (77 °F)				
Thinners	Dry to Tape	Wet Edge	Time Between Coats	Dry to Fly
CA8000 All Other Colors	2 ½ - 3 hours	10 minutes	10 - 15 minutes	10 hours
CA8000 White and Gray	3 - 4 hours	15 minutes	15 - 20 minutes	12 hours
30 °C (87 °F)				
Thinners	Dry to Tape	Wet Edge	Time Between Coats	Dry to Fly
CA8000 All Other Colors	1 - 2 hours	5 minutes	5 - 10 minutes	7 hours
CA8000 White and Gray	2 ½ - 3 hours	10 minutes	10 - 15 minutes	10 hours

Accelerated cure for dry hard:

Allow 20 minutes flash off at 24 °C ± 3 °C (75 °F ± 10 °F)
followed by 15 minutes at 49 °C (120 °F)

The cure time of Desothane[®] HS topcoat is affected by temperature, but not by humidity. Desothane[®] HS topcoats have been sprayed and rolled between 3% and 95% humidity without negative effects to either the film properties or the appearance.



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VOC (EPA method 24):

CA8000R

824 grams/liter



Flash point closed cup:

CA8000R

-5°C (23°F)

Shelf Life:

24 months from date of manufacture for PRC-DeSoto Standard.

Note: Shelf life is provided for original, unopened containers.

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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