

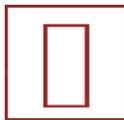
CA3120 Anti-Fretting Epoxy Varnish

Product Description

CA3120 is a one-component anti-fretting epoxy varnish developed to have a high lubrication rate for application to mechanical parts/joints subject to stress and vibration.

- Excellent anti-fretting properties
- High lubrication rate
- Abrasion resistant
- Allows high friction coefficient

Components



Mix Ratio (one component)

- CA3120 (Base)

Specifications



CA3120 is approved to:

- ECS 2294

Note: PPG Aerospace recommends you check the most recent specification QPL's for updated information.

Surface Preparation and Pretreatment



Ensure the surface is clean, dry and intact - DeSoto® CN20 or Desoclean™45 solvent cleaners are recommended. Ensure temperature and humidity are within specified process limits. Observe recommended overcoating windows.

Instructions for Use



Hand stir or mechanically shake base material until product is homogeneous.

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

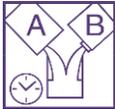
CA3120 Anti-Fretting Epoxy Varnish



Viscosity: (23°C/73°F)

- AFNOR4 29 - 59 seconds
- BSB4 30 - 65 seconds
- FORD4 25 - 56 seconds

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



Pot Life:

N/A

Application Guidelines

Recommended Application Conditions:

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

Application:

Apply one cross coat to achieve the recommended dry film thickness of 6 - 8 μm
Two cross coats is required to achieve 15 - 18 μm
If higher thickness is required, 1 hour flash off at ambient temperature is required between every two cross-coats

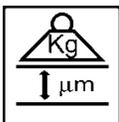


Theoretical Coverage: (ready for use)

23 m²/Lt @ 10 μm dry film thickness
937 ft²/US gal @ 0.4 mil dry film thickness

Recommended Dry Film Thickness:

6 - 8 μm or 15 - 18 μm
0.24 - 0.31 mil or 0.59 - 0.704 mil



Dry Film Density:

1.29 g/cm³
10.7 lbs/US gal

Dry Film Weight:

12.9 g/m² @ 10 μm dry film thickness
0.0026 lbs/ft² @ 0.4 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.

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Equipment



Equipment Type	Tip Size	Air Pressure
Conventional Air Spray	1.0 – 1.5	44 to 73 psi (3 to 5 bar)
HVLP Compliant Air Spray	1.2 – 1.4	29 to 44 psi (2 to 3 bar)

Equipment Cleaning:

Thinners such as 0469/9000 or 0532/9000 are recommended.

Physical Properties



Colour:
Blue-green

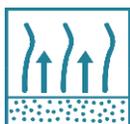


Gloss:
Not Applicable



Drying Times @ 165°C	
Full Cure	60 minutes at 165°C

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



Flash Off Time:
1 hour at 23°C



VOC: (ASTM)

- Base < 670 g/Lt



Flash Point:

- CA3120 Base Component 26°C (79°F)

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Shelf Life:

- CA3120 Base Component 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.

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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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