

# Desobond™ CA102 Adhesive Bonding Primer

## TECHNICAL DATA SHEET

### Product Description

Desobond™ CA102 is a low density adhesion promoter. It was developed to improve bonding characteristics to aged primers, topcoats, acrylics, aluminum, and other aerospace alloys.

- It is available in a single component version (CA102A) or a two component (CA102A/B)
- Compatible with epoxy primers and urethane topcoats
- Eliminates sanding
- Can be sprayed with non-electrostatic spray equipment
- Can be wiped on with lint free wipes
- Service temperature -54 °C to 177 °C (-65 °F to 350 °F)

### Components



#### Mix ratio (by volume):

- |                                |        |
|--------------------------------|--------|
| • CA102A (base component)      | 1 part |
| • CA102B (activator component) | 1 part |

#### Product Compatibility:

CA102 bonding primer is compatible with the following primer and topcoat specifications:

- |                              |                       |
|------------------------------|-----------------------|
| • BMS 10-11 Type I & Type II | • BMS 10-125 Type III |
| • BMS 10-60 Type I & Type II | • DMD 2115            |
| • BMS 10-72 Type VIII        | • MIL-PRF-23377       |
| • BMS 10-79 Type III         | • MIL-PRF-85285       |
| • BMS 10-103                 | • MIL-PRF-85582       |

### Surface Preparation and Pretreatments



Desobond™ CA102 adhesive bonding primer can be applied over clean, dry, intact epoxy primers and polyurethane topcoats.

### Instructions for Use



#### Mixing Instructions:

Prior to mixing, hand stir the base component. Add activator to the base component and stir well, maintain constant agitation for 10 minutes to ensure proper mixing. Induction time for two component version may be required based on temperature.

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*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 for Two Component Version:

Temperature	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Induction Time Required	30 minutes	15 minutes	None



## Viscosity for Two Component Version: (23 °C/73 °F)

- #2 Signature Zahn cup 12 to 18 seconds
- #4 Ford cup 10 to 13 seconds
- ISO 3mm cup 30 to 44 seconds
- ISO 4mm cup 16 to 20 seconds
- BSB3 cup 24 to 28 seconds
- BSB4 cup 14 to 16 seconds
- AFNOR #2.5 cup 41 to 50 seconds
- AFNOR #4 cup 14 to 16 seconds

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



## Pot Life for Two Component Version:

8 hours @ 21 - 25 °C (70 - 77 °F)

## Application Guidelines

### Recommended Application Conditions:

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

### Application:

Ground the aircraft and the application equipment before applying the bonding primer. Stir the bonding primer slowly during the application. The suggested film thickness is 2.5 microns (0.1 mils). This can be accomplished by one coat with a 50% overlap.

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



**Theoretical Coverage:**

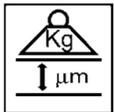
**Single component**

10 square meters/liter at 25 microns dry film (340 square feet/gallon at 0.1 mils dry film)

**Two component**

6 square meters/liter at 25 microns dry film (210 square feet/gallon at 0.1 mils dry film)

Recommended dry film thickness; 2.5 microns (0.1 mils)



**Dry Film Density:**

1.0 grams/cubic centimeter (8.33 pounds/gallon)

**Dry Film Weight:**

3 grams/square meter at 25 microns dry film (0.0006 pounds/square feet at 0.1 mils dry film)



**Equipment:**

CA102 bonding primer is compatible with HVLP, air spray or airless equipment. Can be applied with a lint free wiper.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
High Volume Low Pressure Spray Gun (HVLP)	1.0 mm to 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)

**Equipment Cleaning:**

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

**Physical Properties (product)**



**Color:** Clear

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**Gloss:** Not Applicable



Dry Times	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Dust Free	20 minutes	15 minutes	10 minutes
Tack Free	35 minutes	30 minutes	25 minutes
Dry to Overcoat	1 - 48 hours	1 - 48 hours	1 - 48 hours
Full Cure	7 days	7 days	7 days



**VOC (EPA method 24):**

Mixed, ready to use VOC	810 grams/liter
Two Component	810 grams/liter
Base Component	793 grams/liter
Activator Component	827 grams/liter



**Flash point closed cup:**

Base Component	44 °C (111 °F)
Activator Component	6 °C (43 °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](http://www.ppgaerospace.com)**

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