

F292-0004 Epoxy Clear Coating

Product Description

F292-0004 is a clear two part epoxy lacquer used in specialised areas of aircraft structural interiors

- Resistant to synthetic lubricating oils
- Resistant to organic solvents

Components



Mix Ratio (by volume)

- F292-0004 (Base) 2 part
- ACT214 (Activator) 1 part
- T702 (Thinner) to viscosity

Specifications



F292-0004 is qualified to:

- PPG proprietary release only

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 a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Instructions for Use



Hand stir base material until all components are uniformly dispersed. Add activator to base material and stir thoroughly, add thinner to required viscosity, once mixed the material should be allowed to stand for 30 minutes prior to 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.

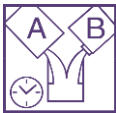
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**Induction Time:**

30 minutes

**Viscosity:** (23°C/73°F)

• AFNOR4	15 - 17 seconds
• BSB4	16 - 18 seconds
• FORD4	14 - 16 seconds
• ISO4	20 - 26 seconds
• ZAHN2	17 - 20 seconds

**Pot Life:**

8 hours minimum @ 21-25°C (70-77 °F)

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

Application:

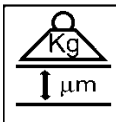
Apply one uniform coat to achieve recommended dry film thickness.

**Theoretical Coverage:**

16 m²/Lt @ 25 µm dry film thickness
640 ft²/US gal @ 1 mil dry film thickness

Recommended Dry Film Thickness:

20-30 µm
0.8-1.2 (mil)

**Dry Film Density:**

1.08 g/cm³
9.03 lbs/US gal

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Dry Film Weight:

27 g/m² @ 25 µm dry film thickness

0.005 lbs/ft² @ 1 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:



Equipment Type	Tip Size	Pressure
Conventional Air Spray	1.2 to 1.5mm	44 to 73 psi (3 to 5 bar)



F292-0004 can also be applied by brush.

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:

Full gloss ≥ 90 units with a 60° gloss meter

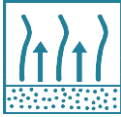


Drying Times:

50% Relative Humidity	23°C(73°F)
Dry to Handle	4 hours
Maskable	8 hours
Hard dry	16 hours
Full Cure	7 days

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

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**Flash Off Time:**

Not Applicable

**VOC: (ASTM)**

Mixed (unthinned)	510 g/Lt
F292-0004 Base Component	500 g/Lt
ACT214 Activator	530 g/Lt
T702 Thinner	820 g/Lt

**Flash Point:**

F292-0004 Base Component	-4°C (25°F)
ACT214 Activator	25°C (77°F)
T702 Thinner	-4°C (25°F)

Shelf Life:

F292-0004 Base Component	24 months in original unopened container
ACT214 Activator	24 months in original unopened container
T702 Thinner	10 years 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:

Asia Pacific

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PPG Aerospace

Sealants and Coatings

Darlington Road

Shildon, Co Durham UK

DL4 2QP

www.ppgaerospace.com

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