



Desothane[®] HS CA8925 Buffable Stain Resistant Topcoat

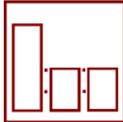
TECHNICAL DATA SHEET

Product Description

Desothane[®] HS CA8925 buffable stain resistant topcoats are high solids topcoats used to protect the exterior of an aircraft.

- Compatible with Desoprime[™] HS and Koroflex[®] primers
- Excellent stain resistance
- Excellent Skydrol[®] resistance
- Excellent gloss and color retention
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- | | |
|---|----------|
| • CA8925 (base component) | 2 parts |
| • CA8925B (activator component) | 1 part |
| • CA8925C (flow control) | 1 part |
| • CA1805CX optional (thinner component) | 0.5 part |

Specifications

CA8925 topcoat is qualified to:

- MIL-PRF-85285 Type I

Product Compatibility:

CA8925 topcoat is compatible with the following primer specifications:

- | | |
|-----------------|-----------------|
| • MIL-PRF-23377 | • MIL-PRF-85582 |
| • MIL-PRF-53022 | • TT-P-2760 |

Surface Preparation and Pretreatments



Desothane[®] CA8925 buffable stain resistant topcoat can be applied over clean, dry, intact primer. For further information, refer to the Technical Data Sheets for the above mentioned primers.

Instructions for Use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well. Then add the flow control additive and optional thinner. Maintain constant agitation for 10 minutes to ensure proper mixing.



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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:

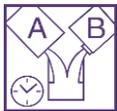
Not Required



Viscosity: (23°C/73°F)

- | | |
|-------------------------|--------------------|
| • #2 Signature Zahn cup | 41 seconds maximum |
| • #4 Ford cup | 30 seconds maximum |
| • ISO 4mm cup | 68 seconds maximum |
| • BSB3 cup | 66 seconds maximum |
| • BSB4 cup | 35 seconds maximum |
| • AFNOR #4 cup | 34 seconds maximum |

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



Pot Life:

4 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 topcoating. Stir the topcoat slowly during the application. The suggested film thickness is 50 to 100 microns (2.0 to 4.0 mils). This can be accomplished with two medium coats with a 50% overlap. Note the first coat should be allowed to tack up before applying the second coat. If the second is applied before the first coat has tacked up, sagging may occur.

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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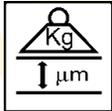


Theoretical Coverage:

Gloss colors

20 square meters/liter at 25 microns dry film (830 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 50 to 100 microns (2.0 to 4.0 mils)



Dry Film Density:

1.44 grams/cubic centimeter (12 pounds/gallon)

Dry Film Weight:

36 grams/square meter at 25 microns dry film (0.00716 pounds/square feet at 1 mil dry film)



Equipment:

CA8925 primer is compatible with all current forms of spray equipment.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm or 1.5 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Electrostatic Air Assisted Airless Spray Gun	#611 or #613 (Graco Nomenclature)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1 bar)
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: Various high gloss colors



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Gloss: 90+ G.U at 60°



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Dry to Tape	8 hours	7 hours	6 hours
Dry Hard	15 hours	12 hours	10 hours
Dry to Fly	55 hours	48 hours	40 hours
Full Cure	7 days	7 days	7 days

Accelerated cure for dry to tape:

Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
followed by 60 minutes at 49°C (120°F)



VOC (EPA method 24):

Mixed, ready for use VOC	420 grams/liter
Base Component	415 grams/liter
Activator Component	0 grams/liter
Flow Control Component	818 grams/liter
Thinner Component	0 grams/liter



Flash point closed cup:

Base Component	29°C (84°F)
Activator Component	170°C (338°F)
Flow Control Component	41°C (105°F)
Thinner Component	-10°C (15°F)

Shelf Life:

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

Note: Shelf life is provided for the 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.



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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

Tel 61 (3) 9335 1557
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