

PR205 HS Epoxy Primer

Product Description

PR205 is a two pack strontium chromate pigmented epoxy primer, designed for the internal and external protection of aircraft.

- Long term corrosion inhibition
- High solids, low VOC
- Inhibits microbial growth in aircraft fuel tanks
- Available in military grade (*Separate TDS available which may be subject to export control restrictions. Please contact your PPG representative to request a copy*)

Components



Mix Ratio (by volume)

- PR205 (Base) 3 part
- ACT205 (Activator) 1 part

Specifications



PR205 is qualified to:

- 741.140/21-00-00-0018-0T04
- AVN 7-003
- BS2X33B : 1998 + A1 : 2005
- MEP 10.059
- MSRR 9064
- SP-J-513-A-0016 Type II Class A

PR205 meets the performance requirements of:

- FS 8010-0207 Type II

Product Compatibility

PR205 is compatible with the following topcoat specifications:

- BS2X34A+B
- Def Stan 80-161
- Def Stan 80-225
- SP-J-513-C-0083

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Surface Preparation and Pretreatment



Ensure that the correct surface pre-treatment has been carried out. Ensure the surface is clean, dry and intact - Desoto[®] CN20 or Desoclean[™] 45 solvent cleaner are recommended.

Instructions for Use



Hand stir or mechanically shake base material until all components are uniformly dispersed. Add activator to base material and mix thoroughly. **Do not add any solvent.** The mixed material is now ready for 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.



Induction Time:

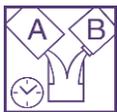
Not required



Viscosity: (23°C/73°F)

- | | |
|----------|-----------------|
| • AFNOR4 | 20 - 26 seconds |
| • BSB3 | 40 - 48 seconds |
| • BSB4 | 23 - 26 seconds |
| • FORD4 | 19 - 23 seconds |
| • ISO4 | 38 - 46 seconds |
| • ZAHN2 | 25 - 30 seconds |

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



Pot Life: @ 21-25°C (70-77°F)

Spray Application : 2 Hours

Brush Application : 4 Hours maximum

Application Guidelines

Recommended Application Conditions:

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

Application:

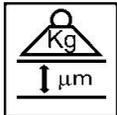
Ensure equipment is set up correctly to achieve the recommended flow rate and apply a single wet closed coat to achieve 15-25 µm dry film thickness.

**Theoretical Coverage:** (ready for use)

30 m²/Lt @ 20 µm dry film thickness
 1200 ft/US gal @ 0.8 mil dry film thickness

Recommended Dry Film Thickness:

15-25 µm
 0.6-1 mil

**Dry Film Density:**

1.71 g/cm³
 14.30 lbs./US gal

Dry Film Weight:

34 g/m² @ 20 µm dry film thickness
 0.007 lbs/ft² @ 0.8 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:

PR205 is compatible with most types of current spray equipment, though atomization and low film wetting is difficult to achieve with airless spray and it is not recommended for use.



Equipment Type	Tip Size	Pressure
Airmix	609 to 611	29 to 43 psi (2 to 3 bar)
HVLP Air Spray	1.0 to 1.2 mm	29 to 43 psi (2 to 3 bar)
Pressure Pot	0.85 to 1 mm	29 to 43 psi (2 to 3 bar)
Airless	Not Recommended	
Air-assisted Electrostatic	609 to 611	43 to 72 psi (3 to 5 bar)
Low Pressure Electrostatic	1.0 to 1.2 mm	43 to 72 psi (3 to 5 bar)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use, DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties



Colour:

Yellow (PR205)
Green (PR205/C5145)



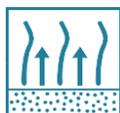
Gloss:

< 20 gloss units using a 60 gloss meter



DRYING TIMES	23°C(73°F)	40°C(104°F)	70°C(158°F)
Surface Dry	4 hours	1 hour	30 minutes
Dry to Tape	6 hours	1.5 hours	45 minutes
Dry to Overcoat	4 hours (min.) 48 hours (max.)	1 hour	30 minutes
Full Cure	7 days	24 hours	3 hours

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



Flash Off Time:

15 minutes before force dry



VOC: (ASTM)

Mixed ready for use	<350 g/Lt
PR205 Base Component	345 g/Lt
ACT205 Activator	355 g/Lt



Flash Point:

PR205 Base Component	-17°C (1.4°F)
ACT205 Activator	23°C (73°F)

Shelf Life:

PR205 Base Component	12 months in original unopened container
ACT205 Activator	24 months in original unopened container
PR205 Kits	12 months in original unopened container
ACT205 Sempens	06 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.

Note: When procuring to a qualified material specification, follow those storage instructions.

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

ASC – Australia
Tel 61 (3) 9335 1557 Fax
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Tel 44 (0) 1388 770222
Fax 44 (0) 1388 770288

ASC - South Europe
Tel 33 (0) 235 53 43 71
Fax 33 (0) 235 53 54 44

Americas

1 (818) 362-6711 or 1-800-AEROMIX

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