

Desofill™ CA8620 / CA8620G HS PU Sanding Surfacers

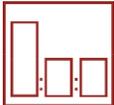
TECHNICAL DATA SHEET

Product Description

Desofill™ HS CA8620 and CA8620G sanding surfacers are chromate-free, chemically cured, chemical and solvent resistant polyurethane coatings. They are designed to fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces

- Corrosion resistant primer required when applied to aluminum substrates
- High solids, low VOC
- High build
- Compatible with epoxy primers and polyurethane topcoats
- Excellent flexibility & water resistance
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix Ratio (by volume)

- | | |
|--|---------|
| • CA8620 or CA8620G (Base) | 2 parts |
| • CA8000B (Activator) | 1 part |
| • CA8000C / CA8000C1 or CA8000C2 (Thinner) | 1 part |

Note: Quicker dry times can be achieved by using CA8000C1 and CA8000C2 thinners.

Note: CA8620LV is an exempt blend thinner version of CA8000C that gives a mixed and ready to use VOC of 350 grams/liter.

CA8620 / CA8620G

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Specifications



CA8620 is qualified to:

- ECS 2067-20
- DGQT 1.7.0.0121
- MEP 10-70

CA8620G is qualified to:

- BAMS 565-015 Class A Grade B
- DGQT 1.7.0.0121
- MEP 10-70
- CMS-CT-904
- GAMPS 3105

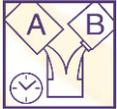
Product Compatibility

CA8620G / CA8620 are compatible with the following specifications:

- AIMS 04-04-012
- AIMS 04-04-013
- AIMS 04-04-024
- AIMS 04-04-031
- AIMS 04-04-032
- AMS3095A
- BAMS 565-002 Class A Grade B
- BAMS 565-009 Type II Grade B
- BMS 10-60 Type II Class B Grade D
- BMS10-72 Type VIII
- BMS 10-125 Type III Grade D
- BMS 10-126 Type I Grade D
- BS2X33 A&B
- CMFS037
- CMS-CT-101 Type I
- DHMS C4.04 Type VI Class B Grade B
- DMS 2143 Type 1 Class 1 Composition C
- DPM 6456
- DPM 6546
- FEDEX STANDARD
- GAMPS 3209
- GP110AEE
- MEP 10-069
- MM1276 Type II
- MS100029E Class HS
- RMS 430 Type II
- SMS-111207 Type 1
- VMS C4.04 Type VI Class B Grade B

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

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Pot Life: @ 21 - 25°C (70 - 77°F)

Thinner	Time
CA8000C	3 hours
CA8620LV	3 hours
CA8000C1	2 hours
CA8000C2	1 hour

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 surfacer. Stir the sanding surfacer slowly during the application. The suggested dry film thickness is 60 to 200 microns (2.4 to 8 mils). This can be accomplished by two or more medium coats. Note the first and second coat should allow to tack up before applying the next coat. If the next coat is applied before the previous coat has tacked up, sagging may occur.

When using CA8000C2 thinner, we recommend to apply about 30 to 45 microns at each coat with 30 to 45 minutes in between coat.

When using CA8000C thinner, we recommend to apply about 30 to 45 microns for each coat with about 1 hour to 1,5 hour in between coat

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.



Theoretical Coverage: (ready for use)

21 square meters/liter at 25 microns dry film (850 square feet/gallon at 1 mil dry film)

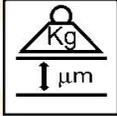
Recommended Dry Film Thickness:

Recommended film thickness before sanding: 60 - 200 microns (2,4 to 8 mils)

Recommended film thickness after sanding: 25 - 125 microns (1 to 5 mils)

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Dry Film Density:

1.72 grams/cubic centimeter (14.3 pounds/gallon)

Dry Film Weight:

43 grams/square meter at 25 microns dry film (0.0089 pounds/square feet at 1 mil dry film)


Equipment:

Desofill™ sanding surfacer is compatible with all current forms of spray equipment

Equipment Type	Tip Size	Pot pressure	Atomization Pressure at the cap
Electrostatic Air spray gun	1.5 mm or 1.8 mm Fluid rate : 320 – 400 ml/min	10 to 20 psi (0.69 to 1.4 bar)	72 to 87 psi (5 to 6 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 (HVLP) spray gun	1.0 mm or 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray gun	1.5 mm or 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	43 to 72 psi (3 to 5 bar)

Equipment Cleaning:

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

Physical Properties


Colour:

 Beige (8620A02250)
 Light grey (8620E02211) and Grey (CA8620G)

Gloss: Not applicable

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Drying Times at 60 µm (55% +/- 5 Rh)	15 – 21°C (59 – 70°F)	22 – 28°C (71– 84°F)	> 29°C (>85°F)
CA8000C Thinner			
Tack Free	2 hours	1 - 1 ½ hour	1 hour
Dry to Tape	> 4 hours	3-4 hours	2-3 hours
Dry to Sand	> 12 hours	10 - 12 hours	8 -10 hours
Topcoat after Sanding	8 days	8 days	8 days
Full Cure	7-9 days	7-9 days	7-9 days
CA8000C1 Thinner			
Tack Free	1 hour	1 hour	45 minutes
Dry to Sand	8 hours	7 hours	6 hours
Topcoat after Sanding	8 days	8 days	8 days
Full Cure	7-9 days	7-9 days	7-9 days
CA8000C2 Thinner			
Tack Free	45 minutes	30 minutes	20 minutes
Dry to Tape	> 2 hours	1.5-2 hours	1-1.5 hours
Dry to Sand	> 4 hours	3-4 hours	2-3 hours
Topcoat after Sanding	8 days	8 days	8 days
Full Cure	7-9 days	7-9 days	7-9 days
CA8620LV			
Tack Free	2 hours	1 ½ hour	1 hour
Dry to sand	10 hours	9 hours	8 hours
Topcoat after Sanding	8 days	8 days	8 days
Full Cure	7-9 days	7-9 days	7-9 days

Note: drying time are given at 60 microns dry film thickness and will have to be adjusted at higher thickness

Accelerated cure with CA8000C Thinner for dry to sand

Allow 60 minutes flash off at 25°C +/- 3°C (75°F) followed by 1 ½ hour at 60°C (140°F)

Accelerated cure with CA8000C2 Thinner for dry to sand

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Allow 30 minutes flash off at 25°C +/- 3°C (75°F) followed by 1 hour at 60°C (140°F)

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

VOC

VOC:

Mixed, ready for use VOC (ASTM D3960) with CA8000C series	< 420 g/Lt
Mixed, ready for use VOC (EPA method 24) with CA8620LV	< 350 g/Lt
Base Component	< 350 g/Lt
Activator Component	< 115 g/Lt
CA8000 series thinner Component	< 760 g/Lt
CA8620LV Thinner component	< 884 g/Lt



Flash Point:

CA8620 Base Component	16°C (60°F)
CA8000B Activator Component	47°C (116°F)
CA8000C series Thinner Component	24°C (75°F)
CA8620LV Thinner Component	15°C (60°F)

Shelf Life:

12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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

Note: Shelf Life is valid only for product stored in 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, the specification shelf life requirements must be observed.

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:



Desofill™ CA8620 / CA8620G HS PU Sanding Surfacers

Asia Pacific

ASC – Australia

Tel 61 (3) 9335 1557
Fax 61 (3) 9335 3490

ASC – Japan

Tel 81 561 35 5200
Fax 81 561 35 5201

ASC – South East Asia

Tel 65 6861 1119
Fax 65 6861 6162

ASC – Suzhou

Tel (86-512) 6661 5858
Fax (86-512) 6661 6868

ASC – Tianjin

Tel (86-022) 2482
8625 Fax (86-022)
2482 8600

Americas

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

Europe and Middle East

ASC – Central Europe

Tel 49 (40) 742 193 10
Fax 49 (40) 742 139 69

ASC – Middle East & India

Tel (971) 4 883 9666
Fax (971) 4 883 9665

ASC – North Europe

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

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Issue Date: 05/18
Lit: 4605

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