PPG Aerospace
PRC-DeSoto

Koropon® HS CA3000 Series Epoxy Topcoats

TECHNICAL DATA SHEET

Product Description

Koropon® HS CA3000 series high solids epoxy topcoats are used to protect the interior of the aircraft from strong fluids, such as jet fuel, etc.

- Compatible with epoxy primers
- Excellent adhesion and corrosion resistance
- Easy to clean
- Excellent Skydrol® resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components

Mix ratio (by volume):

- CA3000/XXXXX (base component) 3 parts
- CA3000B (activator component) 1 part

Specifications

CA3000 is qualified to:

- DMS 2433 Type I Composition C
- CMS-CT-203 Type I Class 3
- EMS 53181 Type II Class A & C
- GMS 5006 Type I
- HMS 15-1100 Type II Class 2
- MCS 9010 Type X Class 1 Grade 2
- MS10014E Class HS
- ZMS 2433 Type I COMP C

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

Product Compatibility:

CA3000 is compatible with the following primer specifications:

- BMS 10-11 Type I
- DMS 1786
- EMS 53181 Type I

Surface Preparation and Pretreatments

CA3000 topcoat can be applied over clean, dry, intact epoxy primers. If the primer is 4 to 48 hours old, then no special preparation is needed. If the primer was applied over 48 hours ago, then abrade the surface lightly and clean the sanding residue with a mild solvent such as Desoclean™ 110. For further information, refer to the Technical Data Sheet for the above mentioned primers.

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Instructions for Use

Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator to the base component and stir well, maintain constant agitation for 10 minutes to ensure proper mixing.

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	15 to 35 seconds
• #4 Ford cup	10 to 25 seconds
• ISO 4mm cup	17 to 58 seconds
• BSB3 cup	24 to 58 seconds
• BSB4 cup	14 to 31 seconds
• AFNOR #4 cup	14 to 31 seconds

Note: Viscosities quoted are typical ranges 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 painting. Stir the topcoat slowly during the application. The suggested film thickness is 45 to 55 microns (1.8 to 2.2 mils). This can be accomplished by one or 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.

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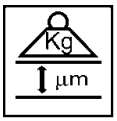
These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.

Theoretical Coverage:

19 - 21 square meters/liter at 25 microns dry film (750 to 850 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 45 to 55 microns (1.8 to 2.2 mils)



Dry Film Density:

1.72 grams/cubic centimeter (14.33 pounds/gallon)

Dry Film Weight:

43 grams/square meter at 25 microns dry film (0.0087 pounds/square feet at 1 mil dry film)

Equipment:

CA3000 topcoats are 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: Available in a variety of 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)
Dust Free	3 hours	2 hours	1 ½ hours
Dry to Tape	5 hours	4 hours	3 hours
Dry Through	11 hours	9 hours	7 ½ hours

Accelerated cure dry to tape:

Allow 15 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
followed by 60 minutes at 65°C (150°F)

VOC (EPA method 24):

Mixed, ready to use VOC	420 grams/liter
Base Component	374 grams/liter
Activator Component	557 grams/liter

Flash point closed cup:

Base Component	8°C (46°F)
Activator Component	7°C (43°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: The coating shelf life is provided for original, unopened containers.

<u>Note:</u> 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:

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Tel 61 (3) 9335 1557
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