

Desofill™ HS CA8620GS Sanding Surfacers

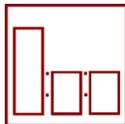
TECHNICAL DATA SHEET

Product Description

Desofill™ CA8620GS sanding surfacer is a chromate-free, chemical and solvent resistant polyurethane surfacer. CA8620GS is designed to fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces. CA8620GS has very good intercoat adhesion to polyurethane topcoats and epoxy primers.

- Compatible with corrosion resistant Desoprime™ HS primers and Desothane® HS topcoats
- Excellent Skydrol® resistance
- Requires a corrosion resistant primer when used over aluminum
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- | | |
|---------------------------------|---------|
| • CA8620GS (base component) | 2 parts |
| • CA8000B (activator component) | 1 part |
| • CA8000C (thinner component) | 1 part |

Product Compatibility:

CA8620GS is compatible with the following topcoat specifications:

- | | |
|----------------|-----------------|
| • BAMS 565-009 | • DPM 6456 |
| • BMS 10-60 | • MEP 10-069 |
| • BMS 10-72 | • MIL-PRF-85285 |

Surface Preparation and Pretreatments



Desofill™ sanding surfacer CA8620GS can be applied over clean, dry, intact primed aluminum and unprimed composite surfaces. Aluminum surfaces need to be primed with a urethane compatible, corrosion resistant primer before applying CA8620GS.

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Instructions for Use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well, and add the thinner component while stirring. 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:

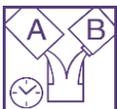
Not Required



Viscosity: (23°C/73°F)

- | | |
|-------------------------|------------------|
| • #2 Signature Zahn cup | 35 to 52 seconds |
| • #4 Ford cup | 25 to 40 seconds |
| • BSB3 cup | 58 to 90 seconds |
| • BSB4 cup | 29 to 46 seconds |
| • AFNOR #4 cup | 31 to 46 seconds |

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



Pot Life:

3 hours @ 21 - 25°C (70 - 77°F)

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Application Guidelines

Recommended Application conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

Application:

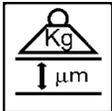
Ground the aircraft and the application equipment before priming. Stir the surfacer slowly during the application. The suggested film thickness is 75 to 250 microns (3.0 to 10.0 mils). This can be accomplished by two or three medium coats with a 50% overlap. Note the first or second coat should be allowed to tack up before applying the second or third coat. If the next coat is applied before the previous coat has tacked up, if not allowed to tack 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.



Theoretical Coverage:

21 square meters/liter at 25 microns dry film (850 square feet/gallon at 1 mil dry film)
 Recommended dry film thickness prior to sanding; 75 to 250 microns (3.0 to 10.0 mils)
 Recommended dry film thickness after sanding; 25 to 75 microns (1.0 to 3.0 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 (0.0089 pounds/square feet at 1 mil dry film)

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Equipment:

CA8620GS 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: Gray



Gloss: Not Applicable



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Tack Free	3 - 4 hours	2 - 3 hours	1 - 2 hours
Dry to Sand	15 - 18 hours	12 - 15 hours	10 - 12 hours
Topcoat after Sanding	Up to 48 hours	Up to 48 hours	Up to 48 hours
Full Cure	7 days	7 days	7 days

Accelerated cure:

Allow 60 minutes flash off at 24°C ± 3°C (75°F ± 10°F) followed by 100 minutes at 60°C (140°F)

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Note: Faster dry-to-sand time can be achieved by substituting CA8000C with CA8000C1 or CA8000C2 thinners.

Note: CA8620GS must be sanded prior to applying topcoat.

VOC

VOC:

Mixed, ready for use VOC (EPA method 24)	420 grams/liter
Base Component	358 grams/liter
Activator Component	113 grams/liter
Thinner Component	864 grams/liter



Flash point closed cup:

Base Component	16°C (60°F)
Activator Component	47°C (117°F)
Thinner Component	24°C (75°F)

Shelf Life:

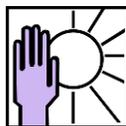
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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

Note: Shelf life is provided for 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.

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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