

Super Koropon[®] 515X408 Fluid Resistant Primer

TECHNICAL DATA SHEET

Product Description

Super Koropon[®] 515X408 fluid resistant primer is a chemical and solvent resistant epoxy coating.

- Compatible with PRC[®] sealants and Desothane[®] topcoats
- Excellent adhesion and corrosion resistance
- Excellent Skydrol[®] resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- 515X408 (base component) 1 part
- 910X937 (activator component) 1 part

Specifications



515X408 primer is qualified to:

- 5PTMRG58
- FMS-1058
- LMA-MR058

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

Product Compatibility:

515X408 primer is compatible with the following sealant specifications:

- 5PTMUG44
- FMS-1044
- FMS-3104
- LMA-MU044

515X408 primer is compatible with the following coating specifications:

- AMS-C-27725
- LMA-MR003
- MIL-PRF-23377
- MIL-PRF-85285

Surface Preparation and Pretreatments



Super Koropon[®] 515X408 primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

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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, maintain constant agitation for 10 minutes to ensure proper mixing. Induction time is required.

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.



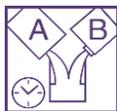
Induction Time:

Temperature	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Induction Time Required	40 minutes	30 minutes	20 minutes



Viscosity: (23°C/73°F)

- | | |
|-------------------------|------------------|
| • #2 Signature Zahn cup | 16 to 20 seconds |
| • #4 Ford cup | 12 to 15 seconds |
| • ISO 3mm cup | 37 to 50 seconds |
| • ISO 4mm cup | 18 to 22 seconds |
| • BSB3 cup | 26 to 30 seconds |
| • BSB4 cup | 15 to 17 seconds |
| • AFNOR #2.5 cup | 45 to 56 seconds |
| • AFNOR #4 cup | 15 to 16 seconds |



Pot Life:

8 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:

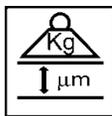
Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 15 to 23 microns (0.6 to 0.9 mils). This can be accomplished by one medium coat with a 50% overlap.

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:

8.4 square meters/liter at 25 microns dry film (357 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 15 to 23 microns (0.6 to 0.9 mils)



Dry Film Density:

1.81 grams/cubic centimeter (15.08 pounds/gallon)

Dry Film Weight:

45 grams/square meter at 25 microns dry film (0.00925 pounds/square feet at 1 mil dry film)

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Equipment:

515X408 primer is compatible with all current forms of non-electrostatic spray equipment.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
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: Green



Gloss: Not Applicable



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Tack Free	45 minutes	30 minutes	20 minutes
Dry to Stack	90 minutes	60 minutes	40 minutes
Overcoat Time	5 - 48 hours	4 - 48 hours	3 - 48 hours
Full Cure	7 days	7 days	7 days

Accelerated cure to dry hard:

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



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VOC:

Mixed, ready to use VOC (EPA method 24)	644 grams/liter
Base Component	498 grams/liter
Activator Component	787 grams/liter



Flash Point closed cup:

Base Component	6°C (42°F)
Activator Component	-6°C (22°F)

Shelf Life:

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

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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