

09W015B White High Build Sanding Surfacers

TECHNICAL DATA SHEET

Product Description

09W015B is a chrome free, chemically cured, chemical and solvent resistant polyurethane high build sanding surfacer. 09W015B is designed to fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces.

- Resistant to hydraulic fluids, lubricating oils, diesel fuel, and water
- Quick recoat time
- Fast dry with addition of accelerator or low temperature oven cure
- Excellent flow and leveling
- Easily sanded
- Can be applied with brush or roller

Components



Mix ratio (by volume):

- | | |
|--------------------------------|------------|
| • 09W015B (base component) | 3 parts |
| • 80X042 (activator component) | 1 part |
| • CA1805CX (thinner component) | 0.25 parts |

Note: Addition of CA1805CX thinner component may be adjusted to achieve desired application viscosity.

Note: For touch-up applications, accelerator 85X116 can be added to the mixed material for faster dry-to-sand time.

Specifications



09W015B meets the performance requirements of:

- BAMS 565-015

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

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Product Compatibility:

09W015B is compatible with the following primer specifications:

- BAMS 565-008

09W015B is compatible with the following topcoat specifications:

- BAMS 565-009

Surface Preparation and Pretreatments



09W015B primer can be applied over clean, dry, intact primed aluminum and unprimed composite surfaces. Aluminum surfaces need to be primed with a urethane compatible coating. For further information, refer to the above mentioned primers.

Instructions for Use



Mixing Instructions:

Stir or shake 09W015B base component for 5 to 10 minutes to ensure any pigment, which may have settled on the bottom of the can, has been fully incorporated into the base. Slowly add three (3) volumes of 09W015B base component to one (1) volume of 80X042 activator component and mix thoroughly. Add one quarter (0.25) volumes of CA1805CX thinner component and mix thoroughly to uniformity. Mix ratio with 80X042 is 3 parts base: 1 part activator: 0.25 parts thinner.

For faster dry to sand time, 85X116 can be used with 09W015B to accelerate cure and dry-to-sand time at the expense of pot life. Up to 8 fl. oz. (236 mL) of 85X116 can be added per gallon of mixed and thinned material. At this level of addition, 09W015B will have a 2-hour dry-to-sand time and a pot life of approximately 45 minutes to 1 hour. Add 85X116 within 5 minutes of initial mixing of 09W015B components and stir until homogeneous. Apply the material immediately. Discard any unused material at the end of its usable pot life. Do not thin aged material in an attempt to apply the material beyond its usable pot life. 85X116 is to be used for touch-up application only and is not recommended for painting large surfaces. Contact your PPG Aerospace Technical representative for more information.

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 15° and 30°C (59° to 86°F). The minimum temperature of the paint components should be 15°C (59°F) prior to mixing.

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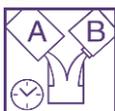
Induction Time:

Not Applicable



Viscosity: (23°C/73°F)

- #4 Ford cup 14 to 21 seconds



Pot Life:

Standard mix: 3 - 4 hours @ 20 - 26°C (68 - 78°F)

With 85X611 accelerator (at 8 oz. per gallon addition):
45 - 60 minutes @ 20 - 26°C (68 - 78°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 spraying. Stir the surfacer slowly during the application. The suggested film thickness is 25 to 150 microns (1 to 6 mils) before sanding. This can be accomplished by two or three medium coats with a 50% overlap. Note the initial coat should be allowed to tack up before applying the next coat. When using three coat process, allow the second coat to tack up before applying the third coat. Applying a new coat before the existing one has tacked up may result in sagging and possibly pinholes.

Sanding Preparation:

Once the surface is properly cured to a state in which sanding can occur, a 340 to 600 grit sand paper should be used to achieve the desired final texture prior to top coating. Once sanding is complete, Desoclean 110 or Isopropyl Alcohol or a 50/50 blend of Isopropyl Alcohol and water should be used to thoroughly wipe down the surface until it is free of all sanding dust.

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

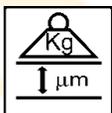
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Theoretical coverage:

17.5 square meters/liter at 25 microns dry film (720 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 25 to 150 microns (1 to 6 mils)



Dry Film Density:

1.84 grams/cubic centimeter (15.4 lbs./gallon)

Dry Film Weight:

4.36 grams/square meter at 25 microns dry film (0.0096 lbs./square feet at 1 mil dry film)



Equipment:

09W015B is compatible with the spray equipment listed below:

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
High Volume Low Pressure Spray Gun (HVLV)	1.3 - 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 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.

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Physical Properties (product)



Color White



Gloss <20 G.U. at 60°



Dry Times at 18 - 24°C (65 - 75°F) 50% ± 10% RH

Standard Mix

Tack Free 2 hours

Recoat Time With Itself 1 - 12 hours

Dry Hard 4 hours

Dry to Sand 12 hours min
6 days max

Overcoat Time After Sanding 1 - 24 hours

With 85X116 Accelerator (at 8 oz. per gallon addition)

Dry to Sand 2 hours

Overcoat Time After Sanding 1 hour min
6 days max

Force dry schedule for dry to sand:

Allow a minimum of 15 minutes flash off time at ambient conditions (70° ± 5°F and 50% ± 10% relative humidity) prior to exposing painted parts to high temperatures. Complete testing should be done prior to use. Below are suggested starting points. Other variables may affect cure schedules.

Temperature	Time
49°C (120°F)	45 minutes
60°C (140°F)	30 minutes
71°C (160°F)	20 minutes
82°C (180°F)	15 minutes

Note: These guidelines for the heat-accelerated cure of two component urethane coatings. These parameters are to achieve dry to sand time. Your actual results may depend on the mass of the parts or degree of cure needed.

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VOC

VOC:

Mixed, ready to use VOC (EPA method 24) with 80X042	205 grams/liter
09W015B	38 grams/liter
80X042 Activator Component	565 grams/liter
85X116 Accelerator	0 grams/liter
CA1805CX	0 grams/liter



Flash Point closed cup:

09W015B	-20°C (-4°F)
80X042 Activator Component	4°C (40°F)
85X116 Accelerator	43°C (109°F)
CA1805CX	-9°C (15°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 13°C to 32°C (55°F to 90°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:

Asia Pacific

ASC – Australia
Tel 61 (3) 9335 1557
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Fax 81 561 35 5201

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Tel 65 6861 1119
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Fax (86-512) 6661 6868

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Tel (971) 4 883 9666
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ASC – North Europe
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