

Desofill™ CA8620 HS PU Sanding Surfacers

TECHNICAL DATA SHEET

Product Description

Desofill™ CA8620 is a chromate free polyurethane sanding surfacer designed to improve the appearance of aluminium, fibre glass and composites. CA8620 can be used as a sanding primer or as a pore filler.

- High solids, low VOC
- Corrosion resistant primer required when used on aluminium surfaces
- Compatible with epoxy primers & Desothane® HS 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 (Base) 2 parts
- CA8000B (Activator) 1 part
- CA8000C or CA8000C2 (Thinner) 0.5 - 1 * part

(* 0.5 volume thinner when applied as pore filler
1 volume thinner when applied as a surfacer)

Specifications



CA8620 is qualified to:

- ECS 2067-20
- DGQT 1.7.0.0121
- DGT 99993
- MEP 10-70

CA8620 meets the performance requirements of:

- AIMS 04-04-011

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Product Compatibility

CA8620 is compatible with the following primer specifications:

- AIMS 04-04-012
- AIMS 04-04-026
- AIMS 04-04-054
- BS2X33A+B

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

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaner are recommended. When applying to aged primer / topcoat, surface must be sanded using sand paper types 180, 240, or 320 then degreased prior to application of CA8620. For application to composite, surface must be degreased using Desoclean™ 110 or DeSoto® CN13 solvent cleaners prior to application of CA8620.

Instructions for Use



Base may require mechanical agitation. Ensure all components are adequately dispersed. Add activator to base and stir well, then add required thinner while stirring. Continuously agitate for 10 minutes to ensure mixing is homogenous.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.



Induction Time:

Mix Ratio 2:1:1 30 minutes @ 23°C (73°F)
 Mix Ratio 2:1:0.5 No induction time required

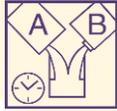


Viscosity: (23°C/73°F)

Flow Cup	2:1:1 Mix Ratio by Volume	2:1:0.5 Mix Ratio by Volume
AFNOR4	15-20 Seconds	30-45 Seconds
BSB4	16-23 Seconds	35-54 Seconds
FORD4	12-17 Seconds	24-41 Seconds
ISO4	26-38 Seconds	64-105 Seconds
ZAHN2	22-27 Seconds	38-80 Seconds

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

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Pot Life: @ 21 - 25°C (70 - 77°F)

Thinner	1 Volume	0.5 Volume	0 Volume
CA8000C	3 hours	2 hours	1 hour
CA8000C2	2 hours	1 hour	

Application Guidelines

Recommended Application Conditions:

Temperature 15 - 35°C (59 - 95°F)
Relative Humidity 30 - 85%

Application:

With C2 thinner, apply 3 coats at 30 - 40 µm each to achieve the required thicknesses of 90 - 120 µm with 30 - 45 minutes between coats, or apply 2 coats at 30 - 45 µm each to achieve 60 - 90 µm with 30 - 45 minutes between coats.

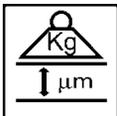


Theoretical Coverage: (ready for use)

6 - 7 m² /Lt @ 90 µm dry film thickness
240 - 280 ft/US gal @ 3.6 mil dry film thickness

Recommended Dry Film Thickness:

60 - 120 µm
2.4 - 4.8 (mil)



Dry Film Density:

1.66 g/cm³
13.8 lbs/US gal

Dry Film Weight:

149 g/m² @ 90 µm dry film thickness
0.0305 lbs/ft² @ 3.6 mil dry film thickness

Note: 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.

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Equipment:



Equipment Type	Tip Size	Air Pressure	Fluid Flow
PROXs	1.5 or 1.8mm	72 - 87 psi (5 - 6 bar)	320 - 400ml/min
Conventional Air Spray	1.5 or 1.8mm	43 - 72 psi (3 - 5 bar)	

CA8620 can also be applied unthinned by brush or cloth.

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties



Colour:

Beige (8620A02250)
 Light Grey (8620E02211)



Gloss:

Not applicable



Drying Times @ 23°C (73°F) & 50% Relative Humidity			
		1 Vol.	0.5 Vol.
Dry to Tape @ 60 µm			
	CA8000C	3-4 hrs	3-4 hrs
	CA8000C2	1.5-2 hrs	2-3 hrs
Dry to Tape @ 90-120 µm		1 Vol.	0.5 Vol.
	CA8000C2	3-4 hrs	-
Dry to Sand @ 60 µm		1 Vol.	0.5 Vol.
	CA8000C	10-12 hrs	-
	CA8000C2	3-4 hrs	5-7 hrs
Dry to Sand @ 90-120 µm		1 Vol.	0.5 Vol.
	CA8000C2	10-12 hrs	-
Dry to Overcoat @ 60 µm		1 Vol.	0.5 Vol.
	CA8000C	4 hrs min. 72 hrs max.	6 hrs min. 72 hrs max.
	CA8000C2	2 hrs min. 72 hrs max.	4 hrs min. 72 hrs max.
Full Cure	7-9 days		

Note: For drying characteristics of unthinned properties please contact PPG.

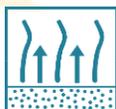
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Force Dry:

On Aluminium Alloy
On Composites

30 minutes air drying then 1 hour @ 60°C (140°F)
Please contact PPG for advice

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



Flash Off Time:

30 - 45 minutes between coats



VOC: (ASTM)

Mixed ready for use	375 g/Lt (2:1:1 mix ratio)
Mixed ready for use	320 g/Lt (2:1:0.5 mix ratio)
Mixed unthinned	245 g/Lt
CA8620 Base Component	310 g/Lt
CA8000B Activator	115 g/Lt
CA8000C Thinner	760 g/Lt
CA8000C2 Thinner	760 g/Lt



Flash Point:

CA8620 Base Component	29°C (84°F)
CA8000B Activator	47°C (116°F)
CA8000C Thinner	22°C (95°F)
CA8000C2 Thinner	22°C (72°C)

Shelf Life:

CA8620 Base Component	24 months in original unopened container
CA8000B Activator	24 months in original unopened container
CA8000C & C2 Thinner	24 months in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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, 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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