

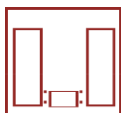
F565 Intermediate Coatings (EMEA)

Product Description

F565 is a two pack, pigmented, polyamide based coating formulated for use as intermediate coats in selectively strippable finish paint systems.

- High resistance to phosphate ester based hydraulic fluid
- Quick strippability with neutral, non chloride based strippers

Components



Mix Ratio (by volume)

- | | |
|------------------------|-----------|
| • F565 (Base) | 4 parts |
| • F275-189 (Activator) | 1 part |
| • T239 (Thinner) | 3-4 parts |

Specifications



F565 is qualified to:

- 741.140/21-00-00-0039-0T04/0A (F565-4010 Light Grey Only)
- AIMS 04-04-032 (F565-4010 Light Grey Only)
- AIMS 04-04-037 (F565-E03310 Yellow Only)
- AIMS 04-04-060 (F565-4010 Light Grey Only)
- BS2X35 A&B

Product Compatibility

F565 intermediate coat is compatible with the following primer specifications:

- | | | | |
|------------------|------------------|----------------|-----------------|
| • AIMS 04-04-001 | • AIMS 04-04-031 | • BAMS 656-009 | • DTD 5599 |
| • AIMS 04-04-002 | • AIMS 04-04-032 | • BMS 10-60 | • Mil-PRF-85285 |
| • AIMS 04-04-003 | • AIMS 04-04-034 | • BMS 10-72 | • MM 0114 |
| • AIMS 04-04-012 | • AIMS 04-04-036 | • BMS 10-79 | • MSRR 1003 |
| • AIMS 04-04-013 | • AIMS 04-04-037 | • DTD 5567 | |
| • AIMS 04-04-025 | • BAMS 565-002 | • DTD 5580 | |
| | • BAMS 656-009 | | |

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

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Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner DeSoto® CN20 or Desoclean™ 45 are recommended. Observe recommended overcoating windows between primers and intermediate coat and intermediate coat and topcoat.

Instructions for Use



Base may require mechanical agitation. Ensure all components are adequately dispersed. Add activator to base component and stir well, then add the thinner while stirring. It is recommended to sieve the mixing with 50 µm filters.

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.



Special Mixing Conditions :

Up to 30°C (86°F) - Add 3 volumes of thinner
Above 30°C (86°F) - Add 4 volumes of thinner



Induction Time:

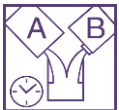
Not required



Viscosity: (23°C/73°F)

• AFNOR4	16-18 seconds
• BSB3	30-40 seconds
• FORD4	15-16 seconds
• ISO4	20-30 seconds
• ZAHN2	20-21 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	30-70%

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Application:

Apply 3 single horizontal passes of the gun to achieve recommended dry film thickness of 5 -10 µm (0.2-0.4 mil). Maintain constant agitation during the application process.



Theoretical Coverage: (mix ratio 4:1:4)

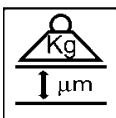
7 m²/Lt @ 7 µm dry film thickness

280 ft²/US gal @ 0.28 mil dry film thickness

Recommended Dry Film Thickness:

5 - 10 µm

0.2 - 0.4 (mil)



Dry Film Density:

1.5 g/cm³

12.5 lbs/US gal

Dry Film Weight: (mix ratio 4:1:4)

11 g/m² @ 7 µm dry film thickness

0.002 lbs/ft² @ 0.28 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.

Equipment:

F565 is compatible with the following spray equipment. When using with electrostatic equipment ensure that the E-Stats is set to off.



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

Before and immediately after using F565-4010 clean equipment using T239 thinner only until the solvent is clear. Failure to do so will result in equipment blockage.

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Physical Properties



Colour:

Light Grey (F565-4010)
Dark Grey (F565/C1746)
Yellow (F565-E03110)



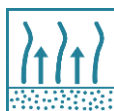
Gloss:

N/A



Drying Times @ 50 % R.H	23°C (73°F)	35°C (95°F)
Dust Free	15 minutes	
Dry to Tape	2 hours	
Re-coat with Self	30 minutes	
Dry to Overcoat	4 hours (min.) 48 hours (max.)	4 hours (min.) 48 hours(max.)
Full Cure	7 days	7 days

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



Flash Off Time:

Not required



VOC: (ASTM)

Mixed ready for use	780 g/Lt
F565 Base Component	770 g/Lt
F275-189 Activator	810 g/Lt
T239 Thinner	780 g/Lt



Flash Point:

F565 Base Component	23°C (73°F)
F275-189 Activator	23°C (73°F)
T239 Thinner	20°C (68°C)

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Shelf Life:

F565 Base Component	12 months in original unopened container
F275-189 Activator	24 months in original unopened container
T239 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.

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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