

Desofill™ HS CA8620G Sanding Surfacers

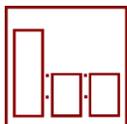
TECHNICAL DATA SHEET

Product Description

Desofill™ HS CA8620G sanding surfacer is a chromate-free, chemically cured, chemical and solvent resistant polyurethane coating. CA8620G is designed to fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces.

- Needs a corrosion resistant primer when going over aluminum substrates
- Compatible with Desothane® HS topcoats
- Excellent adhesion
- High build
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- | | |
|---------------------------------|---------|
| • CA8620G (base component) | 2 parts |
| • CA8000B (activator component) | 1 part |
| • CA8000C (thinner component) | 1 part |

Note: Quicker dry times can be achieved by using CA8000C1 and CA8000C2 thinners.

Note: CA8620LV is an exempt blend thinner version of CA8000C that gives a mixed and ready to use VOC of 350 grams/liter.

Specifications



CA8620G is qualified to:

- | | |
|--------------------------------|--------------|
| • BAMS 565-015 Class A Grade B | • GAMPS 3105 |
| • CMS-CT-904 | • MEP 10-070 |
| • DGT 99 993 | |

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

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Product Compatibility:

CA8620G is compatible with the following topcoat specifications:

- AIMS 04-04-012
- AIMS 04-04-013
- AIMS 04-04-024
- AIMS 04-04-031
- AIMS 04-04-032
- AMS 3095
- BAMS 565-002 Class A Grade B
- BAMS 565-009 Type II Grade B
- BMS 10-60 Type II Class B Grade D
- BMS 10-72 Type VIII
- BMS 10-125 Type III Grade D
- BMS 10-126 Type I Grade D
- CMFS037
- CMS-CT-101 Type I
- DHMS C4.04 Type VI Class B Grade B
- DMS 2143 Type 1 Class 1 Composition C
- DPM 6456
- DPM 6546
- FEDEX STANDARD
- GAMPS 3209
- GP110AEE
- MEP 10-069
- MM1276 Type II
- MS100029E Class HS
- RMS 430 Type II
- SMS-111207 Type 1
- VMS C4.04 Type VI Class B Grade B

Surface Preparation and Pretreatments



Desofill™ HS sanding surfacer CA8620G can be applied over clean, dry, intact primed aluminum and non-primed composite surfaces.

Instructions for Use



Mixing Instructions:

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

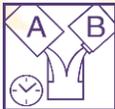
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Viscosity: (23°C/73°F)

- | | |
|-------------------------|------------------|
| • #2 Signature Zahn cup | 35 to 52 seconds |
| • #4 Ford cup | 25 to 40 seconds |
| • BSB4 cup | 30 to 46 seconds |
| • AFNOR #4 cup | 29 to 46 seconds |

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



Pot Life: 21 - 25°C (70-77°F)

Thinner	Time
CA8000C	3 hours
CA8620LV	3 hours
CA8000C1	2 hours
CA8000C2	1 hour

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 applying the surfacer. Stir the sanding surfacer slowly during the application. The suggested film thickness is 75 to 200 microns (3 to 10 mils). This can be accomplished by two or three medium coats with a 50% overlap. Note the first and second coat should be allowed to tack up before applying the second and third coat. If the next coat is applied before the previous coat has tacked up, sagging may occur.

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.



Theoretical Coverage:

- 21 square meters/liter at 25 microns dry film (850 square feet/gallon at 1 mil dry film)
- Recommended dry film thickness before sanding; 75 to 200 microns (3 to 10 mils)
- Recommended dry film thickness after sanding; 25 to 125 microns (1 to 5 mils)

Note: CA8620G should be sanded before top coating.

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Dry Film Density:

1.72 grams/cubic centimeter (14.3 pounds/gallon)

Dry Film Weight

43 grams/square meter at 25 microns dry film (0.0089 pounds/square feet at 1 mil dry film)


Equipment:

Desofill™ CA8620G sanding surfacer 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

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Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
CA8000C Thinner			
Tack Free	2 hours	1 ½ hours	1 hour
Dry to Sand	10 hours	9 hours	8 hours
Topcoat After Sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days
CA8620LV Thinner			
Tack Free	2 hours	1 ½ hours	1 hour
Dry to Sand	10 hours	9 hours	8 hours
Topcoat After Sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days
CA8000C1 Thinner			
Tack Free	1 hour	1 hour	45 minutes
Dry to Sand	8 hours	7 hours	6 hours
Topcoat After Sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days
CA8000C2 Thinner			
Tack Free	45 minutes	30 minutes	20 minutes
Dry to Sand	6 hours	5 hours	4 hours
Topcoat After Sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days

Accelerated cure with CA8000C Thinner for dry to sand:

Allow 60 minutes flash off at 24°C ± 3°C (75°F)
 followed by 1 ½ hours at 60°C (140°F)

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VOC

VOC:

Mixed, ready to use VOC (EPA method 24) with CA8000C	420 grams/liter
Mixed, ready to use VOC (EPA method 24) with CA8620LV	350 grams/liter
Base Component	350 grams/liter
Activator Component	113 grams/liter
CA8000C Thinner Component	864 grams/liter
CA8620LV Thinner Component	884 grams/liter



Flash point closed cup:

Base Component	16°C (60°F)
Activator Component	47°C (117°F)
CA8000C Thinner Component	24°C (75°F)
CA8620LV Thinner Component	15°C (60°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:

Asia Pacific

ASC – Australia

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Fax 61 (3) 9335 3490

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PRC-DeSoto International, Inc.
12780 San Fernando Road
Sylmar, CA 91342
www.ppgaerospace.com

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