



Desoprime™ HS CA7236 Chrome-Free Epoxy Primer

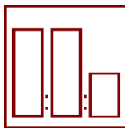
TECHNICAL DATA SHEET

Product Description

Desoprime™ HS CA7236 is a high solids, chrome-free, corrosion inhibiting epoxy primer. CA7236 is designed for use on military aircraft exterior substrates such as composites and aluminum. Qualified to MIL-PRF-32239 System Specification with DesoGel™ EAP-9 pretreatment and Desothane® HS CA9311 polyurethane topcoat.

- Chrome-free
- Excellent adhesion and corrosion resistance
- Compatible with Desothane® HS topcoats
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- | | |
|---------------------------------|----------|
| • CA7236A (base component) | 1 part |
| • CA7236B (activator component) | 1 part |
| • CA7236C (thinner component) | 0.5 part |

Specifications



CA7236 is qualified to the following specification:

- MIL-PRF-32239

CA7236 primer meets the performance requirements of:

- MIL-PRF-23377 Type I Class N

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

Product Compatibility:

CA7236 primer is compatible with the following topcoat specifications:

- | | |
|------------------|-----------------|
| • AIMS 04-04-036 | • DMS 2115 |
| • MMS-420 | • MIL-PRF-85285 |
| • MIL-PRF-32239 | |



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Surface Preparation and Pretreatments



CA7236 can be applied on scuffed and cleaned composite surfaces or over aluminum substrates coated with surface pretreatment DesoGel™ EAP-9.

Instructions for Use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. The activator component should be stirred by hand before mixing. Add 1 volume of activator to 1 volume of base component and mix to uniformity before adding 0.5 volume of thinner. 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:

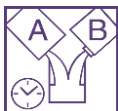
| Temperature | 22 - 28°C (71 - 84°F) |
|-------------------------|--------------------------|
| Induction Time Required | 30 minutes |



Viscosity: (23°C/73°F)

- #4 Ford cup 30 seconds maximum

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



Pot Life:

4 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 while the primer is being applied. The suggested film thickness is 20 to 30 microns (0.8 to 1.2 mils). This can be accomplished by one medium coat with a 50% overlap. After applying primer, a close inspection is recommended to ensure a continuous coating was applied. The primer will appear translucent. It should not be applied to full hide.

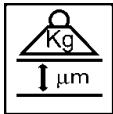
These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.



Theoretical Coverage:

18.9 square meters/liter at 25 microns dry film (773 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 15 to 25 microns (0.6 to 1.0 mils)



Dry Film Density:

0.704 grams/cubic centimeter (5.878 pounds/gallon)

Dry Film Weight:

37 grams/square meter at 25 microns dry film (0.00760 pounds/square feet at 1 mil dry film)

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Equipment:

CA7236 primer 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: White



Gloss: Not Applicable



| Dry Times | 22 - 28°C (71 - 84°F) |
|----------------|-------------------------------------|
| Dust Free | 2 hours |
| Dry Through | 5 - 7 hours |
| Dry to Topcoat | 5 hours minimum 72 hours maximum |
| Full Cure | 7 days |

Accelerated cure for dry hard:

Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
followed by 60 minutes at 49°C (120°F)



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VOC

VOC:

| | |
|--|-----------------|
| Mixed, ready for use VOC (EPA method 24) | 340 grams/liter |
| Base Component | 456 grams/liter |
| Activator Component | 10 grams/liter |
| Thinner Component | 0 grams/liter |



Flash point closed cup:

| | |
|---------------------|-------------|
| Base Component | 16°C (60°F) |
| Activator Component | -14°C (7°F) |
| Thinner Component | -16°C (4°F) |

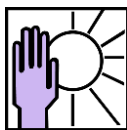
Shelf Life:

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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