



Desoprime™ CF/CA7501

TECHNICAL DATA SHEET

Product Description

Desoprime™ CF/CA7501 epoxy primer is a high solids non chromated epoxy coating used on aircraft non-metallic exterior substrates.

- Chromate free
- Compatible with Desothane® HS topcoats
- Passes the rain erosion test
- Excellent adhesion and Skydrol® resistance
- Compatible with all current spray equipment
- Can be applied in a wide range of conditions
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- CA7501A (base component) 1 part
- CA7501B (activator component) 1 part

Specifications



CA7501 primer is qualified to:

- BMS 10-118 Type I & Type II

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

Product Compatibility:

CA7501 is compatible with the following topcoats:

- | | |
|------------------------------|-----------------|
| • AIMS 04-04-013 | • DMS 2143 |
| • BAMS 565-009 | • DPM 6456 |
| • BMS 10-60 Type I & Type II | • DPM 6546 |
| • BMS 10-72 Type VIII | • MEP 10-069 |
| • BMS 10-125 Type III | • MIL-PRF-85285 |
| • CMS-CT-101 | • MM1276 |
| • DMS 2115 | |



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Surface Preparation and Pretreatments



CA7501 chrome free epoxy primer is used over clean, dry, intact composite substrates.

Instructions for Use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. CA7501B activator should be stirred by hand before mixing. Add activator to base component and stir well. Maintain constant agitation for 10 minutes to ensure proper mixing. Induction time may be required based on temperature.

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:

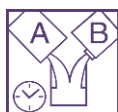
Temperature	13 - 18°C (55 - 64°F)	18 - 23°C (65 - 74°F)	24 - 29°C (75 - 84°F)	>29°C (>85°F)
Induction Time Required	1 ½ hours	1 hour	30 minutes	None



Viscosity: (23°C/73°F)

- | | |
|-------------------------|------------------|
| • #2 Signature Zahn cup | 15 to 19 seconds |
| • #4 Ford cup | 11 to 15 seconds |
| • ISO 3mm cup | 36 to 50 seconds |
| • ISO 4mm cup | 17 to 22 seconds |
| • BSB3 cup | 25 to 30 seconds |
| • BSB4 cup | 14 to 17 seconds |
| • AFNOR #2.5 cup | 41 to 56 seconds |
| • AFNOR #4 cup | 14 to 16 seconds |

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



Pot Life:

5 hours @ 21 - 25°C (70 - 77°F)
3 hours @ >35°C (>95°F)

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Application Guidelines

Recommended Application Conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

Application:

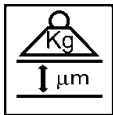
Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 20 to 30 microns (0.6 to 1.2 mils). This can be accomplished with one medium coat with a 50% overlap.

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 square meters/liter at 25 microns dry film (722 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 20 to 30 microns (0.6 to 1.2 mils)



Dry Film Density:

1.76 grams/cubic centimeter (14.66 pounds/gallon)

Dry Film Weight:

44 grams/square meter at 25 microns dry film (0.009 pounds/square feet at 1 mil dry film)



Equipment:

CA7501 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)



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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



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Dust Free	1 - 1 ½ hours	½ - 1 hours	15 - 30 minutes
Tack Free	2 - 3 hours	1 - 2 hours	30 - 60 minutes
Dry to Tape	3 - 4 hours	2 - 3 hours	1 - 2 hours
Dry to Topcoat	3 - 24 hours	2 - 24 hours	1 - 24 hours
Dry to Fly	96 hours	72 hours	48 hours
Full Cure	7 days	7 days	7 days
Overcoat Time with CA8000 CA8800 CA9008	2 - 72 hours	2 - 72 hours	2 - 72 hours
Overcoat Time with CA9000	5 - 24 hours	4 - 24 hours	3 - 24 hours

Accelerated cure:

Allow 30 minutes flash off at 24°C ± 5.6°C (75°F ± 10°F)
followed by 30 minutes at 49°C (120°F) for dry to topcoat

VOC

VOC (EPA method 24):

Mixed, ready to use VOC	350 grams/liter
Base Component	382 grams/liter
Activator Component	258 grams/liter



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Flash point:

Base Component
Activator Component

16°C (60°F)
-4°C (24°F)

Shelf Life:

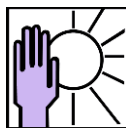
12 months from date of manufacture according to the specification. Consult the specification to verify shelf life requirements.

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:

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