



# Desoprime™ CA7502 Chrome-Free Epoxy Primer

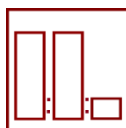
## TECHNICAL DATA SHEET

### Product Description

Desoprime™ CA7502 chrome-free high solids epoxy primer is designed for use on aircraft exterior and/or exterior detail parts (components). It is currently in use by Original Equipment Manufacturers, airlines and third party paint facilities worldwide.

- Chrome-free
- Urethane topcoat compatible
- Passes rain erosion test
- Excellent adhesion and corrosion resistance
- Excellent fluid 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):

- |                                 |             |
|---------------------------------|-------------|
| • CA7502A (base component)      | 4 parts     |
| • CA7502B (activator component) | 4 parts     |
| • CA7502C (thinner component)   | 1 part      |
| • G Kit Yield                   | 2 ¼ gallons |

### Specifications



CA7502 primer is qualified to:

- |  |              |
|--|--------------|
| • BMS 10-72 Type VIII, IX, X<br>Composition NC | • CMS-CT-201 |
|  | • PWA 36525  |

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



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## Product Compatibility:

CA7502 is compatible with the following topcoats:

- AMS 3095
- BAC 5312
- BAMS 565-002 Class A Grade B
- BAMS 565-009 Type II Class 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
- D6-1816
- 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



CA7502 can be applied over composites, aluminum prepped with DesoGel™ EAP-9, DesoGel™ EAP-12 or chemical conversion coatings per MIL-DTL-5541, and chromic acid anodized aluminum.

## Instructions for Use



### Mixing Instructions:

Prior to mixing, thoroughly shake the base component. The activator component should be stirred by hand before mixing. Add activator to base component and stir well, and then add CA7502C thinner under agitation. 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 - 21°C (55 - 70°F)	22 - 26°C (71 - 80°F)	>27°C (>80°F)
Induction Time Required	2 hours	1 hour	30 minutes



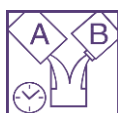
## Desoprime™ CA7502 Chrome-Free Epoxy Primer



### Viscosity: (23°C/73°F)

• #2 Signature Zahn cup	15 to 19 seconds
• #4 Ford cup	12 to 15 seconds
• ISO 4mm cup	18 to 22 seconds
• BSB3 cup	26 to 30 seconds
• BSB4 cup	15 to 17 seconds
• AFNOR #4 cup	15 to 16 seconds

*Note: Viscosities quoted are the 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	20 - 90%

### Application:

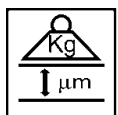
Ground the aircraft and the application equipment before priming. The suggested dry film thickness is 12.5 to 30 microns (0.5 to 1.2 mils). This can be accomplished with one medium coat with a 50% overlap. After applying primer, a close inspection is recommended to ensure a continuous coating was applied. The primer should appear translucent and 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 square meters/liter at 25 microns dry film (722 square feet/gallon at 1 mil dry film)  
Recommended dry film thickness; 12.5 to 30 microns (0.5 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)

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## Equipment:

CA7502 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:** Gray



**Gloss:** Not Applicable



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Dust Free	2 - 3 hours	½ - 1 ½ hours	¼ - 1 ¼ hours
Dry to Tape	3 - 4 hours	2 - 3 hours	2 - 3 hours
Dry to Fly	72 hours	48 hours	24 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 hours minimum	4 hours minimum	3 hours minimum



## Desoprime™ CA7502 Chrome-Free Epoxy Primer

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
Thinner Component	0 grams/liter



#### Flash point closed cup:

Base Component	16°C (60°F)
Activator Component	-4°C (24°F)
Thinner Component	-9°C (15°F)

#### Shelf Life:

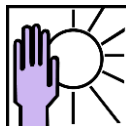
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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](http://www.ppgaerospace.com)**

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