Technical Data

PPG Aerospace
PRC-DeSoto

Product Name	**CA40000** (5690/)	
Product Description	High Durability Polyurethane Finish	
Key Features	CA40000 is a two pack, ambient curing polyurethane finish possessing excellent durability with maximum gloss retention, with excellent chemical resistance and adhesion characteristics. A wash primer / polyurethane primer scheme, P99 / PAC33 can be used where chemical pre-treatment is not chosen.	
Specifications – Approval	Airbus Airbus BAE BS ISO	TN A.007.10028 TN A.007.10113 AVN 7-004 BS2X34A
Specifications – Performance	Airbus	AIMS 04.04.012
Catalyst/Hardener/Activator	0796/9000	
Thinner/Reducer	Standard Accelerator thinner High temperature thinner	0576/9000 0945/9000 0559/9000
Pack Size	5690/ 0796/9000 Thinner	1 and 5 litre 1 and 5 litre 1 and 5 litre
Mix Ratio	5690/ 0796/9000 Thinner	1 Volume 1 Volume viscosity
Recommended Schemes	Apply over suitably prepared primed surface. P99 Wash Primer / PAC33 polyurethane primer. Product may also be applied over other high solids and conventional solids primers.	

Product Application Parameters

Surface Preparation	Ensure surface is clean and sound and free from any contaminants
Preparation	Ensure all pigmented components are stirred and all pigment is adequately dispersed by low speed mechanical agitation, manual stirring or use of paint shakers.
Mixing	Add hardener to base component and stir well. Add thinner to achieve the recommended viscosity. See notes for 2 and 3 coat system.

APPLICATION

It is an option to apply CA 40000 in either 2 or 3 coats and with certain colours to ensure opacity 3 coats will be required.

STANDARD 2 COAT APPLICATION

For the first coat mix the CA40000 equal volumes 1 – 1 with the activator mix thoroughly and add 0.5 volume of the chosen thinner. Apply one single track light wet closed coat, allow to dry for a period of between 30 – 60 minutes before applying the 2nd coat. For the 2nd coat mix the CA40000 equal volumes 1 – 1 with the activator mix thoroughly and add 0.75 volume of the chosen thinner. Apply one double track or cross coat, to achieve the required dry film thickness of 50 – 70µm.

3 COAT APPLICATION

For the first coat mix the CA40000 equal volumes 1 – 1 with the activator mix thoroughly and add 0.75 volume of the chosen thinner. Apply one single track light wet closed coat , allow to dry for a period of between 30 – 60 mins before applying the 2nd coat. For the 2nd coat mix the CA40000 equal volumes 1 – 1 with the activator mix thoroughly and add 1 volume of the chosen thinner. Apply one single track wet closed coat and allow to dry for a period of between 30 – 60 mins before applying the 3rd and final coat. For the 3rd coat mix and apply the material as per the 2nd coat to achieve the required finish and dry film thickness of 50 – 70µm.

NOTE : These guidelines are designed to assist the refinisher achieve the desired standard but should further information be required please contact the Technical Service Department.

Viscosity

Cup	Electrostatic Eg. 4500	Airless	Air Assisted	HVLP or Pro X 2
BSB3	24 – 26	24 – 26	26 – 28	26 – 28
AFNOR 2.5	40 – 45	40 – 45	45 – 50	45 – 50
DIN 4	12 – 13	12 – 13	13 – 14	13 - 14
ISO 3mm	30 – 37	30 – 37	37 – 44	37 – 44
Ford 4	12 - 16	12 - 16	12 - 16	12 – 15

Induction Time Not Required
Pot Life @ 23C With 0576/9000 3 - 4 Hrs @ 23C
With 0945/9000 2 Hrs @ 30C

Recommended Application Conditions
Temperature 15 – 35 C
Relative Humidity 20 – 85 %

Application Equipment

Equipment Type	Tip Size	Pressure (Bar)
Airmix	611	3 – 4 bar
HVLP Air Spray	1.6 mm	2 - 3 bar
Conventional Air Spray	1.6 mm	3 - 4 bar
Airless	9 – 11 thou	4 bar
Air-assisted Airless Electrostatic	9 – 11 thou	3 – 4 bar
Low Pressure Electrostatic	1.0 – 1.2	4 bar

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Equipment Cleaning Thoroughly clean with CN20 cleaner.

Dry Film Thickness 50 – 70 µm depending upon surface profile

Drying Times@23C

	With 0576/9000	With 0945/9000
Dry to overcoat	30-60 minutes	30-60 minutes
Dry to Tape	10 – 12 hours	3 – 4 hours
Dry to Fly	48 hours	48 hours
Full Cure	7 days	7 days

Special Notes

Physical Characteristics

Colour	as required	
Gloss	full gloss	
Coverage	4 - 6 m2 per litre @ 50 µm	
Dry Film Density	1.7 g/cm^3	
VOC Content (Ready for use)	645 g/lt	
Flash Point	5690/	-17 - +21° C
	0796/9000	23° C
	0576/9000	-7°C
	0945/9000	-7°C
	0559/9000	-7°C
Shelf Life	24 Months in original unopened containers	
Storage Conditions	5° to 35° C	

Health & Safety

This product is safe to use and apply when recommended precautions are observed. Before using this product it is important to read and understand the Material Safety Data Sheet. This provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. Material Safety Data Sheets are available on request.