PPG Aerospace
PRC-DeSoto

Technical Data

Product Name	PAC33CF (4360/3031) Beige, (4360/2015) Grey
Product Description	PAC33CF chromate-free polyurethane primer 4360/3031
Key Features	PAC33CF is a two-component, ambient curing, polyurethane primer, characterized by high chemical resistance and flexibility, and is designed to be used over PAC99 etch primer for the exterior finishing of civil aircraft.
Specifications – Approval	-
Specifications – Performance	When used over wash primer P99, TN A.007.10113, AIMS 04.04.012 and AMS3095
Catalyst/Hardener/Activator	0736/9000
Thinner/Reducer	0433/9000
Pack Size	-
Mix Ratio	5:1:4-5 by volume
Recommended Schemes	When used over wash primer P99, PAC33CF and under CA8000 or CA40000 meets the performance requirements of TN A.007.10113 and AIMS 04-04-012

Product Application Parameters

Surface Preparation	Ensure that the correct surface pre-treatment has been carried out and that drying and overcoat times within the process are strictly adhered to.
Preparation	Ensure the surface is clean and sound and free from any contaminants and that temperature and humidity are within specified process limits.
Mixing	Hand stir or mechanically agitate base material until all pigment is uniformly dispersed. Add one volume of 0736/9000 to five volumes of base, mix thoroughly and thin to viscosity using approximately 4 to 5 volumes of thinner 0433/9000.
Viscosity	AFNOR2.5 45 – 55 seconds BSB4 18 – 20 seconds DIN4 13 – 14 seconds ISO 3 39 – 54 seconds
Induction Time	none required
Pot Life	4 hours
Application Method	Apply one wet even coat with 50% overlap from each stroke or a double track or cross coat to achieve a dry film thickness of 15 – 25µm
Conditions	Temperature 15 – 35°C Humidity 35 – 70%

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Application Equipment PAC33CF is compatible with all types of spray equipment. For further information, please consult the relevant Scheme Sheets.

Equipement	Tip size	Flow rate	Air Pressure (Bar)
Airmix Kremlin	∅ = 0.28 mm - Angle 60° Ref : 06.134	320 – 360 ml/min	50 – 60 bars
HVLP	1,2 mm		1,5 - 2 bars
Conventional Air Spray	1,5 mm		3 – 4 bars
Airless	**Not recommended**		
Airless Air assisted	609 – 611	360 ml / min	50 - 60 bars
PRO 3500 or Pro XS4	1,2 ou 1,5 mm	360 ml / min	5 - 6 bars

Equipment Cleaning Cleaners CN20 or CN44 are recommended
Dry Film Thickness 15 – 25 µm

Drying Times at 23°C 50% RH

Dust Free	30 – 40 minutes
Dry To Tape	2 – 3 hours
Re-coat with self	0.5 – 72 hours
Dry to Overcoat	1 – 72 hours
Full Cure	7 days

Flash Off Time

Not applicable

Physical Characteristics

Colour Beige or grey
Gloss -
Coverage 15m^2/litre @ 20 microns
Dry Film Density -
VOC Content 600g/litre
(Ready for use)
Flash Points 4360/3031 (Base) 5ºC
0736/9000 (Activator) 40ºC
0433/9000 (Thinner) 18ºC
Shelf Life 24 months from date of manufacture.
Storage Conditions 5-35ºC in the original unopened containers. Partly used containers must be resealed immediately after use. Once opened, activator 0736/9000 must be resealed immediately.

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.

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