PPG Aerospace
PRC-DeSoto

Technical Data

Product Name	**PR 143**
Product Description	PR 143 Epoxy Primer
Key Features	PR143 is a two-pack, ambient curing, epoxy primer developed for the internal and external protection of aircraft. The base component contains strontium chromate for long-term corrosion inhibition. Fully cured PR143 possess excellent resistance to aircraft fluids such as phosphate ester hydraulic oils and, combined with its superior water resistance and adhesion characteristics, offers a significant advantage over conventional epoxy primers.
Specifications – Approval	AVN 7-003 PPG - AFS 1806, PPG -AFS 1835, BS2X33B PPG-DTD900/6064 ABR 7-0133
Specifications – Performance	Meets the performance requirements of Mil-P-23377 type 1 and 2 (black)
Catalyst/Hardener/Activator	ACT143
Thinner/Reducer	T187 or T17
Pack Size	5 litre base, 2.5 hardener, 5 litre thinner
Mix Ratio	2:1:1
Recommended Schemes	Can be applied over chemically pre-treated surfaces, wash primer PR30B or over flatted / abraded painted surfaces

Product Application Parameters

Surface Preparation	Ensure correct surface pre-treatment has been carried out and that drying and overcoat times within the process are adhered to.	
Preparation	Ensure the surface is clean, dry, free of contaminants and that temperature and humidity are within acceptable limit.	
Mixing	Hand stir or mechanically shake the base material until all the pigment is uniformly dispersed. By volume add one part Activator 143 to two parts base and mix thoroughly before adding solvent T187 (approx 1 volume) to the recommended viscosity.	
Viscosity	BS B3	26-30 seconds
	DIN 4	13-14 seconds
	FORD 4	15-17 seconds
	AFNOR 2.5	45-55 seconds
Induction Time	None required	
Pot Life	8 hours	
Application Method	Apply one wet even cross-coat to achieve a dry film thickness 15 – 25µm	
Recommended Application Conditions	Temperature	15 – 30°C
	Relative Humidity	20 – 80%

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Application Equipment PR 143 is compatible with all types of spray equipment.

Equipment Type	Tip Size	Pressure (Bar)
Airmix	9 – 11 thou	50-60
HVLP Air Spray	1.2mm	1.5 - 2
Conventional	1.5mm	3 - 4
Airless	9 – 11 thou	4 - 6
Air-assisted Airless	609 – 611	50 - 60
Low Pressure Electrostatic	1.2 – 1.5mm	5-6

Equipment Cleaning CN20
Dry Film Thickness 15 – 25µm

Drying Times

	23°C	70ºC	125ºC
Dry to Handle	40 min		
Dry To Tape	4 hrs		
Dry To Mask	4 hrs		
Hard dry	6 hrs		
Re-coat with self	30 min		
Dry to Overcoat	4-48 hrs		
Full Cure	24 hrs	3 hours	1 hour

Flash-Off Time 15 minutes before force dry

Physical Characteristics

Colour Yellow, green and black
Gloss N/A
Coverage 12-16 m² / litre @ 15-20µm
Dry Film Density 1.72 yellow, black 2.2g/cm^3
VOC Content 675g/litre
(Ready for use)
Flash Point PR 143 23°C ACT 143 23°C
T 187 30°C
Shelf Life 24 Months. Once opened, ACT143 must be used within two months.
Storage Conditions 5° to 35°C in the original unopened containers. Partly sealed containers must be re-sealed immediately after use.

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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