

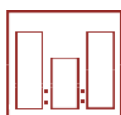
Desothane® HD 9008B0900D Buffable Clear Coat

Product Description

Desothane® HD 9008B0900D is a buffable clear coat intended to be used over Desothane® HD 9008 Basecoat. 9008B0900D can also be used as a buffable clear coat over pigmented polyurethane topcoats such as Desothane® HS CA8000 and CA8800.

- High solids, low VOC
- Flexible, chemical resistant polyurethane varnish
- Excellent UV durability, colour & gloss retention
- Easy to apply in a wide range of environmental conditions
- Extended service life
- Buffable and easy to clean
- Service Temperature - 54°C to 177°C (-65°F to 350°F)

Components



Mix Ratio (by volume)

- | | |
|-----------------------------|---------|
| • 9008B0900D (Base) | 3 parts |
| • 9008B (Activator) | 2 parts |
| • 9008CR (Standard Reducer) | 3 parts |
| or | |
| 9008CS (Summer Reducer) | |
| or | |
| 9008CSR (Slow Reducer) | |
| or | |
| 9008CV (Fast Reducer) | |

Specifications



9008B0900D is qualified to:

- | | |
|------------------|------------------------|
| • AIMS 04-04-023 | • AIMS 04-04-037 |
| • AIMS 04-04-025 | • AMS 3095 |
| • AIMS 04-04-033 | • ECS 7379 |
| | • RRJ 0000-RE-811-3173 |

9008B0900D meets the performance requirements of:

- BMS 10-72

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Product Compatibility

9008B0900D is compatible with the following topcoat/basecoat specifications:

- AIMS 04-04-025
- AIMS 04-04-031
- AIMS 04-04-032
- BAMS 565-002
- BAMS 565-009
- BMS 10-11
- BMS 10-60
- BMS 10-72
- BMS 10-79
- DMS 2014

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

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner. Desoclean™ 110 or DeSoto® CN13 solvent cleaners are recommended. Observe recommended overcoating windows.

Instructions for Use



Base component should be manually agitated only. Add activator to base component and stir well, then add reducer while stirring.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.



Induction Time:

Not required



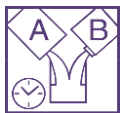
Viscosity: (23°C/73°F)

- | | |
|-------------------------|-----------------|
| • AFNOR4 cup | 14 - 16 seconds |
| • BSB3 cup | 24 - 31 seconds |
| • BSB4 cup | 14 - 18 seconds |
| • FORD4 cup | 11 - 16 seconds |
| • ISO4 cup | 16 - 24 seconds |
| • #2 Signature ZAHN cup | 15 - 20 seconds |

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

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Pot Life:

	Using 9008CR	Using 9008CS	Using 9008CV	Using 9008CSR
Pot Life @ 23°C (73°F)	2 hours	2 hours	1 hour	2 hours
Pot Life @ 30°C (86°F)	2 hours	2 hours	1 hour	2 hours

Application Guidelines

Recommended Application Conditions:

Relative Humidity 30-85%	Using 9008CR	Using 9008CS	Using 9008CV	Using 9008CSR
Temperature	15-35°C (59°C-95°F) with Airspray Graco XS3. 15-28°C (59°C-82°F) with LP gun	28-35°C (82-95°F)	15-23°C (59°-73°F)	>30°C (86°F)

Application:

Apply one cross coat (cross coat definition - apply one medium, wet horizontal and one medium wet vertical coat) to a dry film thickness of 25-30 microns (1 to 1.2 mils) Apply a second cross coat to achieve total dry film thickness of 50-70 (2.0-2.8 mils). See drying time table for inter-coat times.

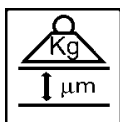


Theoretical Coverage: (ready for use)

9 m²/Lt @ 50 µm dry film thickness
360 ft²/US gal @ 2 mil dry film thickness

Recommended Dry Film Thickness:

- 1 Coat: 25 - 30 µm (1 - 1.2 mil)
- 2 Coat: 50 - 70 µm (2 - 2.8 mil)



Dry Film Density:

1.14 g/cm³
9.6 lbs/US gal

Dry Film Weight:

57 g/m² @ 50 µm dry film thickness
0.011 lbs/ft² @ 2 mil dry film thickness

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Note: These application guidelines represent PPG's best advice for usage in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.

Equipment:



Equipment Type	Tip Size	Flow Rate	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12oz./min)	10 to 40 psi (0.69 to 2.8 bar)	50 to 70 psi (3.5 to 5 bar)
Electrostatic Air Assisted Airless Spray Gun	611 through 612 711 through 712	240-350 ml/min (8-12oz./min)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1bar)
High Volume Low Pressure Spray Gun (HVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Low Volume Low Pressure Spray Gun (LVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)		29 psi (2 bar)

Note: Contact your local Technical Service Representative for information on use of alternative application equipment.

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44, Desoclean™ 45 or PPG MB28 solvent cleaners are recommended.

Repair:

If the clear coat has to be repaired, abrade with 400 sand paper then Scotch-Brite™. Clean with Isopropyl Alcohol Cleaner to remove finger or adhesive marks. Finally clean with a tack rag prior to applying a further cross coat of the clearcoat.

Physical Properties



Colour:

Colourless



Gloss:

>90 units with a 60° gloss meter (When applied over 9008 basecoat)

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Drying Times:

DRYING TIMES	Using 9008CR @ 23°C (73°F) 50% R.H.	Using 9008CS @23°C (73°F) 50% R.H.	Using 9008CSR @35 °C (95°F) 80% R.H.
Time Between Coats	30 mins -2 hours	30 mins -2 hours	30 mins -1 hours
Full Cure	7 days		
9008 Basecoat Overcoat Time	Minimum 2 hours - Maximum 5 days		

DRYING TIMES	Using 9008CR	Using 9008CS	Using 9008CV	Using 9008CSR
Dry to Tape @ 23°C (73°F)	13-17 hours	13-17 hours	5-7 hours	N/A
Dry to Tape @ 30°C (86°F)	6-8 hours	6-8 hours	N/A	6-8 Hours
Sagging Limit @ 15°C (59°F)	85µm in 2 coats	N/A	85µm in 2 coats	N/A
Sagging Limit @ 23°C (73°F) & 55% RH	1 st coat:35µm 2 nd coat:100 µm	N/A	1 st coat:35µm 2 nd coat:100µm	N/A
Sagging Limit @ 30°C (86°F) & 80% RH	Pass: 100 µm in 2 coats	1 st coat:30-35µm 2 nd coat:60µm Total:90-95µm	N/A	1 st coat:25µm 2 nd coat:55µm Total:80µm

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

Accelerated Cure:

15-30 minutes flash off, followed by 75 minutes at 60°C (140°F) for full cure.



Special Note:

For aircraft re-painting a minimum period of 48 hours is recommended before flying.

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VOC

VOC: (ASTM)

Mixed ready for use	<520 g/Lt
9008B0900D Base	340 g/Lt
9008B Activator	110 g/Lt
9008CR Reducer	880 g/Lt
9008CS Reducer	860 g/Lt
9008CSR Reducer	890 g/Lt
9008CV Reducer	870g/Lt



Flash Point:

9008B0900D Base	22°C (72°F)
9008B Activator	47°C (166°F)
9008CR Reducer	23°C (73°F)
9008CS Reducer	38°C (100°F)
9008CSR Reducer	40°C (104°F)
9008CV Reducer	23°C (73°F)

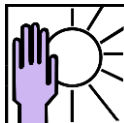
Shelf Life:

9008B0900D Base	24 months in original unopened container
9008B Activator	24 months in original unopened container
9008CR Reducer	24 months in original unopened container
9008CS Reducer	24 months in original unopened container
9008CSR Reducer	24 months in original unopened container
9008CV Reducer	24 months in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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:

Asia Pacific

ASC – Australia

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Fax 61 (3) 9335 3490

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Fax 44 (0) 1388 770288

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1 (818) 362-6711 or 1-800-AEROMIX

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