

Primer 90 Green

TECHNICAL DATA SHEET

Product Description

Primer 90 is a two component epoxy primer, designed for internal & external protection of aircraft.

- Excellent fluid resistance
- Excellent corrosion resistance
- Direct adhesion primer

Components



Mix Ratio (by volume)

- | | |
|-------------------------|-----------------|
| • 4120/3600 (Base) | 1 part |
| • 0611/9000 (Activator) | 1 part |
| • 0515/9000 (Thinner) | 0.1 - 0.2 parts |

Specifications



Primer 90 is qualified to:

- TN-A-007-10012

Primer 90 meets the technical requirements of:

- MIL-P-23377

Product Compatibility

Primer 90 is compatible with the following topcoat specifications:

- AIMS 04-04-003
- AIMS 04-04-012

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

Surface Preparation and Pretreatment



Ensure surface to be painted is clean, dry and intact using a high performance solvent cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Primer 90 Green

Instructions for Use



Hand stir or mechanically shake base material until all components are uniformly dispersed. Slowly add activator to base while stirring. Add required thinner 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:

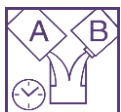
Not required



Viscosity: (23°C/73°F)

- | | |
|----------|-----------------|
| • AFNOR4 | 15 – 17 seconds |
| • BSB3 | 27 - 33 seconds |
| • FORD4 | 13 - 16 seconds |
| • ISO3 | 41 - 59 seconds |
| • ZAHN2 | 16 - 21 seconds |

Note: Viscosities quoted are 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	30 - 80%

Application:

Apply 1 cross coat to achieve the recommended dry film thickness 15 - 25 µm



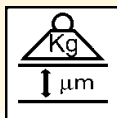
Theoretical Coverage: (mixed unthinned)

14 m²/Lt @ 20 µm dry film thickness
560 ft²/US gal @ 0.8 mil dry film thickness

Recommended Dry Film Thickness:

15 - 25 µm
0.6 - 1 mil

Primer 90 Green

**Dry Film Density:**

1.80 g/cm³
15.0 lbs/US gal

Dry Film Weight:

36 g/m² @ 20 µm dry film thickness
0.007 lbs/ft² @ 0.8 mil dry film thickness

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	Tip Size	Air Pressure
Conventional Air Spray	1.5 mm	43 to 58 psi (3 to 4 bar)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto[®] CN20, Desoclean[™] CN44 solvent cleaners are recommended.

Physical Properties

**Colour:**

Green

**Gloss:**

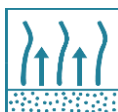
<5 units with a 60° gloss meter

Primer 90 Green



Drying Times @ 50 % R.H.	23°C (73°F)	70°C (158°F)
Dry to Touch	15 minutes	
Dry to Overcoat	2 to 72 hours	30 minutes
Dry to Handle	2 hours	
Dry to Tape	2.5 hours	
Full Cure	7 days	3 hours

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



Flash Off:

30 minutes prior to overcoating or force drying



VOC: (ASTM)

Mixed unthinned	605 g/Lt
4120/3600 Base	470 g/Lt
0611/9000 Activator	740 g/Lt
0515/9000 Thinner	870 g/Lt



Flash Point:

4120/3600 Base	12°C (54°F)
0611/9000 Activator	20°C (68°F)
0515/9000 Thinner	9.5°C (49°F)

Shelf Life:

4120/3600 Base	24 months in original unopened container
0611/9000 Activator	24 months in original unopened container
0515/9000 Thinner	10 years 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.

Primer 90 Green

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.



Primer 90 Green

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:

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