

## CA7012 HS Chromate Free Epoxy Primer

### Product Description

CA7012 is a two component, chromate and lead free epoxy, corrosion inhibiting primer. CA7012 is suitable for use on fibre reinforced composite materials, suitable pretreated aluminium substrates, titanium and corrosion resistant steels.

- High solid, low VOC
- Excellent fluid resistance & adhesion characteristics
- Compatible with polyurethane topcoats
- Also available in military grades - (separate TDS available on request, may be subject to military export control restrictions)

### Components



#### Mix Ratio (by volume)

- CA7012 (Base) 3 parts
- CA7012B (Activator) 1 part

### Specifications



CA7012 is approved to:

- SP-J-513-A-0013 Type II Class A

#### Product Compatibility

CA7012 is listed on the following specifications:

- SP-J-513-A-0014
- SP-J-513-B-0307
- SP-J-513-B-0378
- SP-J-513-C-0083
- SP-J-513-M-0024

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

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## Surface Preparation and Pretreatment



Ensure surface to be painted is clean, dry and intact, if necessary use a high performance solvent cleaner e.g. DeSoto® CN20 or Desoclean™ 45 solvent cleaner. When required, lightly abrade using P240-P320 sand paper (mechanical sander) or P400 (hand abrade). Remove abrasive residue/dust using tack cloth, then solvent degrease.

## Instructions for Use



Base may require mechanical agitation. Prior to mixing, mechanically shake the base component for 10-15 minutes until homogeneous. Stir activator by hand then add to base. Stir mix thoroughly until uniform.

**Note :** All product components should be allowed to condition at temperatures of 15 – 30°C (59 – 86°F) for a minimum of 24 hours prior to mixing and application.



### **Induction Time:**

Not required



### **Viscosity:** ( 23°C/73°F)

- AFNOR4 24 - 29 seconds
- BSB3 46 - 58 seconds
- FORD4 21 - 24 seconds
- ISO4 43 - 58 seconds
- ZAHN2 28 - 35 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 - 35°C (59 - 95°F)  
Relative Humidity 30 - 85%

### **Application:**

Apply a single coat to achieve a dry film thickness between 20 - 30 µm

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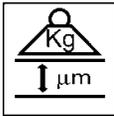


**Theoretical Coverage:** (ready for use)

24 m<sup>2</sup>/Lt @ 25 µm dry film thickness  
960 ft<sup>2</sup>/US gal @ 1 mil dry film thickness

## Recommended Dry Film Thickness:

20 - 30 µm  
0.8 - 1.2 mil



## Dry Film Density:

1.72 g/cm<sup>3</sup>  
14.3 lbs/US gal

## Dry Film Weight:

43 g/m<sup>2</sup> @ 25 µm dry film thickness  
0.0088 lbs/ft<sup>2</sup> @ 1 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:** CA7012 is compatible with all current forms of current spray equipment.



Equipment Type	Tip Size	Pressure
Airmix	11"	Refer to Manufacturer
HVLP Air Spray	1.3 to 1.8mm	29 to 43 psi (2 to 3 bar)
Pressure Pot	1.0 to 1.2mm	29 to 43 psi (2 to 3 bar)
Airless	11"	Refer to Manufacturer
Air-assisted Airless Electrostatic	11"	Refer to Manufacturer
Low Pressure Electrostatic	1.0 to 1.2mm	72 to 97 psi (5 to 6 bar)

## Equipment Cleaning:

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

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## Physical Properties

**Colour:**

Brown Beige (FED STD 595B-30257)

**Gloss:**

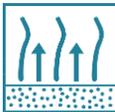
<20 units with a 60° gloss meter



Drying Times	23°C (73°F)	40°C (104°F)	70°C (158°F)	125°C (257°F)
Dry to Handle	8 hours	2 hours	45 minutes	20 minutes
Dry to Tape	8 hours	2 hours	45 minutes	20 minutes
Hard Dry	16 hours	4 hours	90 minutes	30 minutes
Re-coat with Self	30 to 45 minutes	When Cool	When Cool	When Cool
Dry to Overcoat	4 hours (min.) 72 hours (max.)	45 minutes	45 minutes	20 minutes
Full Cure	7 days	3 hours	3 hours	1 hour

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

*Note ii: CA7012 primer is **NOT** to be force dried when overcoated with CA1400 intermediate coat.*

**Flash Off:**

15 - 30 minutes before force drying.

**VOC: (ASTM)**

Mixed ready for use	<350 g/Lt
CA7012 Base Component	335 g/Lt
CA7012B Activator	365 g/Lt

**Flash Point:**

CA7012 Base Component	<21°C (70°F)
CA7012B Activator	25°C (77°F)

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## Shelf Life:

CA7012 Base Component	24 months in original unopened container
CA7012B Activator	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](http://www.ppgaerospace.com)**

**For sales and ordering information call the local PPG office at the numbers listed below:**

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### **Americas**

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

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