

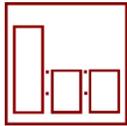
825X466 Super Koropon® Composite Sanding Surfacer

Product description

825X466 is a chromate-free, chemically cured, chemical and solvent resistant polyurethane sanding surfacer. 825X466 is designed to fill in the irregularities and surface defects commonly experienced on composite surfaces. 825X466 is designed to provide maximum protection for composite laminates against strippers and conditions of humidity, including Skydrol.

- Chrome-free
- High build
- Compatible with Desothane® HS topcoats
- Excellent adhesion
- Resistant to hydraulic fluids, lubricating oils, diesel fuel, and water
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

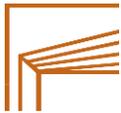
Components



Mix ratio (by volume):

- 825X466 (base component) 4 parts
- 910-702 (activator component) 1 part
- 020-707 (thinner component) 4 part

Specifications



825X466 Super Koropon® sanding surfacer is listed on the following:

- BAC 5837

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

Product compatibility:

825X466 Super Koropon® sanding surfacer is compatible with the following topcoats specifications:

- AMS 3095
- BAMS 565-002 Class A Grade B
- BAMS 565-009 Type II Grade B
- BMS 10-60 Type II Class B Grade D
- BMS 10-72 Type VIII
- BMS 10-125 Type III Grade D
- DMS 2143 Type 1 Class 1
- Composition C DPM 6456
- DPM 6546
- GAMPS 3209
- GP110AEE

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- BMS 10-126 Type I Grade D
- DHMS C4.04 Type VI Class B Grade B
- MEP 10-069
- MM1276 Type II

Surface preparation and pretreatments



825X466 Super Koropon® sanding surfacer can be applied over clean, dry, intact paintable surfaces.

Instructions for Use



Mixing instructions:

Prior to mixing, thoroughly shake the base component. Add activator 910-702 to 825X466 base and stir well, add thinner 020-707 while stirring. Maintain constant agitation for 10 minutes to ensure proper mixing.

Note: It is important to condition the paint for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 13° and 35°C (55° to 95°F). The minimum temperature of the paint components should be 13°C (55°F) prior to mixing.



Induction time:

Not required



Viscosity: (23°C/73°F)

- #4 Ford cup 30 seconds max

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



Pot life:

6 hours @ 21 - 25°C (70-77°F)

Application guidelines

Optimum recommended application conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

Application:

Ground the aircraft and the application equipment before applying the surfacer. Stir the sanding surfacer slowly during the application. The suggested film thickness is 75

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to 200 microns (3 to 10 mils). This can be accomplished by two or three medium coats with a 50% overlap. Note the first and second coat should be allowed to tack up before applying the second and third coat. If the next coat is applied before the previous coat has tacked up, sagging may occur.

Scuff sand to a smooth finish using wet or dry waterproof silicon carbide grit 320 or 400.

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.

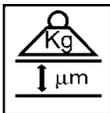


Theoretical coverage:

11.19 square meters/liter at 25 microns dry film (456 square feet/gallon at 1 mil dry film)

Recommended dry film thickness before sanding; 75 to 200 microns (3 to 10 mils)

Recommended dry film thickness after sanding; 25 to 125 microns (1 to 5 mils)



Dry film weight

4.42 grams/square meter at 25 microns dry film (0.009097 pounds/square feet at 1 mil dry film)



Equipment:

825X466 Super Koropon® sanding surfacer surfacer is compatible with all current forms of spray equipment.

Equipment type	Tip size	Pot pressure	Atomization pressure at the cap
Electrostatic air spray gun	1.2 mm or 1.5 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Electrostatic air assisted airless spray gun	#611 or #613 (Graco Nomenclature)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1 bar)
High volume low pressure spray gun (HVLP)	1.0 mm to 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional air spray gun	1.2 mm to 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)

Equipment cleaning:

Clean spray equipment as soon as possible after use. Flush spray equipment with DeSoto® CN20, DeSoto® CN44, or Desoclean™ 45 high performance solvent cleaner.

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Physical properties (product)



Color: Green



Gloss: Not Applicable



Dry times	21 - 27°C (70 - 80°F)
Dust free	5 – 10 minutes
Dry to handle	1 hour minimum
Recoatable	1 hour minimum
Dry to sand	4 hours minimum
Full cure	7 days

Accelerated cure for dry to sand:

Allow 15 minutes flash off at 24°C ± 3°C (75°F)
followed by 30 minutes at 60°C (140°F)



VOC:

Mixed, ready to use VOC (EPA method 24)	585 grams/liter
825X466 Base Component	457 grams/liter
910-702 Activator Component	113 grams/liter
020-707 Thinner Component	832 grams/liter



Flash point closed cup:

825X466 Base Component	-5.56°C (22°F)
910-702 Activator Component	-5.56°C (22°F)
020-707 thinner	-0.56°C (31°F)

Shelf Life:

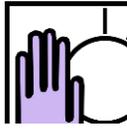
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

Note: Shelf life is provided for original, unopened containers.

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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.

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
Tel 61 (3) 9335 1557
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