

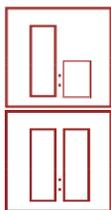
KS35 CF Epoxy Knifing Stopper

Product Description

KS35 is a chromate free epoxy based knifing stopper for direct application to composite and pre-primed metallic substrates. KS35 is intended for the filling of surface irregularities for aesthetic purposes.

- Low VOC
- Chromate free
- Low film weight
- Excellent water resistance
- Resistant to Skydrol® fluids
- Overcoatable with epoxy & polyurethane primers & primer surfacers

Components



Mix Ratio Table

Application Method	Knife or Spatula		Spray	Squeegee
Components	Mix by Weight	Mix by Volume	Mix by Weight	Mix by Weight
KS35A Base + KS35B Activator + T17 Thinner	2 : 1 : 0	1 : 1 : 0	2 : 1 : 0.4	2 : 1 : 0.2
KS35A Base + KS35B1 Activator + T17 Thinner	2 : 1 : 0	1 : 1 : 0	2 : 1 : 0.4	2 : 1 : 0.2

Specifications



KS35 is qualified to the following specifications:

- AIMS 04-04-030 (with KS35B activator)
- HMRC0095 (with KS35B activator)
- MDL5048 (with KS35B activator)
- DGQT 1.7.0.0139 (with KS35B1 activator)
- SMS 0803 (with KS35B1 activator)

Product Compatibility

KS35 is compatible with the following primer specifications:

- AIMS 04-04-001
- AIMS 04-04-002
- AIMS 04-04-003
- BS2X33A+B
- MEP 10-059
- SP-J-513-A-0016

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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 cleaner. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended. Observe recommended overcoating windows for primers.

Instructions for Use



Thoroughly stir both the KS35A base and the KS35B/KS35B1 activator to ensure all components are adequately dispersed. Add appropriate activator and stir thoroughly until an even coloured smooth paste is obtained. Add thinner if required for spray/squeegee application.



NOTE: Consult mix ratio table for correct weight/weight or volume/volume mix ratio.

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:

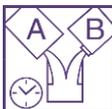
Not required



Viscosity: (23°C/73°F)

Not applicable

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



Pot Life: (@ 21 - 25°C (70 - 77°F))

30 minutes with KS35B

45 minutes with KS35B1

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

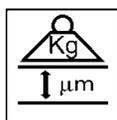
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Application:

Mixed product can be applied by broad bladed knife or non metallic scraper directly to substrate. Fill the void / irregularity to just above the surface. Once dry (refer drying table) initially abrade with 80-120 grit abrasive paper then finish off to a feathered edge with 180-240 grit paper. The stopper is then suitable for overcoating with primer or primer / surfacer.

Recommended Dry Film Thickness:

15 mm (maximum)
600 mil



Dry Film Density: (1:1 ratio)

1.13 g/cm³
9.4 lbs/US gal

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:



Apply using broad bladed knife or non metallic scraper.
Can also be spray applied using Iwata AZ3 HTE Gravity Gun with a 2mm nozzle (20% w/w T17 thinner addition required).
Squeegee application can also be used for small surface defects (10% w/ T17 thinner addition required).

Physical Properties



Colour:

Blue / Grey



Gloss:

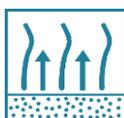
Not applicable

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Drying Times @ 50% R.H.	23°C (73°F)	60°C (140°F)
Dust Free	1 hour	
Dry to Sand with KS35B	2 to 3 hours	30 minutes
Dry to Sand with KS35B1	5 hours	45 minutes
Full Cure	7 days	

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



Flash Off Time:

30 minutes prior to force drying



VOC: (ASTM)

Mixed ready for use (unthinned) <30 g/Lt



Flash Point:

KS35A Base Component	69°C (157°F)
KS35B Activator	54°C (129°F)
KS35B1 Activator	54°C (129°F)
T17 Thinner	16°C (61°F)

Shelf Life:

KS35A Base Component	12 months in original unopened container
KS35B Activator	12 months in original unopened container
KS35B1 Activator	12 months in original unopened container
T17 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.

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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:

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This document has been reviewed by the PPG Aerospace Export Control Department and has been determined to contain only EAR99 controlled data.

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