

# PP404 Epoxide Primer

## TECHNICAL DATA SHEET

### Product Description

PP404 is a two pack cold curing, chromated epoxy primer. PP404 can be overcoated with epoxy, acrylic or polyurethane finishes.

- Conventional solids
- Excellent corrosion resistance
- Excellent resistance to phosphate ester hydraulic fluids
- Excellent water resistance and adhesion properties

### Components



#### Mix Ratio (by volume)

- |                      |              |
|----------------------|--------------|
| • PP404 (Base)       | 1 part       |
| • ACT404 (Activator) | 1 part       |
| • T193 (Thinner)     | to viscosity |

### Specifications



PP404 is qualified to:

- Mil-P-23377D Type I Class I

#### Product Compatibility

PP404 is compatible with the following specifications:

- BSX34A+B
- Mil-C-85285

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

### Surface Preparation and Pretreatment



Ensure that the correct surface pre-treatment has been carried out. Ensure the surface is clean, dry and intact - Desoto® CN20 or Desoclean™ 45 solvent cleaner are recommended.

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## Instructions for Use



Hand stir or mechanically shake base material until all components are uniformly dispersed. Add activator to base material and mix thoroughly add thinner as required.

*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:**

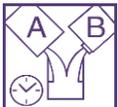
Not required



### **Viscosity:** ( 23°C/73°F)

• AFNOR2.5	43 - 56 seconds
• AFNOR4	15 - 16 seconds
• BSB3	25 - 30 seconds
• BSB4	14 - 17 seconds
• FORD4	12 - 15 seconds
• ISO3	35 - 50 seconds
• ISO4	17 - 22 seconds
• ZAHN2	16 - 20 seconds

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



### **Pot Life:**

8 hours maximum @ 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 the recommended dry film thickness of 15 - 25 µm



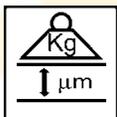
### **Theoretical Coverage:** (ready for use)

16 m<sup>2</sup>/Lt @ 20 µm dry film thickness  
640 ft/US gal @ 0.8 mil dry film thickness

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## Recommended Dry Film Thickness:

15 - 25  $\mu\text{m}$   
0.6 -1 mil



## Dry Film Density:

1.7  $\text{g}/\text{cm}^3$   
14.4 lbs./US gal

## Dry Film Weight:

35  $\text{g}/\text{m}^2$  @ 20  $\mu\text{m}$  dry film thickness  
0.007 lbs/ft<sup>2</sup> @ 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 Type	Tip Size	Material Pressure	Pot Pressure	Atomization Pressure
Airmix	609 to 611	29 to 44 psi (2 to 3 bar)		43 to 58 psi (3 to 4 bar)
HVLP Airspray	1.4 to 1.8			29 psi (2 bar)
Pressure Pot	1.0 to 1.2		10 psi (0.7 bar)	29 psi (2 bar)
Airless	609 to 611			29 to 44 psi (2 to 3 bar)
Air Assisted Electro	609 to 611	29 to 44 psi (2 to 3 bar)		58 to 73 psi (4 to 5 bar)
Low Pressure Electro	1.0 to 1.2	15 to 29 psi (1 to 2 bar)		44 to 73 psi (4 to 5 bar)

## Equipment Cleaning:

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

## Physical Properties



### Colour:

Yellow



### Gloss:

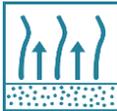
< 10 units with a 60° gloss meter

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DRYING TIMES	23°C (73°F)	70°C (158°F)
Tack Free	1 hour	
Hard Dry	6 hours	30 minutes
Overcoat	1 hour (min.) 72 hours (max.)	
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 Time:**

15 - 30 minutes @ 23°C prior to force dry application



**VOC: (ASTM)**

Mixed (unthinned)	570 g/Lt
PP404 Base Component	450 g/Lt
ACT404 Activator	680 g/Lt
T193 Thinner	840 g/Lt



**Flash Point:**

PP404 Base Component	-4°C (25°F)
ACT404 Activator	4°C (39°F)
T193 Thinner	-4°C (25°F)

**Shelf Life:**

PP404 Base Component	24 months in original unopened container
ACT404 Activator	24 months in original unopened container
T193 Thinner	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.*

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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](http://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  
Fax 61 (3) 9335 3490

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Fax (86-022) 2482 8600

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#### **ASC – Central Europe**

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Fax 49 (40) 742 139 69

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Fax (971) 4 883 9665

#### **ASC – North Europe**

Tel 44 (0) 1388 770222  
Fax 44 (0) 1388 770288

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Tel 33 (0) 235 53 43 71  
Fax 33 (0) 235 53 54 44

### **Americas**

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

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