



## Desoprime™ HS CA7255 Military Epoxy Primer

### Product description

Desoprime™ HS CA7255 military epoxy primer is a high solids, corrosion, chemical and solvent resistant coating used on the exterior of aircraft. CA7255 has excellent adhesion to a variety of substrates and exhibits a high degree of Skydrol® resistance.

- Excellent adhesion and corrosion resistance
- Compatible with Desothane® HS topcoats
- Excellent fluid resistance
- Compatible with all current spray equipment
- Can be applied in a wide range of conditions
- Easy to remove with chemical stripper and dry media blasting
- Service temperature -54°C to 177°C (-65°F to 350°F)

### Components



#### Mix ratio (by volume):

- CA7255A (base component) 1 part
- CA7255B (activator component) 1 part

### Specifications



CA7255 epoxy primer is qualified to:

- MCS 9053 Type 2 Class 1 Grade 1
- MIL-PRF-23377 Type II Class C2

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

#### Product compatibility:

CA7255 primer is compatible with the following topcoat specifications:

- AIMS 04-04-013
- BAMS 565-009
- BMS 10-60
- BMS 10-72
- DMS 2115
- MIL-PRF-22750
- MIL-PRF-53039
- MIL-PRF-64159
- MIL-PRF-85285
- MMS 420

### Surface preparation and pretreatments



Desoprime™ CA7255 high solids primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-DTL-5541, MIL-DTL-81706, MIL-A-8625, or equivalent.

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## Instructions for use



### Mixing instructions:

Prior to mixing, thoroughly shake the CA7255A base component. Mix the activator by hand before adding to the base. Add activator to base component and stir well. Maintain constant agitation for 10 minutes to ensure proper mixing. Induction time is may be needed based on temperature.

*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:

Temperature	13 - 18°C (55 - 64°F)	18 - 23°C (65 - 74°F)	24 - 29°C (75 - 84°F)	>29°C (>85°F)
Induction Time Required	1 ½ hours	1 hour	30 minutes	None



### Viscosity: (23°C/73°F)

- #2 Signature Zahn cup 41 seconds maximum
- #4 Ford cup 30 seconds maximum
- ISO 4mm cup 68 seconds maximum
- BSB3 cup 66 seconds maximum
- BSB4 cup 35 seconds maximum
- AFNOR #4 cup 34 seconds maximum

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



### Pot life:

Temperature	13 - 18°C (55 - 64°F)	18 - 23°C (65 - 74°F)	24 - 29°C (75 - 84°F)	>29°C (>85°F)
Pot life	5 hours	4 hours	3 hours	1 ½ hour

## Application guidelines

### Recommended application conditions:

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

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## Application:

Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 15 to 30 microns (0.6 to 1.2 mils). This can be accomplished by one coat with a 50% overlap.

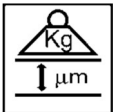
*These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.*



## Theoretical coverage:

17.7 square meters/liter at 25 microns dry film (722 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 15 to 30 microns (0.6 to 1.2 mils)



## Dry film density:

1.76 grams/cubic centimeter (14.66 pound/gallon)

## Dry film weight:

44.0 grams/square meter at 25 microns dry film (0.009 pounds/square feet at 1 mil dry film)



## Equipment:

CA7255 primer 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:** Dark Green



**Gloss:** Not Applicable



<b>Dry Times</b>	<b>13 - 21°C (55 - 70°F)</b>	<b>22 - 28°C (71 - 84°F)</b>	<b>&gt;29°C (&gt;85°F)</b>
Dust Free	45 minutes	30 minutes	20 minutes
Tack Free	75 minutes	1 hour	45 minutes
Dry to Tape	3 hours	2 hours	1 ½ hours
Dry to Topcoat	2 - 72 hours	2 - 72 hours	2 - 72 hours
Dry to Fly	72 hours	48 hours	24 hours
Full Cure	7 days	7 days	7 days

### Accelerated cure:

Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)  
followed by 60 minutes at 49°C (120°F)



### VOC:

Mixed, ready for use VOC (EPA method 24)	340 grams/liter
Base Component	439 grams/liter
Activator Component	258 grams/liter



### Flash point:

Base Component	29°C (85°F)
Activator Component	-4°C (24°F)

### Shelf Life:

12 months from date of manufacture. Consult the specification to verify shelf life requirements.

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

*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.*

## 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

**ASC – Japan**  
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Fax 81 561 35 5201

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### **Americas**

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Fax 44 (0) 1388 770288

**ASC – South Europe**  
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Fax 33 (0) 235 53 54 44

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PRC-DeSoto International, Inc.  
12780 San Fernando Road  
Sylmar, CA 91342  
[www.ppgaerospace.com](http://www.ppgaerospace.com)

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