

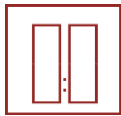
4080 Nitrocellulose Topcoat Matt

Product Description

4080 single component nitrocellulose topcoat is designed for use as internal and external protection of aircraft. 4080 can be applied over metal primer 6840B, Anti corrosive Primer 4888, and Epoxy Primer 7835.

- Ester lubricant resistant
- Quick drying
- Conventional solids

Components



Mix Ratio (by volume)

- 6346/XXXX (Base) 1 part
- 0480/9000 (Thinner) 1 part

Specifications



6346 is qualified to:

- AIR 8104
- Dassault

6346 meets the technical requirements of:

- Mil-L-19538C

Product Compatibility

6346 Topcoat is applicable over the following primer specifications:

- Mil-C-8514
- Mil-C-15328
- Mil-P-7962
- Mil-P-23377
- DHS 186-111

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

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Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner, DeSoto® CN20 or Desoclean™ 45 are recommended. Observe recommended overcoat windows for primers.

Instructions for Use



Thoroughly stir or shake the base to ensure all components are adequately dispersed. Slowly add thinner to base while stirring.

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:

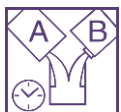
Not required



Viscosity: (21 - 25°C / 70 - 77°F) Mix as described

- AFNOR4 16 - 18 seconds
- BSB3 55 - 85 seconds
- FORD4 15 - 16 seconds
- ISO4 55 - 90 seconds
- ZAHN2 20 - 21 seconds

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



Pot Life:

Not applicable

Application Guidelines

Recommended Application Conditions:

Temperature 18 - 25°C (64 - 77°F)
Relative Humidity 30 - 85%

Application:

Apply 2 - 3 cross coats to reach recommended dry film thickness.



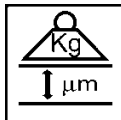
Theoretical Coverage: (ready for use)

7 m²/Lt @ 20 µm dry film thickness (white)
280 ft²/US gal @ 0.8 mil dry film thickness

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Recommended Dry Film Thickness:

20 - 25 μm
0.8 - 1 (mil)



Dry Film Density: (depending on colour)

1.40 g/cm³
11.7 lbs/US gal

Dry Film Weight:

28 g/m² @ 20 μm dry film thickness
0.005 lbs/ft² @ 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	Pressure
Pneumatic Application	1.4 or 1.5 mm	43 to 72 psi (3 to 5 bar)
High Pressure Application	0.33mm (angle 67° or 80°)	1450 to 1885 psi (100 to 130 bar)

Equipment Cleaning:

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

Physical Properties



Colour:

Limited colour range available



Gloss:

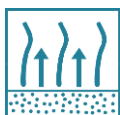
Matt < 5 units with a 60° gloss meter

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DRYING TIMES @ 23°C(73°F) 50% R.H	
Dry to Touch	10 minutes
Dry to Handle	30 minutes
Dry to Tape	2 to 2.5 hours
Full Cure	7 days

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



Flash Off Time:

Not applicable



VOC: (ASTM)

Mixed ready for use	>800 g/Lt
6346 Base Component	700 g/Lt
0480/9000 Thinner	915 g/Lt



Flash Point:

6346 Base Component	5°C (41°F)
0480/9000 Thinner	6°C (43°F)

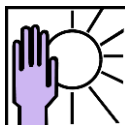
Shelf Life:

6346 Base Component	24 months in original unopened container
0480/9000 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.

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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