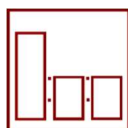


### Product description

Desofill™ HS CA8620G is a chromate-free, chemically cured, chemical and solvent resistant polyurethane sanding surfacer. CA8620G is designed to fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces.

- High solids, low VOC
- Corrosion resistant primer required when applied on aluminum substrates
- Compatible with Desothane™ HS topcoats
- Excellent adhesion
- High build
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

### Components



#### **Mix ratio (by volume):**

- CA8620G (base component) 2 parts
- CA8000B (activator component) 1 part
- CA8000C\* (thinner component) 1 part

*\*Note: Quicker dry times can be achieved by using CA8000C1 and CA8000C2 thinners.*

*\*Note: CA8620LV is an exempt blend version of CA8000C thinner that gives a mixed and ready to use VOC of 350 grams/liter.*

*\*Note: CA1805CX is an exempt solvent blend that does not replace the original thinner, but can be added up to 20% by volume of fully mixed material to facilitate spraying when needed.*

### Specifications



CA8620G is qualified to:

- A2MS 565-015 Class A Grade B
- BAMS 565-015 Class A Grade B
- CMS-CT-904
- DGT 99 993
- GAMPS 3105
- MEP 10-070

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

# Desofill™ HS CA8620G Sanding Surfacers

## Product compatibility:

CA8620G is compatible with the following primer specifications:

- 299-947-322 Type I
- AIMS 04-04-012
- AIMS 04-04-026
- AIMS 04-04-054
- AMS 3095
- A2MS 565-008 Grade A & B Ty II
- A2MS 565-016
- BAMS 565-008 Grade A & B Ty II
- BAMS 565-016
- BMS 10-72 Ty VIII & IX Class NC
- BMS 10-79 Type II & III
- BMS 10-103 Type I Grade A
- BMS 10-118 Type I & II Grade B
- BMS 10-123 Type I Grade B
- CMS-CT-201 CI A & B Gr A & B
- CMS-CT-206 Type I Class A
- DHMS C4.01 Type 3 Grade A
- DHMS C4.18 Ty III CI A Gr B
- GAMPS 3103
- GP110AEE
- HMS 16-1738
- HMS 16-2122
- MEP 10-060 Ty I & II Class A & B
- MEP 10-068 Class A & B
- MEP 10-070
- MIL-PRF-23377
- MM1275 Type I & II
- MS100016E Class S
- PWA 36525 Type 1
- SMS-111204 Ty 1 CI 1 Form 1&2
- SMS-111207 Type 7
- STMGK 189
- TCE-M-20710-14
- VMS C4.01 Type 3 Grade A
- VMS C4.18 Ty 3 Class A Grade B

## Product compatibility:

CA8620G is compatible with the following topcoat specifications:

- AIMS 04-04-012
- AIMS 04-04-013
- AIMS 04-04-024
- AIMS 04-04-031
- AIMS 04-04-032
- AIMS 04-04-033
- AIMS 04-04-037
- AMS 3095
- A2MS 565-002 Class A Grade B
- A2MS 565-009 Type II Grade B
- BAMS 565-002 Class A Grade B
- BAMS 565-009 Type II Grade B
- BMS 10-60 Ty II Class B Grade D
- BMS 10-72 Type VIII
- BMS 10-125 Type III Grade D
- BMS 10-126 Type I Grade D
- CMFS037
- CMS-CT-101 Type I
- DHMS C4.04 Type VI CI B Gr B
- DMS 2143 Ty I Class 1 Comp C
- GAMPS 3209
- GP110AEE
- MEP 10-069
- MM1276 Type II
- MS100029E Class HS
- RMS 430 Type II
- RMS 430 Type II
- SMS-111207 Type 1
- VMS C4.04 Ty VI CI B Gr B



Desofill HS sanding surfacer CA8620G can be applied over clean, dry, intact primed aluminum and composite surfaces.

# Desofill™ HS CA8620G Sanding Surfacers

## Instructions for use



### Mixing instructions:

Prior to mixing, thoroughly shake the base component. Add the activator to the base component and stir well, and add thinner 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:

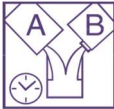
Not Required



### Viscosity: (23°C/73°F)

- ISO #4mm cup 20 to 40 seconds
- #2 Signature Zahn cup 17 to 26 seconds
- #4 Ford cup 14 to 20 seconds

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



### Pot life: 21 - 25°C (70-77°F)

Thinner	Time
CA8000C	3 hours
CA8620LV	3 hours
CA8000C1	2 hours
CA8000C2	1 hour

## Application guidelines

### 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 to 200 microns (3 to 10 mils). This can be accomplished by two or three medium coats with a 50% overlap.

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.

# Desofill™ HS CA8620G Sanding Surfacers

*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:

21 square meters/liter at 25 microns dry film (850 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)

*Note: CA8620G should be sanded before top coating.*



## Dry film weight

43 grams/square meter at 25 microns dry film (0.0089 pounds/square feet at 1 mil dry film)



## Equipment:

Desofill™ CA8620G sanding 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.

## Physical properties (product)



**Color:** Gray



**Gloss:** Not Applicable

# Desofill™ HS CA8620G Sanding Surfacers



Dry times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
CA8000C Thinner			
Tack free	2 hours	1 ½ hours	1 hour
Dry to Sand	10 hours	9 hours	8 hours
Topcoat after sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full cure	7 days	7 days	7 days

CA8000LV Thinner			
Tack free	2 hours	1 ½ hours	1 hour
Dry to Sand	10 hours	9 hours	8 hours
Topcoat after sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full cure	7 days	7 days	7 days

CA8620C1 Thinner			
Tack free	1 hour	1 hour	45 minutes
Dry to sand	8 hours	7 hours	6 hours
Topcoat after sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days

CA8620C2 Thinner			
Tack free	45 minutes	30 minutes	20 minutes
Dry to sand	6 hours	5 hours	4 hours
Topcoat after sanding	Up to 6 days	Up to 6 days	Up to 6 days
Full Cure	7 days	7 days	7 days

Accelerated cure for dry to sand with CA8000C Thinner:

Allow 60 minutes flash off at 24°C (75°F) followed by 1½ hours at 60°C (140°F)

## VOC

### VOC:

Mixed, ready to use VOC (EPA method 24) with CA8000C	420 grams/liter
Mixed, ready to use VOC (EPA method 24) with CA8620LV	350 grams/liter
Base Component	350 grams/liter
Activator Component	113 grams/liter
CA8000C Thinner Component	864 grams/liter
CA8620LV Thinner Component	884 grams/liter

# Desofill™ HS CA8620G Sanding Surfacers



## Flash point closed cup:

Base Component	16°C (60°F)
Activator Component	47°C (117°F)
CA8000C Thinner Component	24°C (75°F)
CA8620LV Thinner Component	15°C (60°F)

## Shelf Life:

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

24 months from date of manufacture for PRC-DeSoto Standard.

*Note: Shelf life is provided for 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.*

## 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:**

# Desofill™ HS CA8620G Sanding Surfacers

## Asia Pacific

**ASC – Australia**  
Tel 61 (3) 9335 1557  
Fax 61 (3) 9335 3490

**ASC – Japan**  
Tel 81 561 35 5200  
Fax 81 561 35 5201

**ASC – South East Asia**  
Tel 65 6861 1119  
Fax 65 6861 6162

**ASC – Suzhou**  
Tel (86-512) 6661 5858  
Fax (86-512) 6661 6868

**ASC – Tianjin**  
Tel (86-022) 2482 8625  
Fax (86-022) 2482 8600

## Americas

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

## Europe and Middle East

**ASC – Central Europe**  
Tel 49 (40) 742 193 10  
Fax 49 (40) 742 139 69

**ASC – Middle East & India**  
Tel (971) 4 883 9666  
Fax (971) 4 883 9665

**ASC – North Europe**  
Tel 44 (0) 1388 770222  
Fax 44 (0) 1388 770288

**ASC – South Europe**  
Tel 33 (0) 235 53 43 71  
Fax 33 (0) 235 53 54 44

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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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