Desothane® HD 9008 Base Coat

Product Description

Desothane® HD 9008 is a pigmented base coat designed for use with clear coat 9008B0900D. The Base coat / clear coat system provides extended service life, improved buffability, and a smooth, easy to clean surface.

- High solids, low VOC
- Outstanding appearance
- Excellent colour and gloss retention
- Opacity achieved in one coat
- Reduction in weight and cycle times
- Service Temperature - 54°C to 177°C (-65°F to 350°F)

Components

Mix Ratio (by volume)

• 9008xxxx (Base)	4 parts
• 9008B (Activator)	1 part
• 9008C (Slow Reducer)	1 part
or	
• 9008C2 (Reducer)	
or	
• 9008C4 (Fast Reducer)	

Specifications

9008 is qualified to the following specifications:

- AIMS 04-04-025
- AIMS 04-04-033
- AIMS 04-04-037
- BAMS 565-018
- ECS 7379 (9008M08001 & 9008E05002 Only)
- RRJ 0000-RE-811-3173

9008 is qualified to AMS 3095 when used with the following systems:

- EAP9 + 7502E + 9008 Basecoat + 9008B0900D
- P99 + PAC33CF + 9008 Basecoat + 9008B0900D
- 7530 + 7065 + 9008 Basecoat + 9008B0900D

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

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Surface Preparation and Pretreatment

Ensure that the correct surface pre-treatment has been carried out and that drying and overcoating times are adhered to.
Ensure the surface is clean, dry and intact using a high performance solvent cleaner. Desoclean™ 110 or DeSoto® CN13 solvent cleaners are recommended.

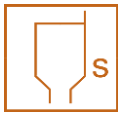
Instructions for Use

Base may require mechanical agitation. Ensure all components are adequately dispersed. Add activator to base component and mix thoroughly. Add reducer while continuing to stir until uniform.

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:

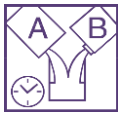
Not required



Viscosity: (23°C/73°F)

- AFNOR4 cup 18 - 24 seconds
- BSB3 cup 35 - 46 seconds
- BSB4 cup 20 - 25 seconds
- FORD4 cup 16 - 22 seconds
- ISO4 cup 32 - 43 seconds
- #2 Signature ZAHN cup 18 - 25 seconds

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



Pot Life:

Pot Life	Using 9008C	Using 9008C2	Using 9008C4
Pot Life @ 23°C (73°F)	N/A	2 hours	30 minutes
Pot Life @ 30°C (86°F)	2 hours	N/A	N/A

Application Guidelines

Recommended Application Conditions:

Relative Humidity 30-75%	Using 9008C	Using 9008C2	Using 9008C4
Temperature	> 30°C (86°F)	15-30°C (59-86°F)	15-23°C (59-73°F)

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Application:

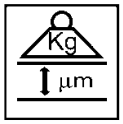
Apply one cross coat (cross coat definition - Apply one medium wet horizontal and one medium wet vertical coat) to a dry film thickness of 30-50 microns (1.2 to 2 mils). If two coats are required to reach opacity, apply second coat between 15 minutes to 2 hours after the first coat.

Theoretical Coverage: (ready for use)

11 m²/Lt @ 50 µm dry film thickness
440 ft²/US gal @ 2 mil dry film thickness

Recommended Dry Film Thickness:

30 - 70 µm depending on colour
1.2 - 2.8 mil



Dry Film Density:

1.9 g/cm³ (white)
15.8 lbs./US gal

Dry Film Weight:

77 g/m² @ 50 µm dry film thickness
0.015 lbs./ft² @ 2.0 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	Flow Rate	Pot Pressure	Atomization Pressure at the Cap
Electrostatic Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12oz./min)	10 to 40 psi (0.69 to 2.8 bar)	50 to 70 psi (3.5 to 5 bar)
Electrostatic Air Assisted Airless Spray Gun	611 through 612 711 through 713	240-350 ml/min (8-12oz/min)	700 to 1200 psi (48 to 82 bar)	40 to 60 psi (2.8 to 4.1bar)
High Volume Low Pressure Spray Gun (HVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)
Low Volume Low Pressure Spray Gun (LVLP)	1.2 mm to 1.5 mm	240-350 ml/min (8-12 oz./ min)		29 psi (2 bar)

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Note: Contact your local Technical Service Representative for information on use of alternative application equipment.

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44, Desoclean™ 45 or PPG MB28 solvent cleaners are recommended.

Physical Properties

Colour:

Wide range of colours available

Gloss:

> = 90 units with a 60° head (when overcoated with 9008B0900D clear coat)

DRYING TIMES	Using 9008C	Using 9008C2	Using 9008C4
Dry to Tape @ 23°C (73°F)	N/A	2-3 hours	1-1.5 hours
Dry to Tape @ 30°C (86°F)	1.5-2.5 hours	1-2 hours	N/A
Sagging Limit @ 15°C (59°F)	N/A	NP	No run up to 30µm above IHP
Sagging Limit @ 23°C (73°F) & 55% RH	N/A	No run up to 30µm above IHP	No run up to 30µm above IHP
Sagging Limit @ 30°C (86°F) & 80% RH	No run up to 30µm above IHP	No run up to 30µm above IHP	N/A

DRYING TIMES	Using 9008C2 @ 23°C (73°F) 50% R.H.	Using 9008C2 @ 30°C (86°F) 85% R.H.	Using 9008C @ 35°C (95°F) 50% R.H.
Dry to Tape	2 to 3 hours	1 to 2 hours	2 to 2.5 hours
Overcoatable with 9008 base	2 to 3 hours (min.) 5 days (max.)	-	2 to 3 hours (min.) 5 days (max.)
Overcoatable with 9008B0900D	2 to 3 hours (min.) 5 days (max.)	1 to 2 hours (min.) 5 days (max.)	2 to 3 hours (min.) 5 days (max.)
Full Cure	7 days	7 days	7 days

***Note**: Wait a minimum of 3 hours prior to applying Pre-mask to prevent solvent entrapment.*

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

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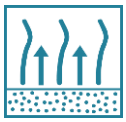

Flash Off Time:

5 - 15 minutes flash off prior to force dry

VOC: (ASTM)

Mixed ready for use	<420 g/Lt
9008xxxx Base Component	350 g/Lt
9008B Activator	110 g/Lt
9008C2 Reducer	870 g/Lt
9008C Reducer	870 g/Lt
9008C4 Reducer	870 g/Lt

Flash Point:

9008 Base Component	33°C (91°F)
9008B Activator	47°C (116°F)
9008C2 Reducer	-1°C (30°F)
9008C Reducer	-1°C (30°F)
9008C4 Reducer	-1°C (30°F)

Shelf Life:

9008 Base Component	24 months in original unopened container
9008B Activator	24 months in original unopened container
9008C2 Reducer	24 months in original unopened container
9008C Reducer	24 months in original unopened container
9008C4 Reducer	24 months in original unopened container

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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ASC – Australia
Tel 61 (3) 9335 1557
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