PPG Aerospace
PRC-DeSoto

F565-4010 Intermediate Coating (US)

TECHNICAL DATA SHEET

Product Description

F565-4010 product is a polyamide-based coating used as an intermediate coat in the selectively strippable exterior paint systems. It is applied directly over the corrosion resistant primer (chromated or non-chromated) and is then top coated with Desothane® HS or HD topcoats.

- Easily removed with mild strippers such as PR-3135
- Decreases stripping time
- Excellent fluid resistance
- Compatible with all current spray equipment
- Can be applied in a wide range of conditions
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components

Mix ratio (by volume):

- F565-4010 (base component) — 4 parts
- F275-0189 (activator component) — 1 part
- 020K026 or 020K026R (thinner component) — 2 parts

Specifications

F565-4010 coating is qualified to:

- AFS1821
- BMS 10-120 Type I Grade A

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

Product Compatibility:

F565-4010 coating is compatible with the following topcoat specifications:

- BAMS 565-009
- BMS 10-60 Type I & Type II
- BMS 10-72 Type VIII
- BMS 10-125 Type III
- CMS-CT-101
- DMS 2115
- DPM 2143
- MEP 10-069
- MIL-PRF-85285
- MM1276

F565-4010 coating is compatible with the following primer specifications:

- BAMS 565-008
- BMS 10-72 Type VIII
- BMS 10-79 Type II & Type III
- BMS 10-118 Type I
- CMS-CT-201
- DHMS 04.18
- DMS 2104
- DPM 2144
- MEP 10-068
- MM1275

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Surface Preparation and Pretreatments

F565-4010 coating can be applied over clean, dry, intact primed surfaces. For further information, refer to the Technical Data Sheet for the above mentioned primers.

Instructions for Use

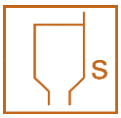
Mixing Instructions:

Prior to mixing, thoroughly shake the F565-4010 base. Add F275-0189 activator to the base component under agitation. Then add 020K026 or 020K026R 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)

• #2 Signature Zahn cup	12 to 16 seconds
• #4 Ford cup	10 to 12 seconds
• ISO 3mm cup	30 to 37 seconds
• ISO 4mm cup	16 to 18 seconds
• BSB3 cup	23 to 26 seconds
• BSB4 cup	13 to 15 seconds
• AFNOR #2.5 cup	40 to 45 seconds
• AFNOR #4 cup	13 to 15 seconds

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

Pot Life:

8 hours @ 21 - 25°C (70 - 77°F)

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Application Guidelines

Recommended Application Conditions:

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

Application:

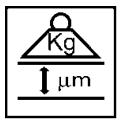
Ground the aircraft and the application equipment before coating. Stir the intermediate coating slowly during the application. The suggested film thickness is 8 to 12 microns (0.3 to 0.5 mils). This can be accomplished by one medium cross coat with a 50% overlap. Note the spray equipment must be flushed with Isopropyl alcohol before using the intermediate coating. Small amounts of strong solvents such as MEK are not compatible with the intermediate coating.

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:

10 square meters/liter at 25 microns dry film (400 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 8 to 12 microns (0.3 to 0.5 mils)



Dry Film Density:

1.48 grams/cubic centimeter (12.33 pounds/gallon)

Dry Film Weight:

37 grams/square meter at 25 microns dry film (0.0078 pounds/square feet at 1 mil dry film)

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Equipment:

F565-4010 is compatible with the following spray equipment. When using with electrostatic equipment ensure that the E-Stats is set to off.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
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)
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 first with Isopropyl Alcohol and then with DeSoto® CN20, DeSoto® CN44, or Desoclean™ 45 high performance solvent cleaner.

Physical Properties (product)

Color: Light Grey

Gloss: Not Applicable

Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Dust Free	20 minutes	15 minutes	12 minutes
Dry to Tape	3 - 4 hours	2 - 3 hours	1 ½ - 2 hours
Dry Topcoat	3 - 10 hours	2 - 10 hours	1 - 10 hours
Dry Hard	10 hours	8 hours	7 hours
Full Cure	7 days	7 days	7 days

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Accelerated cure:

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

VOC

VOC:

Mixed, ready to use VOC (EPA method 24)	750 grams/liter
Base Component	696 grams/liter
Activator Component	806 grams/liter
020K026 or 020K026R	800 grams/liter

Flash point closed cup:

Base Component	23°C (73°F)
Activator Component	23°C (73°F)
020K026	12°C (53°F)
020K026R	12°C (53°F)

Shelf Life:

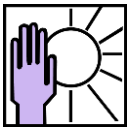
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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

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

<u>Note:</u> 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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