

Desothane[®] HS CA8400 Interior Cabin Coating

TECHNICAL DATA SHEET

Product Description

Desothane[®] HS CA8400 series high solids polyurethane topcoats are designed for cabin interiors. They meet the FAR 25.853 requirements for heat release, smoke density, and burn test.

- Available in semi-gloss or flat colors
- Excellent adhesion to plastic
- Scuff resistant
- UV resistant
- Resists staining from cleaning agents
- Available in Sempen[®] for easy touch up
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- CA8422XXX
or CA8412XXX (base component) 3 parts
- CA8400B (activator component) 1 part

Specifications



CA8400 topcoat is listed on:

- DPM 5391

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

Product Compatibility:

CA8400 topcoats are compatible with the following interior primer specifications:

- BMS 10-11 Type I
- DMS 1786

Surface Preparation and Pretreatments



Desothane[®] CA8400 high solids topcoats can be applied over clean, dry, intact plastic and aluminum surfaces. Aluminum surfaces must be primed before top coating with CA8400 topcoats. For further information, refer to the Technical Data Sheets for the above mentioned primers.

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Instructions for Use



Mixing Instructions:

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

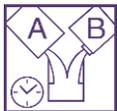
Not Required



Viscosity: (23°C/73°F)

- #2 Signature Zahn cup 16 to 23 seconds
- #4 Ford cup 12 to 18 seconds
- ISO 3mm cup 37 to 71 seconds
- ISO 4mm cup 18 to 34 seconds
- BSB3 cup 26 to 36 seconds
- BSB4 cup 15 to 22 seconds
- AFNOR #2.5 cup 45 to 70 seconds
- AFNOR #4 cup 15 to 19 seconds

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



Pot Life:

Base Component	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 82°F)	>29°C (>85°F)
CA84X1	4 hours	4 hours	3 hours
CA84X2	3 hours	2 - 3 hours	1 - 2 hours
CA84X3	3 hours	2 hours	1 hour
CA84X4	1 hour	30 minutes	15 minutes



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Application Guidelines

Recommended Application conditions:

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

Application:

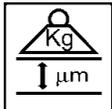
Ground the aircraft and the application equipment before applying the CA8400 Series topcoat. Stir the topcoat slowly during the application. The suggested film thickness is 37 to 50 microns (1.5 to 2.0 mils). This can be accomplished by one or two medium coats with a 50% overlap. Note the first coat should be allowed to tack up before applying the second coat. If the second is applied before the first coat has tacked up, sagging may occur.

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:

20 square meters/liter at 25 microns dry film (820 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 37 to 50 microns (1.5 to 2.0 mils)



Dry Film Density:

1.48 grams/cubic centimeter (12.33 pound/gallon)

Dry Film Weight:

37 grams/square meter at 25 microns dry film (0.0084 pounds/square feet at 1 mil dry film)



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Equipment:

CA8400 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.

Physical Properties (product)



Color: Available in various color standards including DN, BAC and Fed Standard 595B



Gloss: Semi-gloss colors, 10 - 30 G.U or 45 - 75 G.U at 60°
Flat colors, <10 G.U at 60°



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Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
CA84X1 Base Component			
Wet Edge			
Semi-Gloss	45 minutes	45 minutes	20 minutes
Flat and Matt	30 minutes	30 minutes	15 minutes
Time Between Coats	60 - 90 minutes	45 - 60 minutes	30 - 45 minutes
Dry to Tape	8 - 10 hours	5 - 7 hours	3 - 4 hours
CA84X2 Base Component			
Wet Edge			
Semi-Gloss	45 minutes	30 minutes	20 minutes
Flat and Matt	20 minutes	15 minutes	10 minutes
Time Between Coats	30 - 40 minutes	15 - 30 minutes	10 - 20 minutes
Dry to Tape	5 - 7 hours	3 - 5 hours	2 - 3 hours
CA84X3 Base Component			
Wet Edge			
Semi-Gloss	20 minutes	15 minutes	10 minutes
Flat and Matt	15 minutes	10 minutes	10 minutes
Time Between Coats	25 minutes	10 - 20 minutes	10 minutes
Dry to Tape	4 - 5 hours	2 - 3 hours	1 - 2 hours
CA84X4			
Recommended for plural component equipment or Sempen® Base Component			
Time Between Coats	10 minutes	5 - 10 minutes	5 minute
Pot Life	1 hour	30 minutes	15 minutes
Dry to Tape	1 ½ - 2 hours	1 hour	20 minutes

Accelerated cure:

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



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VOC (EPA method 24):

Mixed, ready for use VOC	420 grams/liter
Base Component	490 grams/liter
Activator Component	206 grams/liter
Thinner Component	420 grams/liter



Flash point closed cup:

Base Component	27°C (80°F)
Activator Component	39°C (102°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: The coating 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.



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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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