4123 Epoxy Primer 7835

TECHNICAL DATA SHEET

Product Description

4123/…. is a two component chromated epoxy primer, used for external of aircraft structures.

- Anti corrosive primer
- Corrosion resistant
- Flexible
- Excellent resistance to oil esters, grease, kerosene, hydraulic fluids
- Heat resistant to temperatures up to 130°C (266°F)

Components

Mix Ratio (by volume)

- 4123/…. (Base) 1 part
- 0628/9001 (Activator) 1 part
- 0469/9000 (Thinner) to viscosity (see viscosity section of this document)

Specifications

4123 is qualified to:

- DHS 186-111

4123 meets the technical requirements of:

- MIL-P-23377

Product Compatibility

4123 is compatible with the following topcoat specifications:

- AIMS 04-04-003
- AIMS 04-04-012
- ASNA 4247
- BLGG 140301
- ECS 2139-20
- ECS-L-12261
- NORMDEF 0003-1

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

Ensure surface to be painted is clean, dry and intact using a high performance solvent cleaner DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Instructions for Use

Ensure all mixing / measuring containers are free from contaminants. Shake or stir the base to ensure all components are adequately dispersed. Slowly add activator to base while stirring. Add required thinner to viscosity.

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)

- AFNOR 2.5 45 - 55 seconds
- AFNOR4 15 - 16 seconds
- BSB3 26 - 29 seconds
- BSB4 15 - 17 seconds
- FORD4 12 - 14 seconds
- ISO3 37 - 49 seconds
- ISO4 18 - 21 seconds
- ZAHN2 16 - 19 seconds

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

Pot Life:
8 hours @ 21 - 25 °C (70 - 77 °F)

Application Guidelines

Recommended Application Conditions:
Temperature 15 - 30 °C (59 - 86 °F)
Relative Humidity 30 - 80%
Application:
Apply 1 cross coat to achieve the recommended dry film thickness.

**Theoretical Coverage:** (ready for use)
12 m²/Lt @ 25 µm dry film thickness
480 ft²/US gal @ 1 mil dry film thickness

**Recommended Dry Film Thickness:**
20 - 25 µm
0.8 - 1 mil

**Dry Film Density:**
2.0 g/cm³
16.6 lbs/US gal

**Dry Film Weight:**
48 g/m² @ 25 µm dry film thickness
0.009 lbs/ft² @ 1 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:** 4123 is compatible with all current forms of spray equipment

<table>
<thead>
<tr>
<th>Equipment Type</th>
<th>Tip Size</th>
<th>Pressure</th>
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</thead>
<tbody>
<tr>
<td>Conventional Airspray</td>
<td>15/10 mm</td>
<td>43 to 72 psi (3 to 5 bar)</td>
</tr>
<tr>
<td>Airless</td>
<td>0.33 mm (angle 67 or 80°)</td>
<td>1450 to 1885 psi (100 to 130 bar)</td>
</tr>
</tbody>
</table>

**Equipment Cleaning:**
Clean spray equipment before use and as soon as possible after use. DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

**Physical Properties**

**Colour:**
Green-Blue-Grey (4123/5045)
Yellow-Green (4123/3600)
4123 Epoxy Primer 7835

Gloss:
Matt < 5 units with a 60° gloss meter

<table>
<thead>
<tr>
<th>Drying Times @ 50 % R.H.</th>
<th>23 °C (73 °F)</th>
<th>60 °C (140 °F)</th>
<th>80 °C (176 °F)</th>
<th>120 °C (248 °F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry to Touch</td>
<td>15 to 30 minutes</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Dry to Handle</td>
<td>1 to 1.5 hours</td>
<td></td>
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<td></td>
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<tr>
<td>Dry to Overcoat</td>
<td>4 hours (min.)</td>
<td>72 hours (max.)</td>
<td>20 minutes</td>
<td></td>
</tr>
<tr>
<td>Dry to Tape</td>
<td>2 to 3 hours</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
<td>1 hour</td>
<td>15 minutes</td>
<td></td>
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</tbody>
</table>

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

Flash Off:
30 minutes prior to overcoating or force drying

VOC: (ASTM)
Mixed ready for use (unthinned) 600 g/Lt
4123 Base 460 g/Lt
0628/9001 Activator 750 g/Lt
0469/9000 Thinner 850 g/Lt

Flash Point:
4123 Base 15 °C (59 °F)
0628/9001 Activator 14 °C (57 °F)
0469/9000 Thinner 24 °C (75 °F)

Shelf Life:
4123 Base 24 months in original unopened container
0628/9001 Activator 24 months in original unopened container
0469/9000 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.
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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