Eco-Prime™ CF EEAE152 Epoxy Primer

TECHNICAL DATA SHEET

Product Description

Eco-Prime™ CF EEAE152 is a high solids, chrome-free, corrosion inhibiting epoxy primer. It is used over aluminum and composite surfaces prior to top coating.

- Compatible with Desothane® HS topcoats
- Excellent adhesion
- Low IR green
- Excellent fluid resistance
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components

Mix ratio (by volume):
- EEAE152A (base component) 3 parts
- EEAE152B (activator component) 1 part

Specifications

EEAE152 primers are qualified to:
- CPW 619
- PWA 36519

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

Product Compatibility:

EEAE152 primer is compatible with the following topcoat specifications:
- BMS 10-60 Type I & Type II
- BMS 10-72 Type VIII
- DMS 2115
- MIL-DTL-53039
- MIL-DTL-65419
- MIL-PRF-22750
- MIL-PRF-85285
- MMS-420

Surface Preparation and Pretreatments

Eco-Prime™ CF EEAE152 primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.
Eco-Prime™ CF EEAE152 Epoxy Primer

Instructions for Use

Mixing Instructions:
Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well. Maintain constant agitation for 10 minutes to ensure proper mixing. Induction time is necessary.

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° (55° to 95°F). The minimum temperature of the paint components should be 13°C (55°F) prior to mixing.

Induction Time:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>13 - 21°C (55 - 70°F)</th>
<th>22 - 28°C (71 - 84°F)</th>
<th>&gt;29°C (&gt;85°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Induction Time Required</td>
<td>40 minutes</td>
<td>30 minutes</td>
<td>20 minutes</td>
</tr>
</tbody>
</table>

Viscosity: (23°C/73°F)
- #4 Ford cup: 30 to 45 seconds
- BSB4 cup: 34 to 55 seconds
- AFNOR #4 cup: 34 to 52 seconds

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

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

Application Guidelines

Recommended Application conditions:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>15 - 30°C (59 - 86°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Relative Humidity</td>
<td>20 - 90%</td>
</tr>
</tbody>
</table>

Application:

Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 12 to 23 microns (0.5 to 0.9 mils). This can be accomplished with one medium coat with a 50% overlap.
Eco-Prime™ CF EEAE152 Epoxy Primer

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 (930 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 12 to 23 microns (0.5 to 0.9 mils)

Dry Film Density:
1.76 grams/cubic centimeter (14.66 pounds/gallon)

Dry Film Weight:
44.0 grams/square meter at 25 microns dry film (0.0084 pounds/square feet at 1 mil dry film)

Equipment:
EEAE152 primer is compatible with all current forms of spray equipment.

<table>
<thead>
<tr>
<th>Equipment Type</th>
<th>Tip Size</th>
<th>Pot Pressure</th>
<th>Atomization Pressure at the Cap</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electrostatic Air Spray Gun</td>
<td>1.2 mm or 1.5 mm</td>
<td>10 to 20 psi (0.69 to 1.4 bar)</td>
<td>45 to 60 psi (3.1 to 4.1 bar)</td>
</tr>
<tr>
<td>Electrostatic Air Assisted Airless Spray Gun</td>
<td>#611 or #613 (Graco Nomenclature)</td>
<td>700 to 1200 psi (48 to 82 bar)</td>
<td>40 to 60 psi (2.8 to 4.1 bar)</td>
</tr>
<tr>
<td>High Volume Low Pressure Spray Gun (HVLP)</td>
<td>1.0 mm to 1.4 mm</td>
<td>10 to 20 psi (0.69 to 1.4 bar)</td>
<td>10 psi maximum (0.69 bar)</td>
</tr>
<tr>
<td>Conventional Air Spray Gun</td>
<td>1.2 mm to 1.8 mm</td>
<td>10 to 20 psi (0.69 to 1.4 bar)</td>
<td>45 to 60 psi (3.1 to 4.1 bar)</td>
</tr>
</tbody>
</table>

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.
Eco-Prime™ CF EEAE152 Epoxy Primer

Physical Properties (product)

<table>
<thead>
<tr>
<th>Color:</th>
<th>Dark Green</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gloss:</td>
<td>Not Applicable</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Dry Times</th>
<th>13 - 21°C (55 - 70°F)</th>
<th>22 - 28°C (71 - 84°F)</th>
<th>&gt;29°C (&gt;85°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry to Touch</td>
<td>4 hours</td>
<td>3 hours</td>
<td>2 hours</td>
</tr>
<tr>
<td>Dry to Tape</td>
<td>7 hours</td>
<td>6 hours</td>
<td>5 hours</td>
</tr>
<tr>
<td>Dry to Topcoat</td>
<td>5 - 72 hours</td>
<td>4 - 72 hours</td>
<td>3 - 72 hours</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
<td>7 days</td>
<td>7 days</td>
</tr>
</tbody>
</table>

Accelerated cure to dry hard:

Dry to Tape
- Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
- followed by 60 minutes at 49°C (120°F)

Full Cure
- Allow 30 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
- followed by 24 hours at 49°C (120°F)

VOC:

<table>
<thead>
<tr>
<th>VOC</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Mixed, ready for use VOC (EPA method 24)</td>
<td>340 grams/liter</td>
</tr>
<tr>
<td>Base Component</td>
<td>364 grams/liter</td>
</tr>
<tr>
<td>Activator Component</td>
<td>302 grams/liter</td>
</tr>
</tbody>
</table>

Flash point closed cup:

<table>
<thead>
<tr>
<th>Flash point closed cup</th>
</tr>
</thead>
<tbody>
<tr>
<td>Base Component</td>
</tr>
<tr>
<td>Activator Component</td>
</tr>
</tbody>
</table>
Eco-Prime™ CF EEAE152 Epoxy Primer

Shelf Life:
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.
12 months from date of manufacture for PRC-DeSoto Standard.
*Note:* Shelf life is provided for the 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

For sales and ordering information call the local PPG office at the numbers listed below:

**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

**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

**America**

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

Desoclean, Desothane, DeSoto, and Eco-Prime are trademarks of PRC-DeSoto International, Inc.

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his use of the product. Seller’s and manufacturer’s sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller.

PRC-DeSoto International, Inc.
12780 San Fernando Road
Sylmar, CA 91342
www.ppgaerospace.com

Issue Date: 8/16
Lit: 4147