02Y040B Quick Dry Green Epoxy Primer

TECHNICAL DATA SHEET

Product Description

02Y040B quick dry green epoxy primer is a high solids, chemically cured, strontium chromated primer which provides corrosion, chemical and solvent resistance. It is compatible with MIL-PRF-85285 polyurethane topcoats for protection of military aircraft exteriors.

- Fast dry
- High solids
- Excellent adhesion
- Corrosion inhibiting
- Low density
- Resistant to immersion in hydraulic fluids, lubricating oils, phosphate ester based hydraulic fluids, Skydrol® hydraulic fluid and distilled water

Components

Mix ratio (by volume):

- 02Y040B (base component) 3 parts
- 02Y040BCAT (catalyst component) 1 part

Specifications

02Y040B is qualified to:

- MCS 9053 Type 1 Class 1 Grade 1
- MIL-PRF-23377 Type I Class C2

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

Product Compatibility:

02Y040B is compatible with the following primer specifications:

- DMS 2115
- MIL-PRF-22750
- MIL-PRF-85285
- MMS 420
02Y040B Quick Dry Green Epoxy Primer

Surface Preparation and Pretreatments

02Y040B primer can be applied over clean, dry, intact aluminum and composites surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

Instructions for Use

Mixing Instructions:

Stir or shake the base component to ensure any pigment, which may have settled on the bottom of the can, has been fully incorporated into the base. Do not stir or shake the base component longer than 5 minutes. Slowly add the one volume of catalyst to three volumes base component. Mix by hand stirring, paint shaker or mechanical mixing to ensure the base/catalyst mixture is homogeneous. Do not shake or mechanically mix material for longer than 10 minutes. Constant agitation of the material during spray application is recommended.

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 for standard application, however induction time of 30 minutes is recommended for applications requiring faster dry times, such as touch up or cold weather.

Viscosity: (23°C/73°F)

- #4 Ford cup 40 seconds maximum

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

Pot Life:

4 hours @ 21 - 25°C (70 - 77°F)
02Y040B Quick Dry Green Epoxy Primer

Application Guidelines

Recommended Application Conditions:

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

Application:

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:

19 square meters/liter at 25 microns dry film (772 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 15 to 23 microns (0.6 to 0.9 mils)

Dry Film Density:

1.44 grams/cubic centimeter (12.01 pounds/gallon)

Dry Film Weight:

3.38 grams/square meter at 25 microns dry film (0.00745 pounds/square feet at 1 mil dry film)

Equipment:

02Y040B are 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>
02Y040B Quick Dry Green Epoxy Primer

Equipment Cleaning:
Clean spray equipment as soon as possible after use. Flush spray equipment with IS-237 (MIL-T-81772 Type II) or Desoclean™ 45 high performance solvent cleaner. Once material has cured, use an approved chemical paint removal system to strip primer from parts and equipment.

Physical Properties (product)

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Green</td>
</tr>
<tr>
<td>Gloss</td>
<td>Not Applicable</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Dry Times</th>
<th>21 - 27°C (70 - 80°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tack Free</td>
<td>3 hours maximum</td>
</tr>
<tr>
<td>Dry to Topcoat</td>
<td>3 - 24 hours</td>
</tr>
<tr>
<td>Dry Hard</td>
<td>8 hours maximum</td>
</tr>
<tr>
<td>Full Cure</td>
<td>14 days maximum</td>
</tr>
</tbody>
</table>

Note: Dry times are based on film thickness. Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% relative humidity. After 8 hours of cure, solvent wipe the entire primed surface with IS-297 Primer Re-activator, Acetone or equivalent. After 24 hours of cure, scuff sand the entire primed surface, followed by a solvent wipe.

For dry to stack conditions only: Allow a minimum of 15 minutes flash off time at ambient temperatures prior to exposing painted parts to high temperatures. Complete testing should be done prior to use. Below are suggested starting points. Other variables may affect these cure schedules.
02Y040B Quick Dry Green Epoxy Primer

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>49°C (120°F)</td>
<td>45 minutes</td>
</tr>
<tr>
<td>60°C (140°F)</td>
<td>30 minutes</td>
</tr>
<tr>
<td>71°C (160°F)</td>
<td>20 minutes</td>
</tr>
<tr>
<td>82°C (180°F)</td>
<td>15 minutes</td>
</tr>
</tbody>
</table>

Note: Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% relative humidity.

VOC:
Mixed, ready to use VOC (EPA method 24) 333 grams/liter
Base Component 397 grams/liter
Catalyst Component 190 grams/liter

Flash Point closed cup:
Base Component 8°C (46°F)
Catalyst Component 8°C (46°F)

Shelf Life:
12 months from date of manufacture for most OEM 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 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

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Fax 81 561 35 5201

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Fax 65 6861 6162

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Fax (86-512) 6661 6868

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Fax 33 (0) 235 53 54 44

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**Americas**

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

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