CA7041 HS Polyurethane Primer

TECHNICAL DATA SHEET

Product Description
CA7041 is a two pack, low VOC polyurethane primer, suitable for application on pre-treated aluminium. CA7041 is designed for use on military vehicles and equipment.

- High solids, low VOC
- Suitable for application to suitably pretreated aluminium, aluminium alloys and non-ferrous metal substrates
- Overcoatable with two pack epoxy & polyurethane topcoats

Components

Mix Ratio (by volume)
- CA7041 (Base) 4 parts
- CA7041B (Activator) 1 part

Specifications
CA7041 is qualified to:
- Def Stan 80-207

Product Compatibility
CA7041 is intended for use over suitably pre-treated aluminium e.g. PR30B Etch Primer
CA7041 is compatible with the following Primer/Topcoat specifications:
- BS2X32
- BS2X34
- Def Stan 80-161
- Def Stan 80-208
- Def Stan 80-209
- MIL-PRF-85285

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

Surface Preparation and Pretreatment
Ensure that the correct surface pre-treatment has been carried out. Ensure the surface is clean, dry and intact using a high performance solvent cleaner - DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.
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Instructions for Use

Base material may require mechanical agitation. Ensure all components are adequately dispersed. Add activator to base component and stir thoroughly before use.

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)

- AFNOR4: 31-40 seconds
- FORD4: 30-37 seconds
- ISO4: 68-93 seconds
- ISO5: 30-40 seconds
- ZAHN2: 40-49 seconds

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

Application Guidelines

Recommended Application Conditions:
Temperature 15 - 35°C (59 - 95°F)
Relative Humidity 30 - 85%

Application:
Apply 1 cross coat to achieve recommended dry film thickness of 35 - 45 µm

Theoretical Coverage: (ready for use)
18 m² Lt @ 40 µm dry film thickness
720 ft² US gal @ 1.6 mil dry film thickness

Recommended Dry Film Thickness:
35 - 45 µm
1.4 - 1.8 mil
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Dry Film Density:
1.61 g/m³
13.4 lbs/US gal

Dry Film Weight:
64 g/m² @ 40 µm dry film thickness
0.013 lbs/ft² @ 1.6 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:

<table>
<thead>
<tr>
<th>Equipment Type</th>
<th>Tip Size</th>
<th>Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Airmix</td>
<td>6/13</td>
<td>29 to 51 psi (2 to 3.5 bar)</td>
</tr>
<tr>
<td>HVLP Air Spray</td>
<td>1.8 to 2.0 fluid tip</td>
<td></td>
</tr>
<tr>
<td>Pressure Pot</td>
<td>1.0 to 1.2mm</td>
<td>29 to 43 psi (2 to 3 bar)</td>
</tr>
<tr>
<td>Airless</td>
<td>6/11</td>
<td>870 psi (60 bar)</td>
</tr>
<tr>
<td>Air-assisted Airless Electrostatic</td>
<td>6/11</td>
<td>870 psi (60 bar)</td>
</tr>
<tr>
<td>Low Pressure Electrostatic</td>
<td>1.0 to 1.2mm</td>
<td>43 to 72 psi (3 to 5 bar)</td>
</tr>
</tbody>
</table>

Equipment Cleaning:
Clean spray equipment before use and as soon as possible after use. DeSoto® CN20 or CN44 solvent cleaners are recommended.

Small areas can also be brush applied.

Physical Properties

Colour:
Green

Gloss:
<10 units with a 60° gloss meter
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<table>
<thead>
<tr>
<th>Drying Times</th>
<th>23°C (73°F)</th>
<th>40°C (104°F)</th>
<th>60°C (140°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Touch Dry</td>
<td>1 hour</td>
<td>30 minutes</td>
<td>20 minutes</td>
</tr>
<tr>
<td>Dry to Tape</td>
<td>3 hours</td>
<td>1.5 hours</td>
<td>1 hour</td>
</tr>
<tr>
<td>Dry to Overcoat</td>
<td>1-72 hour</td>
<td>30 minutes</td>
<td>20 minutes</td>
</tr>
<tr>
<td>Dry to Sand</td>
<td>3 hours</td>
<td>1.5 hours</td>
<td>1 hour</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
<td>24 hours</td>
<td>3 hours</td>
</tr>
</tbody>
</table>

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

**Flash Off Time:**
15 minutes between coats or before force drying

**Special Note:**
For wet on wet scheme, overcoat after 1 hour

**VOC: (ASTM)**
- Mixed ready for use: 300g/Lt
- CA7041 Base Component: 295g/Lt
- CA7041B Activator: 305g/Lt

**Flash Point:**
- CA7041 Base Component: 20°C (64°F)
- CA7041B Activator: 25°C (68°F)

**Shelf Life:**
- CA7041 Base Component: 24 months in original unopened container
- CA7041B Activator: 24 months 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.
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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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