

4543/2905 7028 Black Epoxy Topcoat Matt

Product Description

4543/2905 is an air-drying epoxy matt black topcoat designed for the protection of aircraft interior surfaces.

- Conventional solids
- Excellent fluid resistance
- High chemical resistance

Components



Mix Ratio (by volume)

- 4543/2905 (Base) 1 part
- 0654/9000 (Activator) 1 part
- 0468/9000 (Thinner) to viscosity

Specifications



4543/2905 meets the requirements of:

- MIL-C-22750

Product Compatibility

4543/2905 is compatible with the following primer specifications:

- DHS 186-111
- BS2X33A+B

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

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner, DeSoto® CN20, Desoclean™ 45 are recommended. Observe recommended overcoat windows for primers.

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Instructions for Use



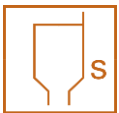
Hand stir or mechanically shake base material until all components are uniformly dispersed. Slowly add activator to base while stirring. Add required thinner while stirring.

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:

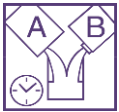
Not required



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 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

Application:

Apply in cross coats to achieve the recommended dry film thickness 25 - 30 µm



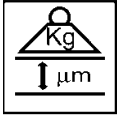
Theoretical Coverage: (mixed unthinned)

12 m²/Lt @ 25 µm dry film thickness
480 ft²/US gal @ 1 mil dry film thickness

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Recommended Dry Film Thickness:

25 - 30 μm



Dry Film Density:

1.9 g/cm³

16.02 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:



Equipment	Tip Size	Air Pressure
Conventional Air Spray	1.0 to 1.5 mm	43 to 72 psi (3 to 5 bar)
Airless	$\varnothing = 0.33\text{mm}$ – Angle 67 or 80° 36	1450 to 1885 psi (100 to 130 bar)



Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use, DeSoto® CN20, CN44 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties



Colour:

Black



Gloss:

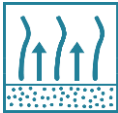
< = 5 units with a 60° gloss meter

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Drying Times @ 50 % Relative Humidity	23°C (73°F)	70°C (158°F)
Dust Free	1 hour	
Dry to Handle	2 hours	
Dry Tape	7 to 8 hours	30 minutes
Dry to Overcoat	2 to 72 hours	
Full Cure	7 days	3 hours

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



Flash Off Time:

30 minutes prior to force drying.



VOC: (ASTM)

Mixed unthinned	615 g/Lt
4543/2905 Base	530 g/Lt
0654/9000 Activator	700 g/Lt
0468/9000 Thinner	870 g/Lt



Flash Point:

4543/2905 Base	16°C (61°F)
0654/9000 Activator	14°C (57°F)
0468/9000 Thinner	14°C (57°F)

Shelf Life:

- 4543/2905 Base 24 months in original unopened container
- 0654/9000 Activator 24 months in original unopened container
- 0468/9000 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.

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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.

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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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