

PP404 Epoxide Primer

Product Description

PP404 is a two pack cold curing, chromated epoxy primer. PP404 can be overcoated with epoxy, acrylic or polyurethane finishes.

- Conventional solids
- Excellent corrosion resistance
- Excellent resistance to phosphate ester hydraulic fluids
- Excellent water resistance and adhesion properties

Components



Mix Ratio (by volume)

- | | |
|----------------------|--------------|
| • PP404 (Base) | 1 part |
| • ACT404 (Activator) | 1 part |
| • T193 (Thinner) | to viscosity |

Specifications



PP404 is qualified to:

- Mil-P-23377D Type I Class I

Product Compatibility

PP404 is compatible with the following specifications:

- BSX34A+B
- Mil-C-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 - Desoto® CN20 or Desoclean™ 45 solvent cleaner are recommended.

PP404 Epoxide Primer

Instructions for Use



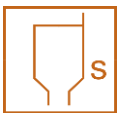
Hand stir or mechanically shake base material until all components are uniformly dispersed. Add activator to base material and mix thoroughly add thinner as required.

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)

• AFNOR2.5	43 - 56 seconds
• AFNOR4	15 - 16 seconds
• BSB3	25 - 30 seconds
• BSB4	14 - 17 seconds
• FORD4	12 - 15 seconds
• ISO3	35 - 50 seconds
• ISO4	17 - 22 seconds
• ZAHN2	16 - 20 seconds

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



Pot Life:

8 hours maximum @ 21 - 25°C (70 - 77°F)

Application Guidelines

Recommended Application Conditions:

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

Application:

Apply a single coat to achieve the recommended dry film thickness of 15 - 25 µm



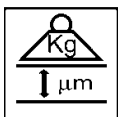
Theoretical Coverage: (ready for use)

16 m²/Lt @ 20 µm dry film thickness
640 ft/US gal @ 0.8 mil dry film thickness

Recommended Dry Film Thickness:

15 - 25 µm
0.6 -1 mil

PP404 Epoxide Primer



Dry Film Density:

1.7 g/cm³
14.4 lbs./US gal

Dry Film Weight:

35 g/m² @ 20 μm dry film thickness
0.007 lbs/ft² @ 0.8 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 Type	Tip Size	Material Pressure	Pot Pressure	Atomization Pressure
Airmix	609 to 611	29 to 44 psi (2 to 3 bar)		43 to 58 psi (3 to 4 bar)
HVLP Airspray	1.4 to 1.8			29 psi (2 bar)
Pressure Pot	1.0 to 1.2		10 psi (0.7 bar)	29 psi (2 bar)
Airless	609 to 611			29 to 44 psi (2 to 3 bar)
Air Assisted Electro	609 to 611	29 to 44 psi (2 to 3 bar)		58 to 73 psi (4 to 5 bar)
Low Pressure Electro	1.0 to 1.2	15 to 29 psi (1 to 2 bar)		44 to 73 psi (4 to 5 bar)

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:

Yellow



Gloss:

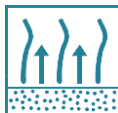
< 10 units with a 60° gloss meter

PP404 Epoxide Primer



DRYING TIMES	23°C (73°F)	70°C (158°F)
Tack Free	1 hour	
Hard Dry	6 hours	30 minutes
Overcoat	1 hour (min.) 72 hours (max.)	
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:

15 - 30 minutes @ 23°C prior to force dry application



VOC: (ASTM)

Mixed (unthinned)	570 g/Lt
PP404 Base Component	450 g/Lt
ACT404 Activator	680 g/Lt
T193 Thinner	840 g/Lt



Flash Point:

PP404 Base Component	-4°C (25°F)
ACT404 Activator	4°C (39°F)
T193 Thinner	-4°C (25°F)

Shelf Life:

PP404 Base Component	24 months in original unopened container
ACT404 Activator	24 months in original unopened container
T193 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.

PP404 Epoxide Primer

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.

PP404 Epoxide Primer

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

Americas

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

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

Desoclean and DeSoto 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.

This document has been reviewed by the PPG Aerospace Export Control Department and has been determined to contain only EAR99 controlled data

PPG Aerospace

Sealants and Coatings

Darlington Road

Shildon, Co Durham UK

DL4 2QP

www.ppgaerospace.com

Issue Date: 07/20

Lit: 4336

PP404 Epoxide Primer