Super Koropon® 515-700 Fluid Resistant Interior Primer

TECHNICAL DATA SHEET

Product Description

Super Koropon® 515-700 fluid resistant conventional solids epoxy coating. This high performance primer is used to protect the structural interior of aircraft from corrosion.

- Compatible with epoxy and urethane interior topcoats
- Excellent adhesion to a variety of aluminum and composite surfaces
- Excellent Skydrol® resistance
- Compatible with all non-electrostatic spray equipment
- Can be applied in a wide range of conditions
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components

Mix ratio (by volume):

- 515-700 (base component) 1 part
- 910-704 (activator component) 1 part

Specifications

515-700 primer is qualified to:

- 171A4764P1
- 507-9-466 Type I
- CM37.14-02-01
- CM37.14-05
- CMS-CT-202 Type I Class 1
- DMS 1786 Type I Composition A
- DPM 4838
- GM 5009
- HBMS-24-008
- MCS 9261
- MMS-415
- MS 37.14
- P8266829
- SP-676
- STMO 685
- SVHS 6600
- VS 1-3-1-41
- HBMS-24-008

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

Product Compatibility:

515-700 primer is compatible with the following topcoat specifications:

- BMS 10-11 Type II
- BMS 10-60 Type I
- DMS 2143
- DPM 5391
Super Koropon® 515-700 Fluid Resistant Interior Primer

Surface Preparation and Pretreatments

Super Koropon® 515-700 primer can be applied over clean properly prepared aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

Instructions for Use

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

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

Viscosity: (23°C/73°F)
- #1 Signature Zahn cup 26 to 35 seconds
- #2 Signature Zahn cup 10 to 16 seconds
- #4 Ford cup 10 to 12 seconds
- ISO 3mm cup 25 to 37 seconds
- ISO 4mm cup 15 to 18 seconds
- BSB3 cup 22 to 26 seconds
- BSB4 cup 12 to 15 seconds
- AFNOR #2.5 cup 37 to 45 seconds
- AFNOR #4 cup 13 to 15 seconds

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

Pot Life:
8 hours @ 21 - 25°C (70 - 77°F)
Super Koropon® 515-700 Fluid Resistant Interior Primer

Application Guidelines

Recommended Application Conditions:

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

Application:

Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 12.5 to 22.5 microns (0.5 to 0.9 mils). This can be accomplished with one medium coat with a 50% overlap.

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:
8.6 square meters/liter at 25 microns dry film (352 square feet/gallon at 1 mil dry film)

Recommended dry film thickness; 12.5 to 22.5 microns (0.5 to 0.9 mils)

Dry Film Density:
1.88 grams/cubic centimeter (15.66 pounds/gallon)

Dry Film Weight:
47 grams/square meter at 25 microns dry film (0.00956 pounds/square feet at 1 mil dry film)

Equipment:
515-700 primer is compatible with all non-electrostatic 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>High Volume Low Pressure Spray Gun</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.
Super Koropon® 515-700 Fluid Resistant Interior Primer

Physical Properties (product)

- **Color:** Green
- **Gloss:** Not Applicable

### Dry Times

<table>
<thead>
<tr>
<th>Condition</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>Tack Free</td>
<td>45 minutes</td>
<td>30 minutes</td>
<td>15 minutes</td>
</tr>
<tr>
<td>Dry to Stack</td>
<td>1 hour</td>
<td>45 minutes</td>
<td>30 minutes</td>
</tr>
<tr>
<td>Dry To Fly</td>
<td>60 hours</td>
<td>48 hours</td>
<td>40 hours</td>
</tr>
<tr>
<td>Dry to Topcoat</td>
<td>1 - 24 hours</td>
<td>1 - 24 hours</td>
<td>1 - 24 hours</td>
</tr>
<tr>
<td>Dry to Tape</td>
<td>2 ½ hours</td>
<td>2 hours</td>
<td>1 ½ hours</td>
</tr>
<tr>
<td>Dry Through</td>
<td>5 hours</td>
<td>4 hours</td>
<td>3 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 for dry hard:
- Allow 15 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
- followed by 40 - 45 minutes at 49°C (120°F)

### VOC (EPA method 24):

- Mixed, ready to use VOC: 650 grams/liter
- Base Component: 499 grams/liter
- Activator Component: 784 grams/liter

### Flash point closed cup:

- Base Component: -5°C (23°F)
- Activator Component: -9°C (16°F)
Super Koropon® 515-700 Fluid Resistant Interior Primer

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

*Note: The coating 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
- **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

**Americas**

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

---

Desoclean, DeSoto, and Super Koropon 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.