

# Desofill™ HS CA8620TG Sanding Surfacers

## TECHNICAL DATA SHEET

### Product Description

Desofill™ HS, CA8620TG, sanding surfacer is a trowelable grade, chromate-free, high solids coating. It is used to cover rivets and seams, and fill in the irregularities and surface defects commonly experienced on aluminum, fiber glass, and composite surfaces

- Designed for application with trowel or knife
- Excellent adhesion to composites, epoxy primers, and Desothane® HS topcoats
- Available in gallon kits or Sempak cartridges
- Excellent fluid resistance
- Needs a corrosion resistant primer when used on aluminum surfaces
- Service temperature -54°C to 177°C (-65°F to 350°F)

### Components



#### Mix ratio (by volume):

- CA8620TG (base component) 1 part
- CA8620TGB (activator component) 1 part

#### Product Compatibility:

CA8620TG is compatible with the following topcoat specifications:

- BAMS 565-009
- BMS 10-60 Type I & Type II
- BMS 10-72 Type VIII
- DPM 6546
- MEP 10-069
- MIL-PRF-85285

### Surface Preparation and Pretreatments



Desofill™ HS, CA8620TG, sanding surfacer can be applied over clean, dry, intact composites and primed aluminum.

### 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.

# Desofill™ HS CA8620TG Sanding Surfacers

*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.*



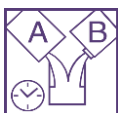
**Induction Time:**

Not Required



**Viscosity:** (23°C/73°F)

Thick paste



**Pot Life:**

1 hour @ 21 - 25°C (70 - 77°F)

## 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 applying the sanding surfacer. The suggested film thickness is 75 to 250 microns (3 to 10 mils). This can be accomplished by two or three applications. Recommended dry film thickness after sanding; 25 to 125 microns (1 to 5 mils).

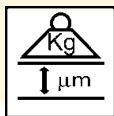
*These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.*



**Theoretical Coverage:**

39 square meters/liter at 25 microns dry film (1596 square feet/gallon at 1 mil dry film)  
 Recommended dry film thickness before sanding; 75 to 250 microns (3 to 10 mils)  
 Recommended dry film thickness after sanding; 25 to 125 microns (1 to 5 mils)

# Desofill™ HS CA8620TG Sanding Surfacers



**Dry Film Density:**

1.6 grams/cubic centimeter (13.33 pounds/gallon)

**Dry Film Weight:**

40 grams/square meter at 25 microns dry film (0.00827 pounds/square feet at 1 mil dry film)



**Equipment Cleaning:**

Clean application equipment as soon as possible after use. Use DeSoto® CN20, DeSoto® CN44, or Desoclean™ 45 high performance solvent cleaner.

## Physical Properties (product)



**Color:** White



**Gloss:** Not Applicable



<b>Dry Times</b>	<b>13 - 21°C (55 - 70°F)</b>	<b>22 - 28°C (71 - 84°F)</b>	<b>&gt;29°C (&gt;85°F)</b>
Dust Free	1 ½ hours	1 hours	45 minutes
Tack Free	2 ½ hours	2 hours	1 ½ hours
Dry to Sand	6 hours	5 hours	4 hours
Full Cure	7 days	7 days	7 days

Accelerated cure for dry to sand:

Allow 1 hour flash off at 24°C ± 3°C (75°F ± 10°F)  
followed by 1 ½ hours at 60°C (140°F)



**VOC:**

Mixed, ready to use VOC (EPA method 24)	5 grams/liter
Base Component	9 grams/liter
Activator Component	0 grams/liter

## Desofill™ HS CA8620TG Sanding Surfacers



### Flash point closed cup:

Base Component	31°C (88°F)
Activator Component	158°C (316°F)

### 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: 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.*



# Desofill™ HS CA8620TG Sanding Surfacers

## 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](http://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, Desofill, Desothane, 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.

PRC-DeSoto International, Inc.  
12780 San Fernando Road  
Sylmar, CA 91342  
[www.ppgaerospace.com](http://www.ppgaerospace.com)

Issue Date: 6/16  
Lit: 4067