Desothane® HS Topcoat – CA 8200 Series

The CA 8200 series is a part of PPG Aerospace’s growing family of Desothane® HS topcoat products. These advanced technology polyurethane topcoat products have been specifically developed to meet the stringent survivability requirements of today’s military applications.

The performance advantages of the CA 8200 series are the result of careful control over the product’s underlying polymer and cross-linking chemistry. Manipulation of the molecular architecture within the cured coating has allowed the development of a material possessing the critical balance of flexibility, fluid resistance, and ease of application. Long-term exterior durability has been achieved by designing a polymeric backbone that eliminates UV-sensitive compounds while the use of star-shaped polymer molecules results in lowered VOC levels. Resistance to the influence of humidity during cure has also been achieved through the use of star polymers.

The CA 8200 series has been modeled after the highly successful commercial aviation topcoat: Desothane® HS topcoat CA 8000 series. This industry-standard topcoat has over eight years of proven in-flight performance. The CA 8200 series is the third generation of a high solids exterior topcoat developed by PPG Aerospace and is qualified to military and OEM specifications.

The CA 8200 series is formulated to deliver a long wet-edge time and is available in a variety of dry-to-tape times. The standard dry-to-tape time is 5 to 7 hours and is available in all gloss ranges. This can also be accelerated to 2 to 3 hours. A one-hour dry hard gloss version is available for plural component application equipment. Not only is Desothane® HS topcoat chemistry unaffected by extremes in humidity, its cure time can be further accelerated by the use of heat when painting detail parts.
Desothane® HS Topcoat
A Family of Products

1) Apply a light to medium first coat with a maximum of 1.5 wet mils (37 microns) over the primer. It is important to apply a uniform first coat so it will flow out without orange peel. Any surface defects will telegraph through the surface of the second coat.

2) The first coat should “tack up” before applying the second coat. Tacking up means there should be a slight transfer of wet paint to the finger when lightly touched.

The correct time between coats is extremely important in obtaining a good finish. If the second coat is applied too soon, it could develop sags around the fasteners. However, if it is applied too late (when the first coat has passed through the tacky stage and is no longer tacky), it will not flow out very well on the first coat and can cause severe orange peel.

3) The second coat should be applied slightly thicker than the first coat with a maximum of 2.5 wet mils (62 microns).

It is recommended to use freshly mixed paint for each coat. Try to avoid mixing old and freshly mixed paint. This can reduce the pot life of the freshly mixed paint and possibly cause surface defects such as orange peel and reduced wet edge.

Application Guidelines – Gloss Colors

Commercial and General Aviation

- CA 8000 / CA 8800 Topcoat
- Qualified to BMS 10-60, BMS 10-72, DMS-2143, DPM 6456, DPM 6546
- Qualified to AIMS 04-04-013 and AIMS 04-04-032
- Qualified to BAMS 565-09
- Qualified to DHMS C4.04
- Qualified to MEP 10-069
- Meets performance requirements of AMS 3095
- Three-component mix for flexibility and robustness of use

Military and Defense

- CA 8200 Topcoat
- Qualified to Mil-PRF-85285
- Qualified to Boeing MMS-420 and DMS-2115 Type I
- Standard product is 5-7 hours dry-to-tape
- Accelerated cure versions available per Mil-PRF-85285 Section 6.12
- Available in all gloss ranges
- Long wet edge time
- Camouflage and semi-gloss colors do not tiger stripe
- Two-component mix ratio to Mil-Spec requirements

Common Topcoat Characteristics

- Gloss coatings have high DOI
- Available in 4 cure times
- Excellent flow and leveling
- Exceptional UV durability in all gloss ranges
- Humidity has no known effect on cure and application
- Can be applied with HVLP, electrostatic, conventional, or plural spray equipment
- Jet fuel and hydraulic fluid resistant
- Skydrol® fluid resistant
- Available in Sempen® applicators for touch-ups
- Walkway coating available as additional component

Walkway coating available as additional component
Desothane® HS Military Topcoat
CA 8200 Series

82 0 1 / F17925

Gloss Designation:
0 High gloss (90+)
1 Camouflage (<5)
2 Semi-gloss (25-35)
7 Dead-matte (<2)

Dry-To-Tape:
1 5-7 hours
2 3-5 hours
3 2-3 hours
4 1 hour

Mix Ratios:
gloss: 1:1
semi-gloss: 3:1
flat: 3:1

Activators:
gloss: 8000D
semi-gloss/flat: 8200B

Cure profile for CA8200 Military and Defense Topcoat

<table>
<thead>
<tr>
<th>CA 82x1/Fxxxx</th>
<th>55°F (13°C)</th>
<th>75°F (24°C)</th>
<th>95°F (35°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry-to-tape</td>
<td>8-10 hours</td>
<td>4 hours</td>
<td>3 hours</td>
</tr>
<tr>
<td>Pot life</td>
<td>4 hours</td>
<td>3 hours</td>
<td>3 hours</td>
</tr>
<tr>
<td>Dry between coats</td>
<td>60-90 min.</td>
<td>45-60 min.</td>
<td>30-45 min.</td>
</tr>
<tr>
<td>Wet edge</td>
<td>Gloss-60 min.</td>
<td>S/G-45 min.</td>
<td>Flat-30 min.</td>
</tr>
<tr>
<td></td>
<td>S/G-45 min.</td>
<td>Flat-30 min.</td>
<td>Flat-30 min.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>CA 82x2/Fxxxx</th>
<th>55°F (13°C)</th>
<th>75°F (24°C)</th>
<th>95°F (35°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry-to-tape</td>
<td>5-7 hours</td>
<td>3-5 hours</td>
<td>2-3 hours</td>
</tr>
<tr>
<td>Pot life</td>
<td>4 hours</td>
<td>2-3 hours</td>
<td>1-2 hours</td>
</tr>
<tr>
<td>Dry between coats</td>
<td>30-40 min.</td>
<td>15-30 min.</td>
<td>10-20 min.</td>
</tr>
<tr>
<td>Wet edge</td>
<td>Gloss-60 min.</td>
<td>Gloss-45 min.</td>
<td>S/G-20 min.</td>
</tr>
<tr>
<td></td>
<td>S/G-45 min.</td>
<td>Flat-15 min.</td>
<td>Flat-15 min.</td>
</tr>
</tbody>
</table>

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<thead>
<tr>
<th>CA 82x3/Fxxxx</th>
<th>55°F (13°C)</th>
<th>75°F (24°C)</th>
<th>95°F (35°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry-to-tape</td>
<td>4-5 hours</td>
<td>2-3 hours</td>
<td>1-2 hours</td>
</tr>
<tr>
<td>Pot life</td>
<td>3 hours</td>
<td>2 hours</td>
<td>1 hour</td>
</tr>
<tr>
<td>Dry between coats</td>
<td>20-30 min.</td>
<td>10-20 min.</td>
<td>10 min.</td>
</tr>
<tr>
<td></td>
<td>S/G-20 min.</td>
<td>Flat-15 min.</td>
<td>Flat-15 min.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>CA 82x4/Fxxxx</th>
<th>55°F (13°C)</th>
<th>75°F (24°C)</th>
<th>95°F (35°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry-to-tape</td>
<td>90 min.</td>
<td>1 hour</td>
<td>20 min.</td>
</tr>
<tr>
<td>Pot life</td>
<td>45 min.</td>
<td>30 min.</td>
<td>15 min.</td>
</tr>
<tr>
<td>Dry between coats</td>
<td>10 min.</td>
<td>5-10 min.</td>
<td>5 min.</td>
</tr>
</tbody>
</table>

Note:
- Dark colors (e.g. black, dark blue) may cure slower than light colors.
- Fxxxx is any Fed. Color Std. 595B.
- Flash-off is typically 1 hour air-dried by heat curing, however this is not recommended on fast versions 82X3 and 82X4.
- All Fed. Std. 595 colors available.
- Compatible with Mil-PRF-23377, Mil-PRF-85582, TTP 2760, and 1432GV primers.
- All Desothane® HS Military topcoats certified and qualified to Mil-PRF-85285 and MMS 420.

4) If a third coat is desired, allow the second coat to “tack up”.
5) Apply a third, medium coat similar to the second coat.

Note:
The time between coats will be affected by temperature, air flow, and film thickness. Thinner films, higher temperatures, and higher air flow will decrease the time between coats. Thicker films, lower temperatures, and poor air flow will increase the time between coats.

Semi-Gloss and Camouflage

The wet edge of camouflage colors is between 20 and 30 minutes for 5 to 7 hours dry-to-tape at 77°F or 25°C for Desothane® HS CA 8200 topcoat. Therefore, it is very important to maintain the wet edge during application to avoid dry spots or tiger stripes. These topcoats can be applied in either one or two coats.

1) In a one-coat (cross coat/box coat) application, apply a light to medium coat followed immediately by a medium coat applied over the same area, but applied in an alternating spray direction to a total wet film thickness of 3.0-4.0 mils (75-100 microns).
Application Properties

**Volatile organic compound (VOC)**

EPA method 24, mixed system 420 g/l max.
Mix ratio (by volume)
- Gloss colors
  - 1 part - Base (CA 8201)
  - 1 part - Activator (CA 8000D)
- Camouflage, semi-gloss, dead-matte
  - 3 parts - Base component (CA 8211, CA 8221 or CA 8271)
  - 1 part - Activator (CA 8200B)

Viscosity, Ford #4 cup
- Fresh mixed: 30 sec. max.
- Pot life*:
  - All gloss colors: 4 hours, 40 sec. max.
  - All other glosses: 3 hours, 50 sec. max.

*Using base component CA 82X1, “X” denotes gloss level

**Theoretical coverage**

All colors and gloss ranges
- 825 ± 50 ft²/gal @ 1 mil dry film
  - (20 ± 1.2 m²/l @ 25 microns dry film)

Accelerated cure - 60 minutes flash off, then four hours at 120°F for dry hard. For full cure apply heat for 24 hours at 120°F (49°C).

Accelerated cure can be achieved by using base components as follows:
- CA 82X2 3-4 hrs DTT @ 77°F (25°C), 50% RH
- CA 82X3 2-3 hrs DTT @ 77°F (25°C), 50% RH

Note: “X” denotes gloss level.

Spray equipment - Compatible with all forms of spray equipment.

Shelf life - 12 months from manufacture date.

Sempen® applicator shelf life - 6 months from manufacture date.

**Dry film density**

Gloss colors
- 0.0075 ± 0.001 lbs/ft² @ 1 mil dry film
  - (37 ± 5 gms/m² @ 25 microns dry film)

Camouflage, semi-gloss, dead-matte
- 0.0084 ± 0.001 lbs/ft² @ 1 mil dry film
  - (41 ± 5 gms/m² @ 25 microns dry film)

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All colors and gloss ranges
- 825 ± 50 ft²/gal @ 1 mil dry film
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**Marking Colors**

1) If the topcoat is dry-to-tape but less than 24 hours old, colors can be applied without abrading the topcoat.
2) If the topcoat is more than 24 hours old, lightly abrade the surface to remove the gloss, wipe clean with either Desoclean® 45 cleaner or Desoclean® 110 cleaner, then wipe dry and apply the marking colors.

2) In a two-coat system, apply a light to medium wet first coat to a uniform continuous film thickness – approximately 1.5-2.0 wet mils (35-50 microns). Allow the first coat to flash off and tack up before starting the second coat. Apply a uniform medium wet coat with a 50 percent overlap. The second coat can be applied wetter to a total wet film thickness of 3.0-4.0 wet mils (75-100 microns).
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.

PPG Aerospace – PRC-DeSoto

Aerospace Service Centers

ASC – Australia
23 Ovata Drive
Tullamarine, Victoria 3043
Australia
Tel 61 (3) 9335 1557
Fax 61 (3) 9335 3490

ASC – Canada
5676 Timberlea Boulevard
Mississauga, Ontario
L4W 4M6
Canada
Tel (905) 629-7999
Fax (905) 629-7009

ASC – China
PPG Aerospace Materials (Suzhou) Co. Ltd.
No. 155 Hua Shan Road
Suzhou New District
Suzhou 215129
China
Tel (86-512) 6661 5858
Fax (86-512) 6661 6868

ASC – Dubai
Post Office Box 17725
JAFZ, Dubai
U.A.E.
Tel (971) 4 883 9799
Fax (971) 4 883 9665

ASC – Germany
Hein-Saß-Weg 29
D-21129 Hamburg
Finkenwerder
Germany
Tel 49 (40) 742 139 69
Fax 49 (40) 742 193 10

ASC – Japan
PPG Japan Ltd.
18-20, 11 Gochi
Handa-shi
Aichi-ken 475-0831
Japan
Tel 81 569 24-8813
Fax 81 569 24-8913

ASC – South Africa
a division of PPG Coatings
South Africa (Pty) Ltd.
10 Enterprise Close
Linbro Business Park
Post Office Box 31
Linbro Park, 2065
Tel 27 11 608 5656
Fax 27 11 608 1689

ASC – South East Asia
63 Tuas Avenue 1
Singapore 639507
Tel 65 6861 1119
Fax 65 6861 6162

ASC – United Kingdom
Darlington Road
Shildon
Co Durham DL4 2QP
England
Tel 44 (0) 1388 770222
Fax 44 (0) 1388 770288

USA Locations

ASC – Atlanta
3330 West Town Point Drive
Suite F
Kennesaw, GA 30144
USA
Tel (770) 429-9998
Fax (770) 429-9130

ASC – Dallas
2750 114th Street
Suite 400
Grand Prairie, TX 75050
USA
Tel (817) 640-1067
Fax (817) 640-1058

ASC – Indianapolis
6022 Corporate Way
Indianapolis, IN 46278
USA
Tel (317) 290-1600
Fax (317) 290-1300

ASC – Los Angeles
5430 San Fernando Road
Glendale, CA 91203
USA
Tel (818) 549-7979
Fax (818) 549-7989

ASC – Philadelphia
823 East Gate Drive
Mt. Laurel, NJ 08054
USA
Tel (856) 234-1600
Fax (856) 234-5515

ASC – Phoenix
2266 S. Dobson Road
Suite 200
Mesa, AZ 85202
USA
Tel (480) 756-6110
Fax (480) 756-6112

ASC – Seattle
14126 NE 190th Street
Woodinville, WA 98072
USA
Tel (425) 483-3999
Fax (425) 483-3993

Manufacturing

France
Coatings
7 Allée de la Plaine
Gonfreville l’Orcher
76700 Harfleur
France
Tel 33 235 53 54 00
Fax 33 235 53 54 02

Japan
Sealants
1-36 Nitto-cho
Handa-shi
Aichi-ken 475-0033
Japan
Tel 81 569 24 0721
Fax 81 569 24 0721

USA
Sealants and Coatings
11601 United Street
Mojave, CA 93501
USA
Tel (661) 824 4532
Fax (661) 824 4531

Manufacturing and Sales

England
Sealants and Coatings
Darlington Road
Shildon
Co Durham DL4 2QP
England
Tel 44 (0) 1388 772541
Fax 44 (0) 1388 774373

France
Coatings
75 Boulevard Winston Churchill
76052 Le Havre Cedex
France
Tel 33 235 53 54 00
Fax 33 235 53 54 50

Regional Sales Offices

France
PRC-DeSoto International, Inc.
20 Chemin Laporte
31300 Toulouse
France
Tel 33 (0) 5 6149 4849
Fax 33 (0) 5 6131 8928

Hong Kong
Suite 1010-1015, 10/F
Cityplaza One
1111, King’s Road
Taikoo Shing
Hong Kong
Tel 852 2861 0918
Fax 852 2804 2859

Japan
PPG Japan Ltd.
Shibuya Cross Tower 13F
2-15-1, Shibuya
Shibuya-ku, Tokyo
15-0002
Japan
Tel 81 3 5778-2544
Fax 81 3 5778-2566

PPG Aerospace

PRC-DeSoto

Where Smart Solutions Take Flight®

PRC-DeSoto International, Inc.
5430 San Fernando Road
Post Office Box 1800
Glendale, CA 91209
USA
Telephone (818) 240-2060
Toll Free (800) AEROMIX
Fax (818) 549-7798

www.ppgaerospace.com

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