



Desobond™ CA104 Wipe Solvent

TECHNICAL DATA SHEET

Product Description

Desobond™ CA104 is a wipe solvent that leaves a thin film to improve adhesion on aged epoxy and urethane coatings. It also improves bonding characteristics to aluminum, acrylics, and other aerospace alloys.

- Eliminates sanding
- Available in one component or two component
- Compatible with epoxy primers and urethane topcoats
- Can be sprayed with non-electrostatic spray equipment
- Removes minor contaminants
- Can be applied with lint free wipes
- Service temperature -54 °C to 177 °C (-65 °F to 350 °F)

Components



Mix ratio (by volume):

- CA104A (base component) 1 part
- CA104B (activator component) 1 part

Product Compatibility:

CA104 is compatible with the following primer and topcoat specifications:

- BMS 10-11 Type I & Type II
- BMS 10-60 Type I & Type II
- BMS 10-72 Type VIII
- BMS 10-79 Type II & Type III
- BMS 10-103
- BMS 10-128 Type III
- DMS 2115
- MIL-PRF-23377
- MIL-PRF-85285
- MMS 420

Surface Preparation and Pretreatments



Desobond™ CA104 can be applied over clean, properly prepared epoxy primer, polyurethane topcoats, aluminum and composite surfaces.

Instructions for Use



Mixing Instructions:

Prior to mixing, hand stir the base component. Add the activator to the base component and stir well, maintain constant agitation for 10 minutes to ensure proper mixing. Induction time may be required based on temperature.

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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:

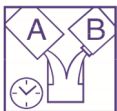
Temperature	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Induction Time Required	30 minutes	15 minutes	None



Viscosity: (23 °C/73 °F)

- #2 Signature Zahn cup 12 to 18 seconds
- #4 Ford cup 10 to 14 seconds
- ISO 3mm cup 30 to 50 seconds
- ISO 4mm cup 16 to 22 seconds
- BSB3 cup 24 to 30 seconds
- BSB4 cup 15 to 17 seconds
- AFNOR #2.5 cup 45 to 56 seconds
- AFNOR #4 cup 14 to 16 seconds

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



Pot Life for Two Component:

8 hours @ 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 priming. Stir the primer slowly during the application. The suggested film thickness is 2.5 microns (0.1 mils). This can be accomplished with one light coat.

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

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Theoretical Coverage:

6 square meters/liter at 25 microns dry film (210 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 2.5 microns (0.1 mils)



Dry Film Density:

0.12 grams/cubic centimeter (1 pound/gallon)

Dry Film Weight:

3 grams/square meter at 25 microns dry film (0.0006 pounds/square feet at 1 mil dry film)



Equipment:

CA104 is compatible with HVLP, airless, air assisted airless spray equipment. It can also be applied with a lint-free wiper or cheese cloth.

Equipment Type	Tip Size	Pot Pressure	Atomization Pressure at the Cap
High Volume Low Pressure Spray Gun (HVLP)	1.0 mm to 1.4 mm	10 to 20 psi (0.69 to 1.4 bar)	10 psi maximum (0.69 bar)
Conventional Air Spray Gun	1.2 mm to 1.8 mm	10 to 20 psi (0.69 to 1.4 bar)	45 to 60 psi (3.1 to 4.1 bar)

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.

Physical Properties (product)



Color: Clear



Gloss: Not Applicable

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Dry Times	13 - 21 °C (55 - 70 °F)	22 - 28 °C (71 - 84 °F)	>29 °C (>85 °F)
Dust Free	20 minutes	15 minutes	10 minutes
Tack Free	35 minutes	30 minutes	40 minutes
Dry to Overcoat	1 - 48 hours	1 - 48 hours	1 - 48 hours
Full Cure	7 days	7 days	7 days

Accelerated cure:

Allow 30 minutes flash off at 24 °C ± 3 °C (75 °F ± 10 °F)
followed by 30 minutes at 49 °C (120 °F)



VOC (EPA method 24):

Mixed, ready for use VOC	810 grams/liter
Base Component	793 grams/liter
Activator Component	827 grams/liter

Vapor Pressure:

CA104A	2.312 mm HG
CA104B	17.922 mm HG



Flash point:

Base Component	44 °C (111 °F)
Activator Component	6 °C (43 °F)

Shelf Life:

24 months from date of manufacture for PRC-DeSoto Standard.

Note: Shelf life is provided for the 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.



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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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Issue Date: 7/14
Lit: 3044