



## Technical Data

<b><u>Product name</u></b>	<b>CA 8400/B900 Desothane HS Ceramic Clearcoat</b>
<b><u>Product Description</u></b>	Desothane HS Ceramic Clearcoat is a two-component polyurethane, mar and scratch resistant high solids clearcoat designed for exterior and interior (furniture) application.
<b><u>Key Features</u></b>	Fire retardant Excellent surface properties which, compared with conventional clearcoats, protect the finish against scratches & abrasion therefore preserving the glossy finish for a long time.
<b><u>Specifications – Approvals</u></b>	FAR 25.853 Vertical Flammability Test - Fire Test to Aircraft Material
<b><u>Catalyst/Hardener/Activator</u></b>	8402B
<b><u>Pack Size</u></b>	Base 5 litres tin Activator 0.5 litre tin
<b><u>Mix Ratio by volume</u></b>	8400B900 2 volumes 8402B 1 volume
<b><u>Recommended Scheme</u></b>	Desothane HS Ceramic Clearcoat is designed to be applied over the CA 8660 Desothane HS Filler & Build Coat

### **Product Application Parameters**

<b>Surface Preparation</b>	Ensure surface is clean and free from any contaminants.
<b>Mixing Instructions</b>	Hand stir the base component to achieve homogeneous product. Add 1 volume of activator 8402B to 2 volumes of base 8400B900 and ensure well mixed.
<b>Viscosity at 23°C (73°F)</b>	24 – 32 seconds Afnor 4 16 – 20 seconds Iso 4
<b>Induction Time</b>	Not required
<b>Pot Life</b>	1 hour after mixture at 23°C or 73°F
<b>Application Method</b>	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.  Following application process is based on our experience and could be Optimized with the customer.



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### Application process

- Apply a 1<sup>st</sup> coat at about 75-100 wet microns (3-4 mils) with a conventional spray gun
  - Allow 2-3 hours drying at ambient temperature
  - Apply a 2<sup>nd</sup> coat at about 75-100 wet microns (3-4 mils) with a conventional spray gun
  - Allow 2 hours flash off at 23°C / 73°F followed by 12 to 48h at 50°C / 122°F
  - Sand with 400 grade paper until a completely smooth surface is obtained
  - Tack rag application
  - Apply a 3<sup>rd</sup> coat at about 75-100 wet microns (3-4 mils) with a conventional spray gun
  - Allow 2-3 hours drying at ambient temperature
  - Apply a 4<sup>th</sup> coat at about 75-100 wet microns (3-4 mils) with a conventional spray gun
  - Allow 2 hours flash off at 23°C / 73°F followed by 12 to 48h at 50°C / 122°F
- If required apply additional coats can be applied**
  - The last coat should be applied according to the following process**
    - Sand with 400 grade paper until a completely smooth surface is obtained
    - Tack rag application
    - Apply one cross coat, allow 15-20 minutes flash off at 23°C / 73°F and apply another cross coat with a conventional spray gun
    - Allow 2 hours flash off at 23°C / 73°F followed by 24 to 48h at 50°C / 122°F
    - Prior to buffing, an additional curing at 50°C for several days can be necessary

**Recommended Application**      15 – 30°C (59°F – 86°F)  
**Conditions**                              30 – 80% RH

### Application Equipment

EQUIPMENT TYPE	TIP SIZE	MAX PRESSURE (Bars)
Conventional Air Spray	1,4 mm	4 Bars

### Film Thickness

Recommended wet film thickness: 75-100 microns (3–4 mils) per coat  
 Recommended dry film thickness: 40-60 microns (1,6–2,5 mils) per coat  
 Recommended total dry film thickness: 250-375 microns (10-15 mils)



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### Physical Characteristics

<b>Colour</b>	Transparent
<b>Gloss</b>	> 90 gu under 60° for glossy varnish
<b>Coverage</b>	Depends on thickness applied
<b>VOC Content (Ready for use)</b>	420g/L
<b>Flash Point</b>	Base            37°C Activator:      48°C
<b>Shelf Life</b>	24 months for base and activator from date of manufacture in original unopened container
<b>Storage Conditions</b>	The material should be stored at temperatures between 5°C to 35°C (40°F to 100°F) to ensure shelf life.

### Health & Safety

This product is safe to use and apply when recommended precautions are observed. Before using this product it is important to read and understand the Material Safety Data Sheet. This provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. Material Safety Data Sheets are available on request.

All recommendations, statements and technical data contained herein are based on tests we reasonably believe to be reliable and correct, but the accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express or implied. The User shall rely on its own information and tests to determine the suitability of any product for its intended use and the User agrees to assume all risks and liability arising in relation to its use of such product (other than death or injury resulting from our negligence) and accordingly we shall not assume any such risks or liability unless we specifically agree to the contrary in writing. If we specifically agree to assume any such risks or liability then (except for death or injury resulting from our negligence) our sole responsibility if any product supplied to the User by us is defective shall be to replace that portion of such product which is defective. Recommendations or statements other than those specifically agreed in writing by us shall not be legally binding on us.