



Technical Data

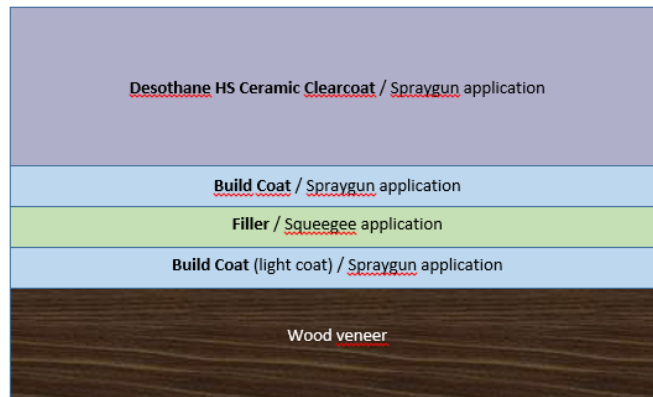
<u>Product name</u>	CA 8660 Desothane HS Filler & Build Coat
<u>Product Description</u>	Transparent fire retardant polyurethane Filler & Build Coat
<u>Key Features</u>	Desothane HS Filler & Build Coat is a two-component, low density product designed for applications on wood and veneer finished aircraft
<u>Specifications – Approvals</u>	FAR 25.853 Vertical Flammability Test - Fire Test to Aircraft Material
<u>Catalyst/Hardener/Activator</u>	8660B
<u>Pack Size</u>	Base 5 litres tin Activator 2.5 litres tin Thinner 2.5 litres tin
<u>Mix Ratio (by weight)</u>	8660 100 parts 8660B 60 parts 8660C 60 parts (for spray application / Build Coat)
<u>Recommended Scheme</u>	8660 is compatible with the CA 8400/B900 Desothane HS Ceramic Clearcoat

Product Application Parameters

Surface Preparation	Ensure surface is clean and free from any contaminants.
Mixing Instructions	Hands stir the base component to achieve homogeneous product. Add 60 parts of activator 8660B to 100 parts of base 8660 and ensure well mixed. Add 60 parts of 8660C thinner while stirring for spray application (Build Coat).
Viscosity	Not applicable
Induction Time	Not required
Pot Life	60 minutes at 23°C (73°F)
Application Method	<p>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.</p> <p>Prior to the transparent pore filler application, we recommend to sand the wood with 400 grade paper and clean with Isopropyl alcohol or acetone.</p> <p>The following application process is based on our experience and could be optimized according to individual requirements.</p>



Technical Data



Pore filler application process – squeegee application

- Prior to Filler application, apply 1 or 2 light coats of Build Coat (100/60/60 parts) using a spray gun and allow 3 to 24 hours drying at 23°C / 73°F
- Apply a 1st coat of Filler (100/60 parts) with a squeegee to force the product into the pores and remove excess.
- Allow 1 to 2 hours drying at 23°C / 73°F and apply a 2nd coat of Filler using a squeegee and remove excess.
- Allow 1 to 2 hours drying at 23°C / 73°F and apply a 3rd coat of Filler using a squeegee and remove excess.
- If necessary (especially on wenge veneer), apply 1 or 2 more coats of Filler.
- Drying time is minimum 3h and maximum 12h (without sanding) at 23°C / 73°F before Build Coat application. If drying is > 12h, a light sanding with Scotch-Brite® is required.

Build coat application process – spray application

- Apply a wet coat of Build Coat (100/60/60 parts) using a spray gun.
- Ensure that all pores are filled.
- Allow 3 hours drying at 23°C / 73°F followed by 12 to 48h at 50°C / 122°F
- Scuff the surface using a 240 or 320 grade paper with a vacuum sanding machine until a completely smooth surface is obtained.

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

Application Equipment

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

Equipment Cleaning CN20 or CN44

Dry Film Thickness Not applicable



Technical Data

Drying Time @ 23°C ± 1°C + 55% RH ± 5%

Touch Dry	3 hours
Full Cure	7 days

Physical Characteristics

Colour	Transparent
Gloss	Not applicable
Coverage	Not applicable
VOC Content (Ready for use)	150g/L without thinner 380g/L with thinner
Flash Point	Base: 29°C Activator: 47°C Thinner: 22°C
Shelf Life	24 months for base and activator from date of manufacture in original unopened container
Storage Conditions	

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.