

## **Product description**

DeSoto<sup>®</sup> 515X349 exterior primer is a conventional solids urethane compatible epoxy coating. This primer was formulated to protect aluminum substrates from corrosion.

- Compatible with Desothane<sup>™</sup> HS topcoats •
- Excellent adhesion to aluminum and composite surfaces •
- Can be applied with all current non-electrostatic spray equipment
- Improved Skydrol<sup>®</sup> resistance
- Can be applied in a wide range of conditions
- Difficult to remove with chemical strippers
- Service temperature -54°C to 177°C (-65°F to 350°F)

## Components

#### Mix ratio (by volume):

- 515X349 (base component)
- 1 part 1 part 910X533 (activator component)

## **Specifications**



515X349 primer is qualified to:

- BMS 10-79 Type III Class A Grade A
- DHMS C4.04 Type 6 Class B Grade A
- DHMS C4.18 Type III Class A Grade A
- DMS 2144 Composition A •
- MS37.14.03

- SMS 111204 Type I
- STM0791
- STMGK 189
- STM-P-K104
- VMS C4.18 Type III

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

#### **Product Compatibility:**

515X349 primer is compatible with the following topcoat specifications:

- AMS 3095 •
- A2MS 565-002 •
- A2MS 565-009
- BAMS 565-002
- BAMS 565-009
- BMS 10-60 Type II Class B Grade D
- BMS 10-72 Type VIII
- BMS 10-125 Type III Grade D
- BMS 10-126 Type I Grade D

- DHMS C4.04
- DMS 2143 •
- FEDEX STANDARD
- **GAMPS 3209**
- GP110AEE
- MEP 10-069
- MM1276 Type II
- MS100029E Class HS
- RMS 430 Type II

- CMFS037
- CMS-CT-101 Type I

- SMS-111207 Type 1
- VMS C4.04 Ty VI CI B Gr B

## Surface preparation and pretreatments



515X349 primer can be applied over materials conforming to MIL-DTL-5541, MIL-A-8625 or chromic acid anodized pretreatments. For further information, refer to the Technical Data Sheet for the above mentioned products.

## Instructions for use



#### **Mixing instructions:**

Prior to mixing, thoroughly shake the base component. Add activator to base component and stir well. Maintain constant agitation for 10 minutes to ensure proper mixing. Induction time is required based on temperature.

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	22 - 28°C	>29°C
	(55 - 70°F)	(71 - 84°F)	(>85°F)
Induction time required	30 minutes	30 minutes	30 minutes



Viscosity: (21 - 25°C / 70 - 77°F)

- #1 EZ Zahn cup
- #2 EZ Zahn cup
- #4 Ford cup

30 to 40 seconds 16 to 20 seconds 8 to 12 seconds

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



#### Pot life:

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 12.5 to 22.5 microns (0.5 to 0.9 mils). This can be accomplished with one medium coat with a 50% overlap

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:

9.5 square meters/liter at 25 microns dry film (375 square feet/gallon at 1 mil dry film) Recommended dry film thickness; 12.5 to 22.5 microns (0.5 to 0.9 mils)



#### Dry film weight:

45.0 grams/square meter at 25 microns dry film (0.0095 pounds/square feet at 1 mil dry film)



#### Equipment:

515X349 primer is compatible with all current non-electrostatic spray equipment.

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: Dark Green



Gloss:

Not Applicable



Dry Times	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Tack Free	45 minutes	30 minutes	20 minutes
Dry to Topcoat	3 - 72 hours	2 - 72 hours	1 ½ - 72 hours
Dry to Fly	72 hours	48 hours	36 hours
Full Cure	7 days	7 days	7 days

Accelerated cure:

Allow 15 minutes flash off at 24°C  $\pm$  3°C (75°F  $\pm$  10°F) followed by 30 minutes at 60°C (140°F)



#### VOC:

Mixed, ready for use VOC (EPA method 24)	650 grams/liter
Base Component	514 grams/liter
Activator Component	804 grams/liter



#### Flash point closed cup:

Base Component	-1°C (31°F)
Activator Component	7°C (45°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.

<u>Note:</u> 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.

# **DeSoto® 515X349 Exterior Primer**

#### 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:

## **Asia Pacific**

**ASC – Australia** Tel 61 (3) 9335 1557 Fax 61 (3) 9335 3490

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**ASC – Suzhou** Tel (86-512) 6661 5858 Fax (86-512) 6661 6868

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# Americas

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## **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

PRC-DeSoto International, Inc. 12780 San Fernando Road Sylmar, CA 91342 www.ppgaerospace.com

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