

P99 Wash Primer

Product Description

P99 is a two pack chromated wash primer designed for the protection of aircraft exteriors.

- Ambient curing wash primer
- Designed to provide high resistance to filiform corrosion
- Excellent adhesion to polyurethane primers
- Excellent adhesion to a variety of light alloys and steel

Components



Mix Ratio (by volume)

- | | |
|--------------------------------|--------------|
| • 7641/3600 (Base) | 1 part |
| • 0841/9000 (Reactive Thinner) | 1 part |
| • 0434/9000 (Thinner) | to viscosity |

Specifications



P99 is qualified to:

- AIMS 04-04-012
- AIMS 04-04-026
- AIMS 04-04-054
- AMS 3095
- MDL 5038

Product Compatibility

P99 is compatible with the following primer specifications:

- AIMS 04-04-001
- AIMS 04-04-002
- AIMS 04-04-038
- AIMS 04-04-012

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

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Surface Preparation and Pretreatment



P99 should **NOT** be applied over fresh (< 7 days) chromate conversion coatings. Ensure that the correct surface pre-treatment has been carried out. Ensure the surface is clean, dry and intact using a high performance solvent cleaner - Desoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Instructions for Use



Hand stir or mechanically shake the base material until all the components are uniformly dispersed. Add reactive thinner to base material and mix thoroughly. Add thinner to the recommended viscosity (typically 0.1 to 0.3 volume)

Note: All products and components should be placed in ambient conditions of 15 - 30°C (59 - 86°F) for at least 24 hours prior to mixing and application.



Induction Time:

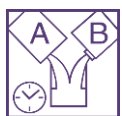
Not applicable



Viscosity: (21 - 25°C/70 - 77°F)

• AFNOR2.5	40 - 45 seconds
• AFNOR4	16 -18 seconds
• BSB3	26 - 32 seconds
• DIN4	13 - 15 seconds
• FORD4	15 - 17 seconds
• ISO3	52 - 67 seconds
• ISO4	15 - 25 seconds
• ZAHN2	20 - 21 seconds

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



Pot Life:

8 hours @ 21 - 25°C (70-77°F)

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Application Guidelines

Recommended Application Conditions:

Temperature 15 - 30°C (59 - 86°F)
Relative Humidity 30 - 75%

Application:

Apply 1 wet even coat to achieve a dry film thickness of 4 - 8 µm (0.16 - 0.32 mil)

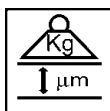


Theoretical Coverage: (unthinned)

15 m²/Lt @ 6 µm dry film thickness
600 ft²/US gal @ 0.24 mil dry film thickness

Recommended Dry Film Thickness:

4 - 8 µm
0.16 - 0.32 (mil)



Dry Film Density:

1.63 g/cm³
13.6 lbs/US gal

Dry Film Weight:

10 g/m² @ 6 µm dry film thickness
0.002 lbs/ft² @ 0.24 mil dry film thickness

Note: 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.

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Equipment:

P99 is compatible with most types of current spray equipment but is **NOT** suitable for application with electrostatic spray equipment. Careful attention should be paid when using the Graco Pro range of spray guns to ensure the electrostatic is switched off.



Equipment	Tip Size	Fluid Rate	Air Pressure
Airmix Kremlin	Ø = 0.28 mm - Angle 60° Ref:06.134	320 to 360 ml/min	725 to 870 psi (50 to 60 bar)
HVLP	1.2 mm		22 to 29 psi (1.5 to 2 bar)
Conventional	1.5 mm		43 to 58 psi (3 to 4 bar)
Airless	NOT RECOMMENDED		
Airless, Air-assisted	609 to 611	approx. 360 to 400 ml/min	58 to 73 psi (4 to 5 bar)
PRO3500 or PROXS4	1.2 or 1.5mm	approx. 360 to 400 ml/min	72 to 87 psi (5 to 6 bar)

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44 or Desoclean™ 45 solvent cleaner are recommended.

Physical Properties



Colour:

Yellow



Gloss:

Not applicable



DRYING TIMES	23°C(73°F) @ 50% RH
Dust Free	20 minutes
Dry to Tape	90 minutes
Dry to Sand	90 minutes
Dry to Overcoat	1 to 24 hours
Full Cure	7 days

Force Dry:

Not applicable

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

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VOC: (ASTM)

Mixed ready for use (unthinned)	755 g/Lt
7641/3600 Base Component	690 g/Lt
0841/9000 Reactive Thinner	820 g/Lt
0434/9000 Thinner	880 g/Lt



Flash Point:

7641/3600 Base Component	13°C (54°F)
0841/9000 Reactive Thinner	13°C (54°F)
0434/9000 Thinner	18°C (64°F)

Shelf Life:

7641/3600 Base Component	24 months in original unopened container
0841/9000 Reactive Thinner	24 months in original unopened container
0434/9000 Thinner	10 years in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

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.

Note: When procuring to a qualified material specification, follow those storage instructions.

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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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