

4125 Direct Adhesion Epoxy Coating

TECHNICAL DATA SHEET

Product Description

4125 epoxy coating is designed for the protection of fasteners used in aircraft assemblies including all types of rivets, nuts, fasteners or aluminium alloys.

- Two pack, direct adhesion epoxy topcoat
- Applicable with all types of fasteners
- Excellent adhesion properties
-

Components



Mix Ratio (by volume)

- | | |
|-------------------------|--------------|
| • 4125 (Base) | 2 parts |
| • 0613/9000 (Activator) | 1 part |
| • 0580/9000 (Thinner) | to viscosity |

Specifications



4125 is qualified to:

- 75-T-2-5721-3-1
- HMRC 0069

4125 meets the performance requirements of:

- | | |
|------------------|-----------------|
| • AIMS 04-04-009 | • ASN-B-707205P |
| • AIMS 04-04-010 | • BLGG 120001 |
| • AIMS 04-04-043 | • DAN 1174 |

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

Surface Preparation and Pretreatment



Ensure surface is clean, dry and intact using a high performance solvent cleaner, DeSoto® CN20 or Desoclean™ 45 solvent cleaner are recommended. Abrade the surface using Scotch-Brite® pad and degrease with MEK before application.

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Instructions for Use



Base component may require mechanical agitation. Ensure all components are adequately dispersed. Add activator to base component and stir well, adjust to recommended viscosity by addition of thinner while stirring.

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:

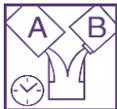
Not required



Viscosity: (23°C/73°F)

• AFNOR2.5	53 - 64 seconds
• AFNOR4	16 - 18 seconds
• BSB3	29 - 33 seconds
• BSB4	16 - 19 seconds
• FORD4	14 - 16 seconds
• ISO3	48 - 63 seconds
• ISO4	21 - 29 seconds
• ZAHN2	19 - 21 seconds

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



Pot Life:

8 hours @ 21 - 25°C (70 - 77°F) with 1 volume of thinner.

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

Application:

Apply 1 - 2 even cross coats to achieve recommended dry film thickness.



Theoretical Coverage: (ready for use unthinned)

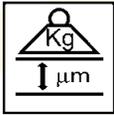
14 m²/Lt @ 30 µm dry film thickness

560 ft²/US gal @ 1.2 mil dry film thickness

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Recommended Dry Film Thickness:

20 - 40 μm
 0.8 - 1.6 mil



Dry Film Density:

1.6 g/cm^3
 13 lbs/Usgal

Dry Film Weight:

48 g/m^2 @ 30 μm dry film thickness
 0.009 lbs/ft² @ 1.2 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.

Equipment:



Equipment Type	Tip Size (mm)	Pressure
HVLP Air Spray	1.2	35 to 36 psi (1.5 to 2 bar)
Conventional Air Spray	1.5	37 to 39 psi (3 to 4 bar)

Equipment Cleaning:

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

Physical Properties



Colour:

Grey M09001 (4125/2047)
 Light Blue (4125/6407)
 Green (4125/5171)



Gloss:

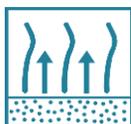
Semi Gloss: 20 - 45 units with a 60° gloss meter

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Drying Times 50% R.H	23°C (73°F)	70°C (158°F)
Dry to Touch	30 minutes	
Dry to Handle	2 hours	
Dry to Tape	3 hours	
Dry to Overcoat	0.5 hours (min.) 72 hours (max.)	
Full Cure	7 days	3 hours

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



Flash Off:

15 minutes before force dry



VOC: (ASTM)

Mixed ready for use	475-575 g/Lt
4125 Base Component	380 g/Lt
0613/9000 Activator	675 g/Lt
0580/9000 Thinner	870 g/Lt



Flash Point:

4125 Base Component	<21°C (70°F)
0613/9000 Activator	<21°C (70°F)
0580/9000 Thinner	<21°C (70°F)

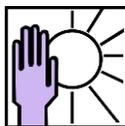
Shelf Life:

4125 Base Component	24 months in original unopened container
0613/9000 Activator	24 months in original unopened container
0580/9000 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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