

4123 Epoxy Primer 7835

TECHNICAL DATA SHEET

Product Description

4123/.... is a two component chromated epoxy primer, used for external of aircraft structures.

- Anti corrosive primer
- Corrosion resistant
- Flexible
- Excellent resistance to oil esters, grease, kerosene, hydraulic fluids
- Heat resistant to temperatures up to 130 °C (266 °F)

Components



Mix Ratio (by volume)

- | | |
|-------------------------|---|
| • 4123/.... (Base) | 1 part |
| • 0628/9001 (Activator) | 1 part |
| • 0469/9000 (Thinner) | to viscosity (see viscosity section of this document) |

Specifications



4123 is qualified to:

- DHS 186-111

4123 meets the technical requirements of:

- MIL-P-23377

Product Compatibility

4123 is compatible with the following topcoat specifications:

- | | |
|------------------|------------------|
| • AIMS 04-04-003 | • ECS 2139-20 |
| • AIMS 04-04-012 | • ECS-L-12261 |
| • ASNA 4247 | • NORMDEF 0003-1 |
| • BLGG 140301 | |

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

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Surface Preparation and Pretreatment



Ensure surface to be painted is clean, dry and intact using a high performance solvent cleaner DeSoto® CN20 or Desoclean™ 45 solvent cleaners are recommended.

Instructions for Use



Ensure all mixing / measuring containers are free from contaminants. Shake or stir the base to ensure all components are adequately dispersed. Slowly add activator to base while stirring. Add required thinner to viscosity.

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)

• AFNOR 2.5	45 - 55 seconds
• AFNOR4	15 - 16 seconds
• BSB3	26 - 29 seconds
• BSB4	15 - 17 seconds
• FORD4	12 - 14 seconds
• ISO3	37 - 49 seconds
• ISO4	18 - 21 seconds
• ZAHN2	16 - 19 seconds

Note: Viscosities quoted are 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	30 - 80%

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Application:

Apply 1 cross coat to achieve the recommended dry film thickness.

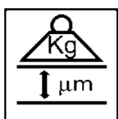


Theoretical Coverage: (ready for use)

12 m²/Lt @ 25 µm dry film thickness
480 ft²/US gal @ 1 mil dry film thickness

Recommended Dry Film Thickness:

20 - 25 µm
0.8 - 1 mil



Dry Film Density:

2.0 g/cm³
16.6 lbs/US gal

Dry Film Weight:

48 g/m² @ 25 µm dry film thickness
0.009 lbs/ft² @ 1 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: 4123 is compatible with all current forms of spray equipment



Equipment Type	Tip Size	Pressure
Conventional Airspray	15/10 mm	43 to 72 psi (3 to 5 bar)
Airless	0.33 mm (angle 67 or 80°)	1450 to 1885 psi) (100 to 130 bar)

Equipment Cleaning:

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

Physical Properties



Colour:

Green-Blue-Grey (4123/5045)
Yellow-Green (4123/3600)

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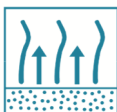
Gloss:

Matt < 5 units with a 60° gloss meter



Drying Times @ 50 % R.H.	23°C (73°F)	60°C (140°F)	80°C(176°F)	120°C(248°F)
Dry to Touch	15 to 30 minutes			
Dry to Handle	1 to 1.5 hours			
Dry to Overcoat	4 hours (min.) 72 hours (max.)	20 minutes		
Dry to Tape	2 to 3 hours			
Full Cure	7 days		1 hour	15 minutes

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



Flash Off:

30 minutes prior to overcoating or force drying

VOC

VOC: (ASTM)

Mixed ready for use (unthinned)	600 g/Lt
4123 Base	460 g/Lt
0628/9001 Activator	750 g/Lt
0469/9000 Thinner	850 g/Lt



Flash Point:

4123 Base	15°C (59°F)
0628/9001 Activator	14°C (57°F)
0469/9000 Thinner	24°C (75°F)

Shelf Life:

4123 Base	24 months in original unopened container
0628/9001 Activator	24 months in original unopened container
0469/9000 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.



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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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