

DeSoto® 825X309 Integral Fuel Tank Coating

Product description

DeSoto® 825X309 Integral Fuel Tank Coating is used to protect the interior of an aircraft's fuel tank against corrosion from fuel contaminants. 825X309 is a chemically-cured coating which provides maximum protection against water, salt water, aircraft fuels, hydraulic fluids, engine oils, and dilute acid solutions.

- Excellent adhesion to aluminum
- Compatible with fuel tank sealants
- Exceptional fluid resistance
- Superior durability
- Compatible with all current non-electrostatic spray equipment
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components



Mix ratio (by volume):

- 825X309 (base component) 4 parts
- 910-702 (activator component) 1 part
- 020-707 (thinner component) 4 parts

Specifications



825X309 integral fuel tank coating is qualified to:

- 207-9-440
- AMS-C-27725 Type 2 Grades 1 & 2
- GAMPS 3102
- GC130AS
- MS-133
- STO 125 LB 006

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

Product compatibility:

825X309 is compatible with the following sealant specifications:

- 207-6-466
- ACS-MRS-7006
- AMS 3265
- AMS 3276
- AMS 3277
- AMS 3281
- AMS-S-8802
- HMS 16-1097
- FMS 1044
- FMS 3064
- DMS 2082
- GMS 4115
- MS-402
- MMS332

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Surface preparation and pretreatments



DeSoto® 825X309 Integral Fuel Tank coatings can be applied over clean, dry, intact aluminum surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

Instructions for use



Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add the activator component to the base component and stir well, and add the thinner component while stirring. Maintain constant agitation for 10 minutes to ensure proper mixing. Induction time is required.

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°C to 35°C (55°F to 95°F). The minimum temperature of the paint components should be 13°C (55°F) prior to mixing.



Induction time:

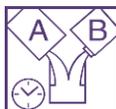
Temperature	13-21°C (55-70°F)	22-28°C (71-84°F)	>29°C (>85°F)
Induction Time Required	45 minutes	30 minutes	15 minutes



Viscosity: (23°C/73°F)

- #2 Signature Zahn cup 15 to 26 seconds
- #4 Ford cup 10 to 20 seconds
- ISO 4mm cup 16 to 40 seconds
- AFNOR #4 cup 14 to 22 seconds

Note: Viscosities quoted are the 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	10-90%

Application:

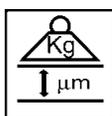
Ground the aircraft and the application equipment before priming. Stir the coating slowly during the application. The suggested film thickness is 20 to 30 microns (0.8 to 1.2 mils). This can be accomplished with one medium coat with a 50% overlap

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:

11 square meters/liter at 25 microns dry film (433 square feet/gallon at 1 mil dry film)
Recommended dry film thickness; 20 to 30 microns (0.8 to 1.2 mils)



Dry film density:

1.68 grams/cubic centimeter (14 pounds/gallon)

Dry film weight:

42 grams/square meter at 25 microns dry film (0.00863 pounds/square feet at 1 mil dry film)



Equipment:

825X309 is compatible with all current forms of 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.

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Physical properties (product)



Color: Green



Gloss: Not Applicable



Dry Times at 10-90% R.H.	13-21°C (55-70°F)	22-28°C (71-84°F)	>29°C (>85°F)
Tack Free	2-3 hours	½-1 ½ hours	¼-1 ¼ hours
Dry Hard	3-4 hours	2-3 hours	2-3 hours
Full Cure	7 days	7 days	7 days

Accelerated cure at minimum 10-50% R.H. at 60°C (140°F):

Dry hard

Flash off for 2 hours, then force cure for 3-4 hours

Full cure

Flash off for 2 hours, then force cure for 24-36 hours

VOC

VOC:

Mixed, ready for use VOC (EPA method 24)	650 grams/liter
Base Component	500 grams/liter
Activator Component	118 grams/liter
Thinner Component	832 grams/liter



Flash point closed cup:

Base Component	2°C (36°F)
Activator Component	-6°C (22°F)
Thinner Component	-1°C (31°F)

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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.

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.

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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ASC – Australia
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