PPG Aerospace
PRC-DeSoto

Super Koropon® 515K011 Fluid Resistant Interior Primer

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TECHNICAL DATA SHEET

Product Description

Super Koropon® 515K011 fluid resistant interior primer is a conventional solids, lead and cadmium free epoxy coating. 515K011 high performance primer is formulated to protect the interior of aircraft from corrosion.

- Easy to spray
- Compatible with epoxy and urethane interior topcoats
- Excellent adhesion to all aluminum and composite surfaces
- Excellent Skydrol® resistance
- Compatible with all current non-electrostatic spray equipment
- Can be applied in a wide range of conditions
- Service temperature -54°C to 177°C (-65°F to 350°F)

Components

Mix ratio (by volume):

- 515K011 (base component) — 1 part
- 910-012 (activator component) — 1 part

Specifications

515K011 primer is qualified to:

- 207-9-436 Class C
- 3M 11-0018
- A8B91-S
- BAMS 565-001 Grade A Category 1 Type 1
- BMS 10-11 Type I Class A
- Grade A
- LES 1091
- MEP 10-059
- MS100013E
- RMS 118 Type I Class G

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

Product Compatibility:

515K011 primer is compatible with the following interior topcoat specifications:

- BAMS 565-002
- BMS 10-11 Type II
- BMS 10-60 Type I
- DMS 2143
- DPM 5391

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Surface Preparation and Pretreatments

Super Koropon® 515K011 primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-C-5541 or equivalent.

Instructions for Use

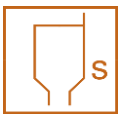
Mixing Instructions:

Prior to mixing, thoroughly shake the base component. Add activator to base component and stir well, 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° 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:

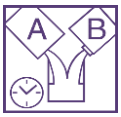
Temperature	13 - 21°C (55 - 70°F)	22 - 28°C (71 - 84°F)	>29°C (>85°F)
Induction Time Required	45 minutes	30 minutes	15 minutes



Viscosity: (23°C/73°F)

• #1 Signature Zahn cup	26 to 35 seconds
• #2 Signature Zahn cup	16 seconds maximum
• #4 Ford cup	12 seconds maximum
• ISO 3mm cup	37 seconds maximum
• ISO 4mm cup	18 seconds maximum
• BSB3 cup	26 seconds maximum
• BSB4 cup	15 seconds maximum
• AFNOR #2.5 cup	45 seconds maximum
• AFNOR #4 cup	15 seconds maximum

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



Pot Life:

16 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	20 - 90%

Application:

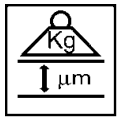
Ground the aircraft and the application equipment before priming. Stir the primer slowly during the application. The suggested film thickness is 12.5 to 22.5 microns (0.5 to 0.9 mils). This can be accomplished with one medium coat with a 50% overlap.

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:

8.9 square meters/liter at 25 microns dry film (362 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 Density:

1.84 grams/cubic centimeter (15.33 pounds/gallon)

Dry Film Weight:

46 grams/square meter at 25 microns dry film (0.00942 pounds/square feet at 1 mil dry film)

Equipment:

515K011 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.

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Physical Properties (product)

Color: 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	15 minutes
Dry to Stack	1 hour	45 minutes	30 minutes
Dry to Tape	2 ½ hours	2 hours	1 ½ hours
Dry Through	5 hours	4 hours	3 hours
Dry to Topcoat	1 - 24 hours	1 - 24 hours	1 - 24 hours
Dry to Fly	60 hours	48 hours	40 hours
Full Cure	7 days	7 days	7 days

Accelerated cure:

Allow 15 minutes flash off at 24°C ± 3°C (75°F ± 10°F)
followed by 40 - 45 minutes at 49°C (120°F)

VOC:

Mixed, ready to use VOC (EPA method 24)	650 grams/liter
Base Component	509 grams/liter
Activator Component	792 grams/liter

Flash point closed cup:

Base Component	16°C (60°F)
Activator Component	-6°C (22°F)

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Shelf Life:

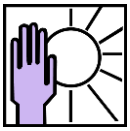
12 months from date of manufacture to most OEM material specifications. Consult the specification to verify shelf life requirements.

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.

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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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