

# 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.

# 4125 Direct Adhesion Epoxy Coating

## 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.*



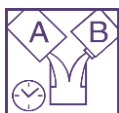
### **Induction Time:**

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.



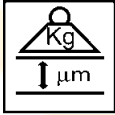
### **Theoretical Coverage:** (ready for use unthinned)

14 m²/Lt @ 30 µm dry film thickness  
 560 ft²/US gal @ 1.2 mil dry film thickness

# 4125 Direct Adhesion Epoxy Coating

## Recommended Dry Film Thickness:

20 - 40 µm  
 0.8 - 1.6 mil



## Dry Film Density:

1.6 g/cm³  
 13 lbs/Usgal

## Dry Film Weight:

48 g/m² @ 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:

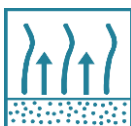
Semi Gloss: 20 - 45 units with a 60° gloss meter

## 4125 Direct Adhesion Epoxy Coating



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)

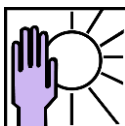
### Shelf Life:

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.*

# 4125 Direct Adhesion Epoxy Coating

## 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](http://www.ppgaerospace.com)**

**For sales and ordering information call the local PPG office at the numbers listed below:**

### **Asia Pacific**

#### **ASC – Australia**

Tel 61 (3) 9335 1557  
Fax 61 (3) 9335 3490

#### **ASC – Japan**

Tel 81 561 35 5200  
Fax 81 561 35 5201

#### **ASC – South East Asia**

Tel 65 6861 1119  
Fax 65 6861 6162

#### **ASC – Suzhou**

Tel (86-512) 6661 5858  
Fax (86-512) 6661 6868

#### **ASC – Tianjin**

Tel (86-022) 2482 8625  
Fax (86-022) 2482 8600

### **Europe and Middle East**

#### **ASC – Central Europe**

Tel 49 (40) 742 193 10  
Fax 49 (40) 742 139 69

#### **ASC – Middle East & India**

Tel (971) 4 883 9666  
Fax (971) 4 883 9665

#### **ASC – North Europe**

Tel 44 (0) 1388 770222  
Fax 44 (0) 1388 770288

#### **ASC – South Europe**

Tel 33 (0) 235 53 43 71  
Fax 33 (0) 235 53 54 44

### **Americas**

1 (818) 362-6711 or 1-800-AEROMIX

**Desoclean and DeSoto are trademarks of PRC-DeSoto International, Inc.  
Scotch-Brite is a trademark of 3M**

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller.

PPG Aerospace  
Sealants and Coatings  
Darlington Road  
Shildon, Co Durham UK  
DL4 2QP  
[www.ppgaerospace.com](http://www.ppgaerospace.com)  
Issue Date: 03/16  
Lit: 4208