

Simco Coatings Inc.

Manufacturer of Military Spec.,
Corps of Engrs. Spec, Industrial, &
Marine Coatings

TECHNICAL DATA SHEET

MILGUARD-23377 EPOXY-POLYAMIDE PRIMER

DESCRIPTION: Milguard-23377 is a two component, high solids, VOC compliant epoxy polyamide primer with excellent chemical, solvent and corrosion resistance suitable to be used on Aluminum, Steel and Galvanized Substrates.

CONFORMANCE: This product conforms to MIL-PRF-23377 Revision K (the latest revision). Both Type I & II, and Class C2 & Class N, in Yellow or Green are available. This data sheet can be used for certain previous revisions of MIL-PRF-23377 & MIL-P-23377. Contact us for details.

Class-C2: Strontium Chromate Based Corrosion-Inhibitors

Class-N: Non-Chromate Based Corrosion-Inhibitors

Type I: Standard Pigments

Type II: Low infrared reflective pigments

TECHNICAL DATA

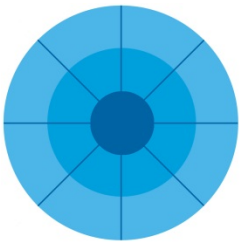
GENERIC TYPE:	Epoxy Resin and Polyamide Curing Agents
COLOR:	Yellow or Dark Green
FINISH:	Semi-Gloss
VOLATILE ORGANIC COMPOUNDS: (MIXED VOC)	2.8 Lbs./Gallon or 340 g/l
MIX RATIO:	3:1 by Volume
SOLIDS BY VOLUME:	60 % (Mixed)
THEORETICAL SPREADING RATE:	Approx. 1,200 sq. ft/gal. @ 1.0 Mil DFT
RECOMMENDED DRY FILM THICKNESS (DFT):	1.0 -1.5 Mils (25 – 38 Microns)
POT LIFE @ 77 ° F, 50% RH:	4 Hrs.
SHELF LIFE:	12 Months
FLASH POINT:	102°F
REDUCER/CLEAN UP:	Epoxy Thinner MIL-T-81772, Type-II
DRY TIME @ 77 °F:	
TACK FREE:	5 Hrs.
DRY HARD:	8 Hrs.
MINIMUM RECOAT:	12 Hrs.
MAXIMUM RECOAT:	3 Days

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SURFACE PREPARATION: Surface must be clean, dry, and in sound condition. Remove all oil, dust grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

IRON & STEEL SUBSTRATES: Remove all oil and grease from surface by solvent cleaning per SSPC-SPI. Minimum surface preparation is commercial blast cleaning per SSPC-SP6. For better performance, use near White Metal Blast Cleaning Per SSPC-SP10. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Remove all weld spatter and all round sharp edges by grinding to a minimum ¼" radius. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

ALUMINUM SUBSTRATES: Remove all oil, grease dirt, oxide and other foreign material by solvent cleaning per SSPC-SP1.

APPLICATION CONDITIONS:

Temperature: 50°F Minimum, 100°F Maximum (Air, Surface and Material)
At least 5 ° F above dew point
Relative Humidity: 65% maximum

MIXING & INDUCTION TIME REQUIREMENT:

Using the proportion of 3: 1 of Component A to Component B, do the following: Agitate Component A by itself with a hand spatula, and then slowly pour in Component B (Hardener/Activator) and mix till mixture is smooth and uniform. At a temperature range of 70°F – 80°F, let mixture stand for 15 - 25 minutes after mixing both components and before application. Colder temperatures will require a longer induction time.

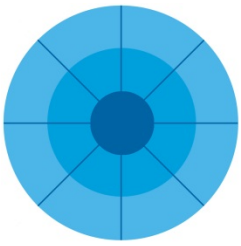
APPLICATION EQUIPMENT:

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer/Clean Up.....MIL-P-81772, Type-II

Airless Spray

Unit.....30: 1 Pump
Pressure.....2400-2800 psi
Hose.....1/4" ID
Tip......009"-.015"
Filter.....60 Mesh



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APPLICATION EQUIPMENT (CONTINUED):

Reduction.....Not recommended

CONVENTIONAL SPRAY

Gun.....DeVilbiss MBC510

Fluid Tip.....FF

Air Cap.....797

Atomization Pressure.....50-60 psi

Fluid Pressure.....10-15 psi

Reduction.....Not recommended

APPLICATION PROCEDURES:

Mix contents of both Part A & B thoroughly with power agitation. Make certain no pigment remains on the bottom of the can. Then combine three parts by volume of Part-A with one part by volume of Part-B. Thoroughly agitate the mixture with power agitation.

PERFORMANCE TIPS:

Stripe coats all crevices, welds and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, over thinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not apply the material beyond recommended pot life

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Epoxy Thinner MIL-T-81772, Type-II

SAFETY PRECAUTIONS:

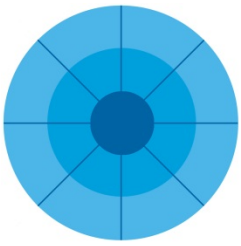
(A) Use normal precautions such as gloves, facemasks. (B) Adequate ventilation must be maintained. (C) Explosion proof lights and electrical equipment. (D) Non-sparking shoes and tools for workers in the area. (E) This product contains flammable materials. Forbid all flames, smoking and welding in the work area. (F) Avoid breathing of vapor, contact with skin and eyes.

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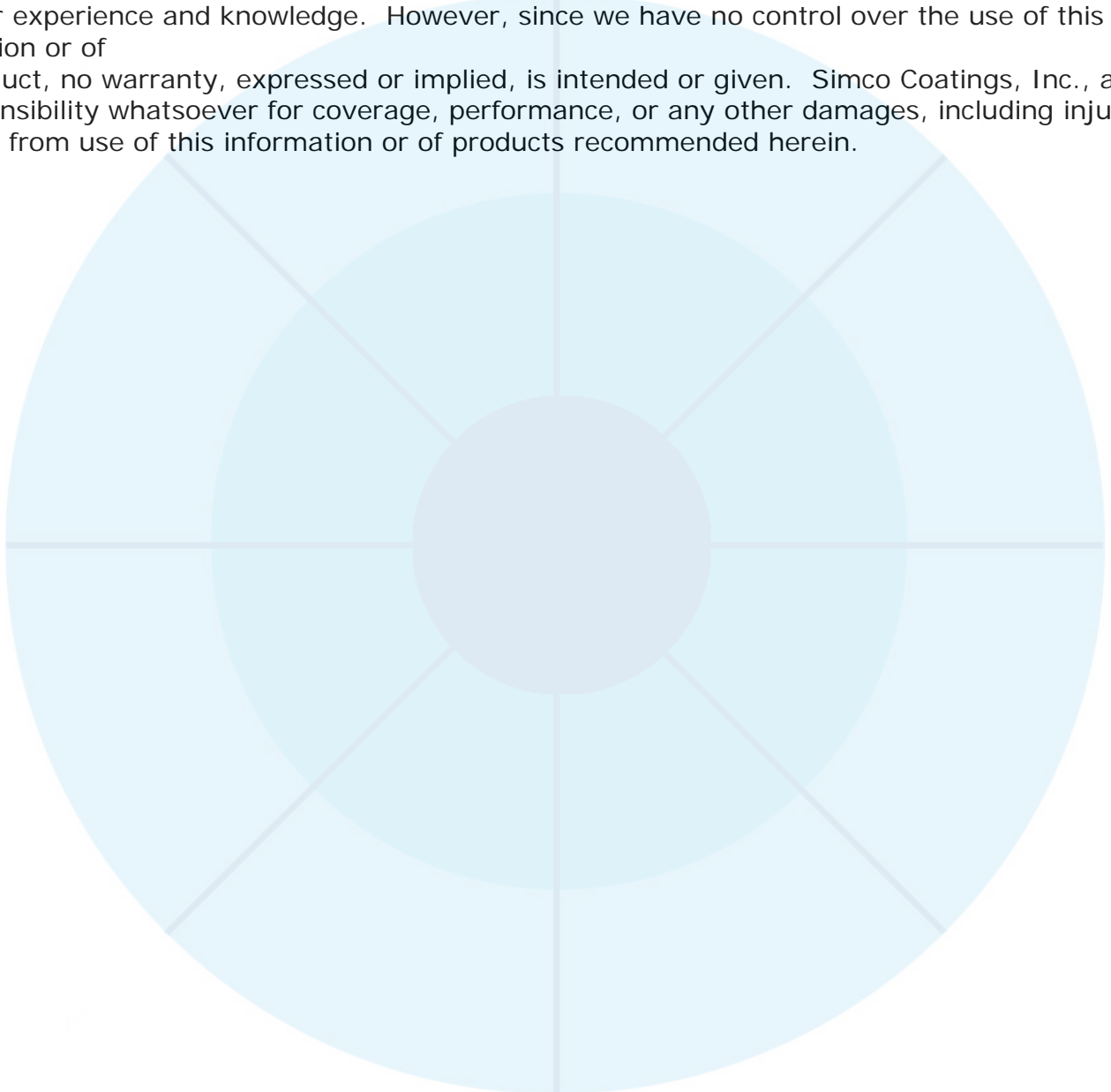
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NON-WARRANTY:

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