



Simco Coatings Inc.

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

**MIL-PRF-4556**  
**EPOXY COATING KIT FOR INTERIOR OF STEEL FUEL TANKS**

**DESCRIPTION:** This epoxy coating consists of a two-component epoxy light yellow primer and a two component white topcoat specifically formulated to use on the interior surfaces of steel tanks used for transportation and storage of military fuel and oils without contributing to contamination of the cargo. The coating, furnished as a kit, is lead and chromate free having a maximum VOC of not more than 2.80 lbs/ gal. (340 g/l) at application.

**CONFORMANCE:** This product conforms to MIL-PRF-4556 Revision F (the latest revision).

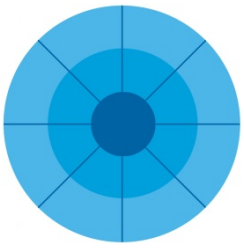
**TECHNICAL DATA**

<b>COLOR &amp; FINISH:</b>	Primer-Light Yellow Topcoat-White Low to medium sheen
<b>GENERIC TYPE:</b>	Epoxy Resin and Polyamide Curing Agents
<b>SOLVENTS TYPE:</b>	Aliphatic Aromatic Hydrocarbons Alcohols/Ketones
<b>FLASH POINT MINIMUM:</b>	95 °F (35 °F)
<b>% SOLIDS BY VOLUME:</b>	58 ± 1
<b>POT LIFE:</b>	4 hrs. Min. @ 75 °F
<b>RECOMMENDED DRY FILM THICKNESS (DFT)COAT:</b>	3.0-4.0 MILS (75-100 Microns)
<b>COVERAGE (THEORETICAL):</b>	
<b>@ 1.0 MIL (25 MICRONS):</b>	Approx. 890 Sq. Ft./Gallon
<b>@ 4.0 MILS (100 MICRONS):</b>	Approx. 222 Sq. Ft./Gallon The actual coverage will be less depending upon method of application and substrate surface
<b>REDUCER/CLEAN UP:</b>	T-81772, Type II Epoxy Thinner
<b>DRY TIME @ 75 °F:</b>	
<b>A. SET TO TOUCH:</b>	5 Hrs.
<b>B. DRY HARD:</b>	18 Hrs.
<b>C. TO TOPCOAT:</b>	24 Hrs.
<b>VOLATILE ORGANIC CONTENT (VOC):</b>	2.80 lbs./gallon or 340 g/l

**PACKAGE:**

A two component material with base and curing agent supplied in separate packages. Mix ratio of Base to curing agent is 4:1 by volume

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## **MIL-PRF-4556** **EPOXY COATING KIT FOR INTERIOR OF STEEL FUEL TANKS**

### **MIXING & INDUCTION TIME REQUIREMENT:**

Using the proportion of 4:1 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 20 - 30 minutes after mixing both components and before application. Colder temperatures will require a longer induction time.

### **SURFACE PREPARATIONS:**

All surfaces to be coated must be dry and cleaned free of rust, oil, dirt, soil and other contaminants. For general use steel should be blast cleaned to a minimum of commercial grade SSPC SP-6". For severe service and sustained immersion, "Near White" SSPC SP-10 is recommended. For best results apply when surface temperature is above 50°F (10°C) and a minimum of 5°F (3°C) above the dew point, and relative humidity is no greater than 85%.

### **APPLICATION:**

Spray recommended. Brush or roller may be used with additional thinning required. Care should be taken to achieve required film build.

### **CONVENTIONAL SPRAY:**

DeVilbiss MBC-510 spray gun "E" Fluid Tip #704, #765 or #78 Air Cap.

### **AIRLESS SPRAY:**

Use of spray tips with 0.015" to 0.021" orifice is suggested depending on available pressure and job conditions, with a minimum of 2800 PSI tip pressure.

### **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.

### **NON-WARRANTY:**

The technical data listed herein has been compiled for your convenience and guidance, and is based upon our experience and knowledge. However, since we have no control over the use of this information or of this product, no warranty, expressed or implied, is intended or given. Simco Coatings, Inc., assumes no responsibility whatsoever for coverage, performance, or any other damages, including injuries resulting from use of this information or of products recommended herein.

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