



Simco Coatings Inc.

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

TECHNICAL DATA SHEET

MIL-DTL-24441 (REVISION D)
FORMULA 151 THROUGH 158, TYPE-III
EPOXY-POLYAMIDE TOPCOAT

1. MIL-DTL-24441/21B Formula 151, Haze Gray,
2. MIL-DTL-24441/22B Formula 152, White
3. MIL-DTL-24441/23B Formula 153, Dark Gray RO 1.8
4. MIL-DTL-24441/24B Formula 154, Dark Gray RO 3.6
5. MIL-DTL-24441/25B Formula 155, Dark Gray RO 6
6. MIL-DTL-24441/26B Formula 156, Red
7. MIL-DTL-24441/27B Formula 157, Gray No. 50
8. MIL-DTL-24441/28B Formula 158, Yellow

DESCRIPTION/CONFORMANCE: These are two-part Epoxy-Polyamide, VOC Compliant Coatings specifically formulated for painting particular areas aboard ships such as bridges, exterior under water hull. These coatings are also suitable to be used as topcoats for exterior and interior application on aircrafts and ground support system. These paints conform to Federal Specification MIL-DTL-24441 Type III (Revision D) for the Formulas shown above.

PRINCIPAL CHARACTERISTICS:

- Can be applied up to 5.0 Mils DFT.
- Excellent resistance to weather, moisture, petroleum products and mild chemicals.
- Good impact resistance

TECHNICAL DATA

COLOR AND FINISH:	As per Formula No., Satin to Semi-Gloss Finish
MASS DENSITY:	11.0 ± 0.5 lbs./gal.
SOLIDS BY VOLUME:	Approx. 63 ± 2%
VOC (BEFORE THINNING):	2.80 lbs./gallon, 340 g/l
THEORETICAL SPREADING RATE:	
@ 1 MIL DFT:	Approx 1,000 sq. ft. /gal.
RECOMMENDED DRY FILM THICKNESS:	3-4 Mils (75-100 Microns)
TOUCH DRY (25 °C/77°F):	2-3 Hrs.
DRY HARD (25 °C/77°F):	6-8 Hrs.
MIN. INTERVAL BEFORE OVERCOATING(77°F):	8 Hrs. at 3-4 Mils DFT
MAX. INTERVAL BEFORE OVERCOATING:	7 Days
FULL CURE AFTER:	7 Days
TEMPERATURE RESISTANCE (DRY):	250°F (121°C)
SHELF LIFE (COOL & DRY PLACE):	Subject to re inspection after 12 months.

Simco Coatings Inc.
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FLASH POINT (TCC):

Base 96°F (36°C)
Hardener 108°F (42°C)

PACKAGING: A two-component material with base and curing agent supplied in 1 and 5-gallon containers (2-Gallon Kit & 10-Gallon Kit.). Mix ratio is 1 to 1 (equal volumes).

**RECOMMENDED SUBSTRATE
CONDITIONS:**

Steel: Properly Primed substrate with Zinc Rich Epoxy or Epoxy Polyamide Green Primer, Formula-150. The surface must be perfectly dry.

MIXING & INDUCTION TIME REQUIREMENT:

During application and the first 24 hours of curing, the substrate temperature must be above 41°F (5°C) and at least 5°F (3°C) above the dew point. The temperature of the mixture of base and hardener during mixing and application should be above 59 °F (15°C), otherwise more solvents must be used to obtain application viscosity. This results in lower sag resistance and slower cure. If thinner is used (Only Use MIL-T-81772 Type II Epoxy Thinner), it should only be added after mixing the components. Using the proportion of 1:1 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 - 20 minutes after mixing both components and before application. Colder temperatures will require a longer induction time.

POTLIFE:

4 Hours At 73°F

CONVENTIONAL SPRAY

Manufacturer:

DeVilbiss Binks

Gun Model:

MBC or JGA #18 or #62

Tip-Air Cap Combination:

704E 66PE

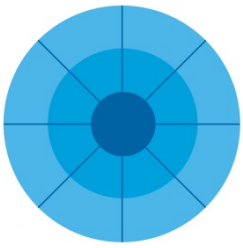
Fluid hose should be 3/8" I.D. with a maximum length of 50 feet. Pot should always have dual regulation and be kept at same elevation as spray gun.

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AIRLESS SPRAY

Manufacturer:

Gun Model:

Pump:

Graco

205-590

Bulldog

Binks

Model 500

Mercury 5C

DeVilbiss

JGN-501

QFA-519

Hose should be 3/8" I.D. minimum, but 1/4" whip end section may be used for ease of application. A maximum length of 100 feet is suggested. Best results will be obtained using a .018"-.021" tip at 2400-2700 p.s.i.

THINNING REQUIREMENT:

Recommended Thinner:	T-81772 Type II Epoxy Thinner
Airless Spray:	0-10% by Volume
Conventional Spray:	5-15%% by Volume
Roller And Brush:	0-5% by Volume
Clean-up Thinner:	T-81772 Type II Epoxy Thinner

CAUTION:

Contains flammable solvents. Keep away from sparks and open flames. Use only grounded explosion proof equipment in accordance with the National Electric Code. Workmen must use nonferrous tools, wear non-conductive and non-sparking shoes in areas where explosion hazards exists.

In confined areas, workmen must wear fresh airline respirators, protective clothing and gloves. Avoid contact with skin, breathing of vapor or spray mist ingestion. Keep out of reach of children.

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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