

MIL-PRF-23377H Type 1, Class C POLYAMIDE EPOXY PRIMER- AIRCRAFT

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TECHNICAL DATA SHEET	
DESCRIPTION:	
<p>MIL-PRF-23377H is a two component, corrosion inhibiting, polyamide primer. This epoxy primer offers excellent corrosion and chemical resistance over properly prepared aluminum and steel substrates. This primer meets Type 1 (standard pigments), Class C (strontium chromate) and was designed to be topcoated with urethane or epoxy topcoats such as MIL-C-83286B, MIL-C-85285C or MIL-C-22750D or MIL-C-46168.</p>	
PROPERTIES:	ADVANTAGES:
<p>COLOR Chromate Yellow</p> <p>SOLIDS by volume 48%-50%</p> <p>SOLIDS by weight 58%-60%</p> <p>Mix Ratio 1-1 by volume with part "B" catalyst</p> <p style="padding-left: 40px;">Let stand (30 minute induction period)</p> <p>Dry Film Thickness .6-.9 mil. Dry</p> <p>Dry Times @77 °F Tack Free 5hrs * Dry 8 hrs * Full Cure 7 days *</p> <p>Recoat 1 hour*</p> <p>Pot Life @ 77 °F 4 hrs.*</p> <p>VOC (maximum) 340 g/L (catalyzed) 2.8 lbs. per gallon</p> <p>Shelf Life @ 77 °F 12 months (D.M.)</p> <p>Reducer MIL-T-81772B ty 2</p> <p>S.F. Coverage 772sq ft.@ 1mil ***</p> <p>* times will vary with, humidity,temperature and film thickness. *** @ 100% transfer efficiency</p>	<p>Corrosion Resistant Chemical Resistant Meets Military Specification Meets ASTM Standards</p> <p style="text-align: center;">Surface Prep & Primer (recommended)</p> <p style="text-align: center;">Aluminum:</p> <p>Solvent wash Alumiprep- Etch & Clean Alodine- Chrome Conversion Coating Prime MIL-P-23377 @ .9 mils dry. (minimum)</p> <p style="text-align: center;">SAFETY:</p> <p>Refer to Material Safety Data Sheets before use</p> <p>Distributed by: PACIFIC RESINS & COATINGS LTD. AIRCRAFT COATINGS & RESINS 151- 5489 Byrne Road, Burnaby, BC, Canada, V5J 3J1 Phone (604)432-6111 or (604)430-4151 Fax (604)432-7006 e-mail info@pwpaints.com</p>
<p>Directions for use:</p> <p>Mix primer part"A" 1-1 by volume with primer catalyst part"B". Stir thoroughly. Thin as needed with MIL-T-81772B ty2 reducer. Apply one full wet coat using 45-55 PSI (conventional spray) at the gun. If a second coat is desired allow 10-15 minutes dry time between coats. Allow the final coat to dry a minimum of 1 hr. @77 °F. Topcoat within 1-2 hours. If primer has been left to dry over 24 hours or has been baked, the surface must be abraded to achieve satisfactory adhesion.</p> <p>NOTE: Never "DRY SPRAY" primers, they need a wet coat to flow into conversion coatings and sand scratches. Refer to M.S.D.S. before use. "NOTE" after mixing let stand for 30 minutes then restir.</p>	