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

TECHNICAL DATA SHEET

DESCRIPTION:

MIL-PRF-23377G 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.

PROPERTIES:

COLOR	Chromate Yellow
SOLIDS by volume	57%
Mix Ratio	3-1 by volume with part "B" catalyst
Let stand (30 minute induction period)	
Dry Film Thickness	.9 mils (minimum)
Dry Times @77 ℉	Tack Free 5hrs *
	Dry 8 hrs *
	Full Cure 7 days *
Recoat	1 hr. minimum *
	3 days maximum *
Pot Life @ 77 °F	4 hrs.*
VOC (maximium)	340 g/L (catalyzed)
Shelf Life @ 77 ℉	12 months (D.M.)
Reducer	MIL-T-81772B ty 2
S.F. Coverage	912 sq/ft gal. ***

* times will vary with, humidity,temperature and film thickness.
*** @ 100% transfer efficiency

ADVANTAGES:

Corrosion Resistant
Chemical Resistant
Meets Military Specification
Meets ASTM Standards

Surface Prep & Primer (recommended)

Aluminum:
Solvent wash
Alumiprep- Etch & Clean
Alodine- Chrome Conversion Coating
Prime MIL-P-23377 @ .9 mils dry. (minimum)

SAFETY:

Refer to **Material Safety Data Sheets** before use

Distributed by:
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(TC)

Directions for use:

Mix primer part"A" 3-1 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 ℉. 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.
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.