



Simco Coatings Inc.

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

TECHNICAL DATA SHEET

MILGUARD-53022 **CORROSION INHIBITING** **LEAD & CHROMATE FREE EPOXY PRIMER**

DESCRIPTION: Milguard-53022 is a Corrosion Inhibiting, lead and chromate free primer. This Epoxy Polyamide Coating is intended for use on properly cleaned and pretreated ferrous and non-ferrous substrates such as aluminum and steel to provide chemical and corrosion resistance.

CONFORMANCE: This product conforms to MIL-DTL-53022 Type II, Revision E (the latest Revision). This data sheet can be used for certain previous revisions. Contact us for details.

TECHNICAL DATA

COLOR & FINISH:

White & Gray
Lusterless

GENERIC TYPE:

Epoxy Resins and Aliphatic Polyamine

% WEIGHT SOLIDS (MIXED):

88 ± 1

% VOLUME SOLIDS (MIXED):

75 ± 1

VOLATILE ORGANIC COMPOUNDS MIXED:

2.8 lbs./gallon or 340 g/l

THEORETICAL SPREADING RATE:

Approx. 1200 sq/ft @ 1.0 Mil DFT

RECOMMENDED DRY FILM THICKNESS:

4-6 Mils

MIX RATIO:

4 Parts by Volume of Epoxy, Component-A to One
Part by Volume of Hardener, Comp-B

POT LIFE:

3-4 Hrs

SHELF LIFE:

24 Months

FLASH POINT:

102°F

DRY TIME @ 75°F:

A.) SET TO TOUCH:

½ Hr.

B.) TO HANDLE:

4 Hrs.

C.) TO TOPCOAT:

6 Hrs.

D.) TO SERVICE:

3 Days

REDUCER/CLEAN-UP:

MIL-T-81772 Type II Epoxy Thinner

PACKAGING:

5's / 1's

Simco Coatings Inc.

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SURFACE PREPARATIONS:

A.) IRON & STEEL:

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.

B.) ALUMINUM:

Remove all oil, grease, dirt, oxide and other foreign material by solvent cleaning per SSPC-SP I. 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%.

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 15 - 25 minutes after mixing both components and before application. Colder temperatures will require a longer induction time. If using thinner, only use MIL-T-81772 Type II Epoxy Thinner (maximum of 5% by volume) and only add it after Component A & Component B have been thoroughly mixed together.

APPLICATION:

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

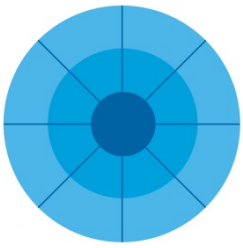
CONVENTIONAL SPRAY: DeVilbiss MBC-510 spray gun "E" Fluid Tip # 704, # 765 or # 78 Air Cap.

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.

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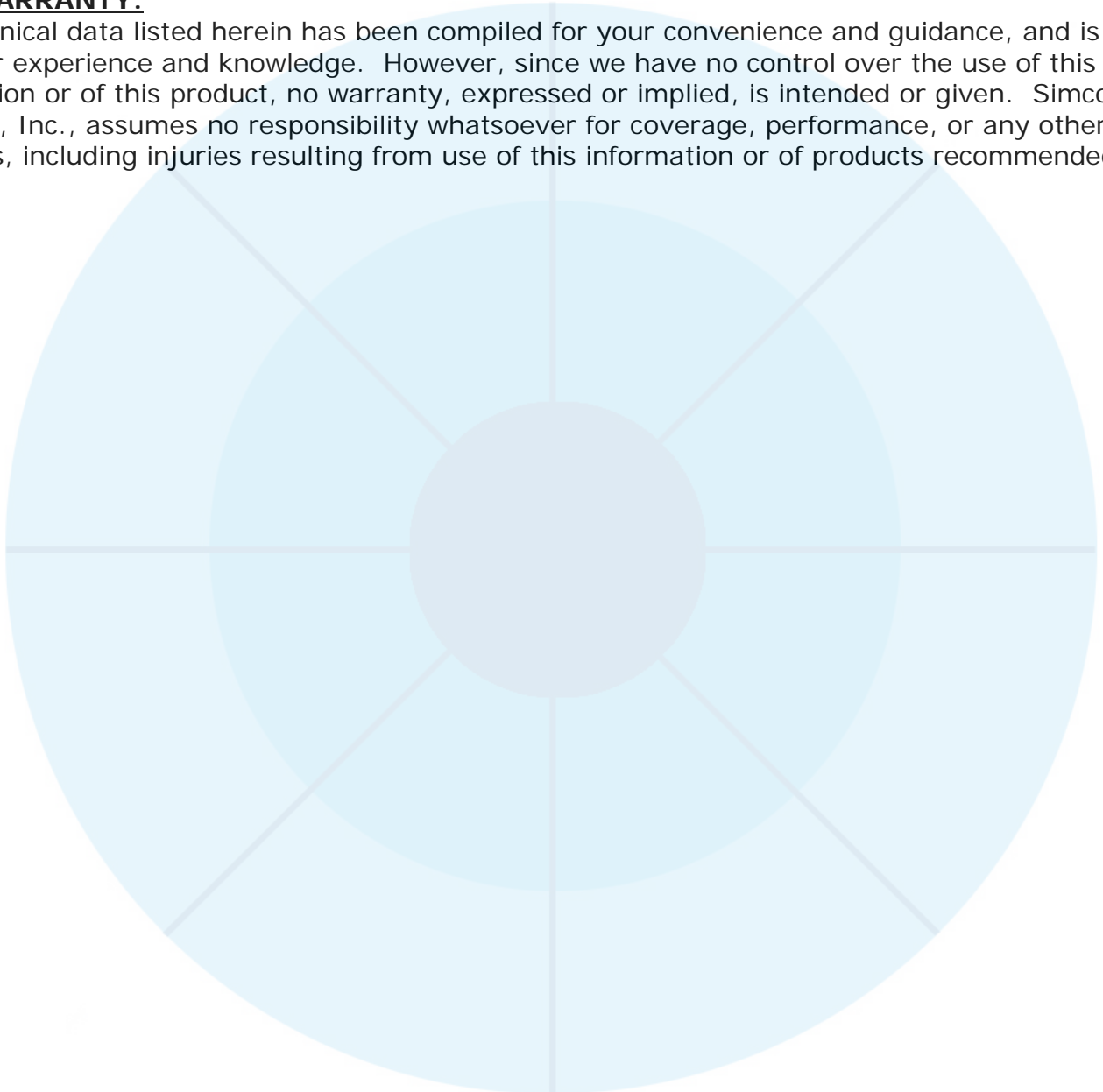
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NON-WARRANTY:

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