



Simco Coatings Inc.

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

TECHNICAL DATA SHEET

MIL-DTL-24441/29B (REVISION D) **FORMULA 150, TYPE-IV** **EPOXY-POLYAMIDE PRIMER GREEN**

DESCRIPTION/CONFORMANCE: This epoxy-polyamide two component lead and chromate free coating is designed to conform the specific composition and performance requirement of Federal Specification MIL-DTL-24441/29B (Revision D Formula-150, Type-IV and is recommended to be used for painting land and marine structures.

PRINCIPAL CHARACTERISTICS:

- Excellent rust preventative properties in adverse or chemically polluted atmospheres.
- Easy application by airless spray up to 5.0 mils (150 Microns) dry film thickness.
- Good adhesion properties on steel, concrete, fiberglass and aluminum when the surface is properly prepared.
- Excellent water and weather resistance for interior and exterior use.
- Good impact resistance
- Resistance to spill/splash mild chemicals.

TECHNICAL DATA

COLOR AND FINISH:	Green, Flat
MASS DENSITY:	Approx 11.25 lbs./gal.
SOLIDS BY VOLUME:	Approx. 65.0%
VOC APPROXIMATE (BEFORE THINNING):	2.25 lbs./gallon, 270 g/l
THEORETICAL SPREADING RATE:	
@ 1 MIL DFT:	1040 sq. Ft. /gal.
RECOMMENDED DRY FILM THICKNESS:	5-6 Mils (125-150 Microns)
TOUCH DRY AFTER (25 °C/77°F):	3 Hrs.
DRY HARD AFTER (25 °C/77°F):	6 Hrs.
MIN. INTERVAL BEFORE OVERCOATING(77°F):	12 Hrs. at 5-6 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.
FLASH POINT (TCC):	Base 96°F (36°C) Hardener 108°F (42°C)
PACKAGE:	A two Component material with base and curing agent supplied in 1 and 5 Gallons Containers Mix ratio in equal volumes.

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SURFACE PREPARATION: Steel: Blast cleaned to a minimum grade SSPC-SP10 (SA2 ½) The surface must be perfectly dry. 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.

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

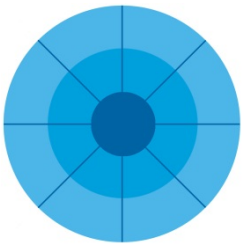
CONVENTIONAL SPRAY

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.

AIRLESS SPRAY

Manufacturer: Graco Binks DeVilbiss
Gun Model: 205-590 Model 500 JGN-501
Pump: Bulldog Mercury 5C QFA-519
Hose should be 3/8" I.D. minimum, but ¼" 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.

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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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