

Simco Coatings Inc.

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

## TECHNICAL DATA SHEET

### SIMFLEX-118 (DOD-P-15328) CHROMATE FREE WASH PRIMER

**DESCRIPTION:** Our Simflex-118 Pretreatment Wash Primer is a two-component, quick dry etch primer specifically formulated with zinc molybdate based corrosion inhibitor and is designed for use on aluminum, galvanized steel, and ferrous substrates to ensure good adhesion of subsequent primer coats. The wash primer itself is not intended to be used as a permanent protective coating.

**CONFORMANCE:** This product conforms to DOD-P-15328 Revision D, Navy Formula #117. Conformance to previous spec MIL-P-15328 Revision C is also available.

### TECHNICAL DATA

<b>TYPE:</b>	Polyvinyl Butyral
<b>COLOR:</b>	Gray
<b>SOLIDS BY VOLUME:</b>	9.6 % (mixed)
<b>RECOMMENDED FILM THICKNESS:</b>	0.3-0.5 mils dry; 3.25-5.5 mils wet
<b>MIXING RATIO:</b>	4:1 by volume (Resin component to catalyst)
<b>THEORETICAL SPREADING RATIO:</b>	305 sq. ft. / gal. @ 0.5 mils
<b>FLASH POINT - CLOSED CUP:</b>	54 °F (mixed)
<b>POT LIFE @ 77°F. (25°C.):</b>	5-6 hrs.
<b>DRYING TIME @ 77°F (25°C):</b>	
<b>A. TO TOUCH:</b>	10 minutes
<b>B. TO HANDLE:</b>	15 minutes
<b>C. HARD DRY:</b>	Min. - 1 hr. ; Max. - 8 hrs.
<b>SHELF LIFE:</b>	1 year
<b>THINNER FOR WASHING/CLEANING:</b>	T-117/118
<b>VOC:</b>	5.98 lbs./gallon or 717 g/l

**PACKAGING:** Available in 1 and 5 gallon short filled containers with a plastic bottle containing phosphoric acid. When phosphoric acid is added to the base component, it will make 1 and 5 gallons respectively.

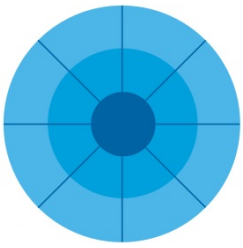
**SURFACE PREPARATION:** Remove all dirt, oil, grease, scale and rust. Sandblasting of surface is preferred. Wash primer must be applied to clean bare metal.

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**CHROMATE FREE WASH PRIMER**

**MIXING:** First, vigorously stir the base component. Then add the acid component while slowly stirring. Do not mix until ready to use, as Simflex-118 Chromate Free Wash Primer is most effective when freshly mixed and must be used within a few hours. The acid component is not a thinner and must be used exactly as directed.

**SPRAY EQUIPMENT:** Devilbiss paint pressure pot with double regulators, MBC-510 gun, FX tip and needle, 705 air cap.

**APPLICATION:** Apply in a wet thin film to a DFT of .3 to .5 mils. Do not exceed DFT of film, for it will impair adhesion of topcoats. Do not apply in temperatures below 40°F.

**WARNING:** This product contains flammable solvents. Avoid breathing of dust. Keep away from heat or open flame. Avoid contact with skin or eyes. Do not take internally. In case of contact with skin, flush with plenty of water and for eyes flush with water for 10-15 minutes. Get medical attention. In confined areas, provide adequate fresh air ventilation; use fresh air masks and explosion proof equipment. Forbid all flames, smoking, and welding in work area.

**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 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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