



SAN DIEGO SEAL, INC.

INDUSTRIAL & MARINE SEALING DEVICES

7635 RONSON ROAD • SAN DIEGO, CA 92111 • TEL: 858-278-3270 • FAX: 858-278-2950
E-MAIL: sales@sandiegoseal.com • VISIT US AT: www.sandiegoseal.com

EPOXY-POLYAMIDE TOPCOAT
MIL-DTL-24441/27A
FORMULA 157, TYPE-III Gray No. 50

Description: These are two-part Epoxy-Polyamide, VOC Compliant Coatings specifically formulated for painting particular areas aboard ships such as bridges, exterior under water hull. These coatings are also suitable to be used as topcoats for exterior and interior application on aircrafts and ground support system.

Principal Characteristics:

Can be applied up to 6.0 Mils DFT.

Excellent resistance to weather, moisture, petroleum products and mild chemicals.

Good impact resistance

Technical Data

Color & Finish:	As per Formula No.; Satin to Semi -Gloss Finish
Mass Density:	11.0 ± 0.5 lbs./gal.
Solids by Volume:	Approx. 63 ± 2%
Flash Point (mixed):	Base 99°F (38°C) / Hardener 108°F (42°C)
Theoretical Spreading Rate:	Approx 1,000 sq. ft. /gal. @ 1 Mil D
Recommended DFT	4-5 Mils (100-125 Microns)
Volatile Organic Compound (VOC):	2.50 lbs./gal.; 300 grm./ltr.
Temperature Resistance	250°F (121°C)
Pot Life	4 hours @ 73°F
Shelf Life	12 months
Flash Point:	Base 99°F (38°C) / Hardener 108°F (42°C)
Packaging:	A two Component material with base and curing agent supplied in: 1 & 5 Gallons Containers 1:1 by volume.
Drying Time @ 75°F:	
To touch	2-3 hours
Dry hard	6-8 hours
Max interval before overcoating	7 days
To full cure	7 days

Recommended Substrate Conditions:

Steel: Properly Primed substrate with Zinc Rich Epoxy or Epoxy Polyamide Green Primer, Formula-150. The surface must be perfectly dry.

Instructions for Use:

Power agitate base component to uniform consistency before combining, then again after combining. Do Not vary proportions.

Substrate Temperature:

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 Instructions:

Ratio: base to hardener 54-46 by weight / base to hardener 50-50 by volume

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. Thinner should be added after mixing the components.

Very good mechanical mixing of base and hardener is essential in view of the paste consistency.

Conventional Spray:

Manufacturer:	<u>DeVilbiss</u>	<u>Binks</u>
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:	<u>Graco</u>	<u>Binks</u>	<u>DeVilbiss</u>
Gun Model:	<u>205-590</u>	<u>Model 500</u>	<u>JGN-501</u>
Pump:	<u>Bulldog</u>	<u>Mercury 5C</u>	<u>QFA-519</u>

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.

Thinning Requirement:

- Recommended Thinner : MIL-24441 Thinner
- Airless Spray : 0-10% by Volume
- Conventional Spray : 5-15% by Volume
- Roller And Brush : 0-5% by Volume
- Clean-up Thinner : MIL-24441 Thinner

Safety Precautions:

- (A) Use normal precautions such as gloves, facemasks.
- (B) Adequate ventilation must be maintained.
- (C) Explosion proof lights & electrical equipment.
- (D) Non-Sparking shoes & tools for workers in area.
- (E) This product contains flammable materials. Forbid all flames, smoking and welding in work area.
- (F) Avoid breathing of vapor, contact with skin or eyes. If product comes in contact with skin or eyes, wash thoroughly with water and obtain medical attention.

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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MIL-DTL-24441/29A (SH)
GREEN PRIMER FORMULA (FA) 150, TYPE-IV

Description:

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-24441/29A (SH) Formula(FA)-150, Type-IV and is recommended to be used for painting land and marine structures.

Principle Features:

- Excellent rust preventative properties in adverse or chemically polluted atmospheres.
- Easy application by airless spray up to 6.0 mils (150 Microns) dry film thickness.
- Good adhesion properties on steel, concrete, fiberglass and aluminum where 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:	2.25 lbs./gal. , 270 gm./ltr.
Theoretical Spreading Rate:	1040 sq. Ft. /gal. @ 1 mil
Recommended DFT:	3-4 Mils (75-100 Microns)
Touch dry after:	3 Hrs.
Dry hard after:	6 Hrs.
Max. Interval Before Overcoating:	7 Days
Full Cure after:	7 Days
Temperature Resistance:	250°F (121°C)
Shelf Life:	12 months
Flash Point:	Base 99°F (38°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.
Pot Life:	5 Hours At 73 °F (23 °C)

Recommended Substrate Conditions:

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

Instructions for use:

Power agitate base component to uniform consistency before combining, then again after combining. Do Not vary proportions.

Substrate Temperature:

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 Instructions:

Ratio: base to hardener 54-46 by weight
base to hardener 50-50 by volume

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. Thinner should be added **after** mixing the components.

Very good mechanical mixing of base and hardener is essential in view of the paste consistency.

Conventional Spray

Model

Air Cap

DeVilbiss

MBC or JGA

704E

Binks

#18 or #62

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

Model

Pump

DeVilbiss

JGN-501

QFA-519

Binks

Model 500

Mercury 5C

Graco

205-590

Bulldog

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.

Thinning Requirement:

Recommended Thinner: MIL-24441 Thinner

Airless Spray: 0-10% by Volume

Conventional Spray: 5-15%% by Volume

Roller And Brush: 0-5% by Volume

Clean-up Thinner: MIL-24441 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 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.

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EPOXY-POLYAMIDE TOPCOAT
MIL-DTL-24441/30A
FORMULA 151, TYPE-IV Gray No. 50

Description: These are two-part Epoxy-Polyamide, VOC Compliant Coatings specifically formulated for painting particular areas aboard ships such as bridges, exterior under water hull. These coatings are also suitable to be used as topcoats for exterior and interior application on aircrafts and ground support system.

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Gun Model	MBC or JGA	#18 or #62
Tip-Air Cap Combination	704E	66PE

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