SHERWIN WILLIAMS.

MIL-PRF-23377J, Class C2

2.8 VOC Chromated Epoxy Polyamide Primer

Type I Yellow E90G203
Catalyst (Component B) V93V230

DESCRIPTION

MIL-PRF-23377J, Class C2 is a two component 2.8 lb/gal VOC compliant, epoxy polyamide primer. It meets MIL-PRF-23377J, Class C2, composition and performance specification. It is used as a primer under MIL-PRF-85285D polyurethane topcoats, or polyurethane chemical agent resistant coatings (CARC) specified in MIL-DTL-53039B, MIL-DTL-64159 or MIL-PRF-22750F epoxy topcoat.

Advantages:

- 2.8 lb/gal VOC
- Fast drying
- Excellent chemical, solvent and corrosion resistance
- For aluminum with chromate conversion coating or anodized aluminum, it offers excellent filiform resistance
- Excellent hold out for high gloss topcoats

These products have been approved by the U.S. Naval Air Warfare Center (NAWC) Patuxent River, MD. Copies of approval letter are available upon request.

Not Stocked - Special Order Only:
Type II Low IR Green.....E90G205
Same Catalyst (Component B) as above.

CHARACTERISTICS

Gloss 10-20 (60°)
Volume Solids: 45% Catalyzed
Viscosity: catalyzed
25 seconds (maximum) #2 Zahn Cup
Recommended film thickness:
Mils Wet 1.3-2.0
Mils Dry 0.6-0.9
Spreading Rate (no application loss)
802-1203 sq ft/gal @ 0.6-0.9 mils DFT
Drying (0.8 mils dft, 77°F, 50% RH):
Tack Free: 5 hours
Dry Hard 8 hours
To Recoat: 2 hours
Force Dry: to dry hard 45-60 minutes at 140°F
Flash Point: 22°F Pensky-Martens Closed Cup
Mixing Ratio: by volume
3 parts E90G203 or E90G205
1 part V93V230
Induction Time: **30 minutes**
Pot Life: 4 hours at room temperature. Higher temperature will shorten pot life
Package Life: 1 year, inside storage

Air Quality Data:
Non-photochemically reactive Volatile Organic Compounds (VOC)
Part A as packaged, maximum
2.85 lb/gal, 342 g/L
V93V230 as packaged, maximum
2.63 lb/gal, 316 g/L
catalyzed as above, maximum
2.8 lb/gal, 340 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility.

SPECIFICATIONS

Aluminum: Clean with acidic cleaner or other appropriate cleaner depending on contamination. Pretreat with chromate conversion coating MIL-DTL-5541F, wash primer DOD-P-15328D, E90G4, or anodize per MIL-A-8625F.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

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APPLICATION

Typical Setups

Reduction: To maintain 2.8 lb/gal VOC, no reducer other than acetone or Oxsol 100 may be added.

May be applied by:

Conventional Spray
Airless Spray
Air Assisted Airless
HVLP

Please consult with your Sherwin-Williams sales representative for proper settings for your spray equipment.

Cleanup:

Clean tools/equipment immediately after use with MEK, MIBK, MAK or n-Butyl Acetate, or any other epoxy thinners, such as MIL-T-81772B, Type II Thinner, R91K210.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- This product must be properly mixed (catalyzed) before using. (See mixing instruction for details.)
- Surface preparation is important for performance.
- For good adhesion, parts primed need to air dry a minimum of 2 hours before topcoating. If parts have been primed for longer than three days, they must be sanded or recoated with a mist coat before topcoating for good adhesion.
- These primers contain strontium chromate.

Performance Properties:

Meets all the performance properties of MIL-PRF-23377J, Class C2.

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility. Please direct any questions or comments to your local Sherwin-Williams facility.

LABEL CAUTIONS

SEE CONTENTS STATEMENT ON LABEL.

Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition.

VAPOR HARMFUL. Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing, Keep warm and quiet. If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately.

SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE.

Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

This product must be mixed with other components before use. Before opening the packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

SEE MATERIAL SAFETY DATA SHEET.22325-051905.