



# PRODUCT FINISHES

## MIL-P-11414F

### Fast Dry HAPS FREE Alkyd Primer

Primer ..... E90R351

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>E90R351 is a single component corrosion-inhibiting primer for use as a primer on steel ammunition surfaces. This product may be top coated or this product may be used without a top coat. This product is for spray application. This product conforms to the requirements of MIL-P-11414Ø. This product is assigned the qualification number 97E07 as a HAPS FREE version of MIL-P-11414Ø. Qualification is granted by the U.S. Army Research Laboratory (ARL).</p> <p><b>Advantages:</b></p> <ul style="list-style-type: none"> <li>• Lead and chrome free.</li> <li>• Fast dry.</li> <li>• Recoatable with enamel.</li> <li>• HAPS Free.</li> </ul> <p>This product meets the VOC regulations for the state of Pennsylvania Department of Natural Resources Code 129.52 relating to all surface coating processes.</p>	<p><b>Gloss:</b> 2-5 at 60°</p> <p><b>Volume Solids:</b> 55-56%</p> <p><b>Weight per Gallon:</b> 12.0-12.4 lb/gal</p> <p><b>Viscosity:</b> 75-85 KU as supplied. Reduce 10% with MAK viscosity is 70 KU Max. Typical 63 KU</p> <p><b>Recommended film thickness:</b> 1.0-1.5 dry</p> <p><b>Spreading Rate</b> (no application loss) @ 1.0 mil dft: 890 sq ft/gal</p> <p><b>Drying</b> (1.0 mils dft, 77°F, 50% RH): Dry Hard: 12 minutes</p> <p><b>VOC: (Typical)</b> Supplied: 3.0 lb./gal, 363 g/l Reduced 10%: 3.37 lb/gal, 404 g/l</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p><b>Steel:</b> Surface must be clean and free of grease, dirt, oil, rust, fingerprints, and other contaminants to insure optimum adhesion and performance properties. Chemical pretreatment (zinc phosphate) or DOD-P-15328 wash primer (E90G4) gives best adhesion and performance results. Where blasting is appropriate, blast in accordance with SSPC-SP6. For optimum adhesion pretreat blasted surface with wash primer E90G4 within two hours after blasting.</p> <p><b>Aluminum:</b> Clean with acidic cleaner or other appropriate cleaner depending on contamination. Pretreat with chromate conversion coating (MIL-C-5541), DOD-P-15328 (E90G4) wash primer, MIL-C-5541 wash primer (E90G16) or anodize per MIL-A-8625.</p> <p><b>Galvanized and other metals:</b> Clean and remove oxidation contamination on surface, followed by treatment with DOD-P-15328 wash primer. Due to the variability in these surface, testing adhesion on each situation is recommended.</p> <p><b>Testing:</b> 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.</p>

## **APPLICATION**

### Typical Setups

#### **Reduction:**

Reduce 10% with Methyl n-Amyl Ketone (SW Code R6K30) to meet PA rule 129.52. Maximum allowable VOC in PA would be 3.37#/gallon based on a weight per gallon of the solvent of 6.76 pounds.

#### **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:**

Toluene, Xylene or lacquer thinner.  
Follow manufacturer's safety recommendations when using any solvent.

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## **SPECIFICATIONS**

#### **Product Limitations:**

- Product must be applied over properly prepared substrates.
- Product should be applied at a dry film build of 1.0 - 1.5 mils.

#### **Performance Properties:**

All requirements of MIL-P-11414E. In addition this product is HAPS FREE and meets the explosive compatibility testing of MIL-P-22332B.

## **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.

**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.