Product Finishes

CC-M4

MIL-DTL-53022, Type I

Lead & Chromate Free Epoxy Primer

White (Component A)..... E90W201
Catalyst (Component B)..... V93V202

DESCRIPTION

E90W201/V93V202 is a conventional solid, two component, lead and chromate free epoxy primer. It meets MIL-DTL-53022, Type I, composition and performance specification. It may be used as a primer under polyurethane chemical agent resistant coatings (CARC) specified in MIL-DTL-53039 or waterborne polyurethane (CARC) specified in MIL-DTL-64159, MIL-PRF-22750 epoxy topcoat, or MIL-PRF-85285 (non-aircraft) polyurethane topcoats.

Advantages:

- Complies to Rule 102, South Coast Air Quality Management District or Rule 66 emission regulation
- Fast dry
- Excellent chemical, solvent and corrosion resistance on aluminum and steel
- Free of lead and chromate hazards

The following MIL-DTL-53022 Type I colors are approved by U.S. Army Research Lab, Aberdeen Proving Ground, Aberdeen, MD.

Sherwin-Williams	QPD
E90W201	Q641
V93V202	Q641

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com

CHARACTERISTICS

Gloss: 10-30 units (60°)
Volume Solids: (Typical)
Component A: 44.1 ± 1%
Component B: 21.4 ± 1%
Admixed: 39.5 ± 1%
Viscosity: (Typical)
Component A: 63-73 Krebs Units
Component B: 10-20 seconds #4 Ford Cup
Admixed: 30-40 seconds #2 Ford Cup
Recommended film thickness:
Mils Wet 2.6 - 5.1
Mils Dry 1.0 - 2.0
Spreading Rate per Admixed Gallon (no application loss):
300-665 sq. ft./gal @ 1.0—2.0 mils DFT
Drying (1 mils DFT, 70°F, 50% RH):
Set to Touch: 90 minutes
Dry Hard: 4 hours
To Recoat: 2 hours to 7 days
Force Dry: to obtain dry hard 30-40 mins at 140°F
Flash Point: 21°F Pensky-Martens Closed Cup
Mixing Ratio: by volume
4 parts Component A
1 part Component B
1 part Reducer (optional)
Shake Component A well before mixing.
Induction Time: 30 minutes
Pot Life: 8 hours at room temperature - higher temperatures will shorten pot life.
Package Life: 24 months unopened, inside storage
Air Quality Data:
Non-Photochemically reactive Volatile Organic Compounds (VOC)* catalyzed as above, maximum
4.35 lb/gal, 521 g/L

SPECIFICATIONS

Steel: 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 DODP- 15328D 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 immediately. Prime with wash primer E90G4 within two hours after blasting.

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.

Galvanized and other metals: Clean and remove oxidation contamination on surface, followed by treatment with DOD-P- 15328D wash primer, E90G4. Due to the variability in these surface, testing adhesion on each situation is recommended

Note: See MIL-DTL-53072 for complete details regarding substrate preparation, coatings and application.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application meth-

APPLICATION

Reduction: If required, use MIL-T-81772, Type II, R91K210 or MIL-T-81772, Type 1, R91K20

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May be applied by:

Conventional Spray
Airless Spray
Air Assisted Airless
HVLP

Clean-Up: Clean tools / equipment immediately after use with MEK (R6K10), MIBK (R6K16), MAK (R6K30), or other epoxy thinners such as MIL-T-81772 Type II (R91K210) or MIL-T-81772, Type I Reducer R91K20

Follow manufacturer's safety recommendations when using any solvent.

APPLICATION

Typical Setups

Product Limitations:

- This product must be properly mixed (catalyzed) before using. (See mixing instruction for details.)
- Surface preparation is important for performance.
- Primer must be applied within 24 hours after the surface has been prepared for priming
- For good adhesion, parts primed with E90W201/V93V202 need to air dry a minimum of 2 hours before topcoat.
- If parts have been primed for longer than seven (3) days, they must be sanded and/or recoated with a mist coat of E0W201/.V93V202 before top coating for good adhesion
- **E90W201/V93V202 should not be used as a primer when using MIL-DTL-53039 Type 2 topcoats**

Performance Properties:
Meets all the performance properties of MIL-DTL-53022D, Type I.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.paintdocs.com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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