

MILSPRAY

Military Technologies

1 QUART OR 1 GALLON MIXED MIL-PRF-23377 EPOXY PRIMER

MIXING RATIO: 2 Parts A to 1 Part B

DIRECTIONS FOR USE:

- Step 1:** Stir contents of Part A until completely blended.
- Step 2:** Pour Part A into mixing container.
- Step 3:** While stirring Part A, **slowly** pour the appropriate quantity of Part B in. **Never pour Part B into Part A while not stirring!**
- Step 4:** Thoroughly mix until all of Part B is incorporated into Part A.
- Step 5:** Induction time: Let mixed material stand for 1/2 hour.
- Step 6:** If it is necessary to add thinner to this coating, use only Mil-T-81772B TY II Epoxy Thinner. In areas where air quality regulations restrict volatile emissions, do not add thinner to this primer if that addition will raise the VOC content to greater than 340 g/L (2.8 lb/gal). The addition of too much thinner can cause pigment to flocculate and fall out of solution.
- Step 7:** Mix for 1- 2 minutes.
- Step 8:** Mixture is now ready to spray!

TECHNICAL INFORMATION

Epoxy Primer Material.....MIL-PRF-23377
Quart Coverage.....100 sq. ft @ 1 mil DFT
Recommended DFT.....0.6 - 0.9 mils
Pot Life*.....4 hrs
VOC..... 2.8 lbs./gal

Storage Temp.....50-75°F
Shelf Life.....1 yr
Dry Hard*.....8 hrs max
To Handle*.....10 hrs max
Recoat*.....5 hrs

Note: Dark colors may cure slower than light colors.

*@77°F/25°C