



MIL-DTL-24441/20B

F-150, TYPE 3
PAINT, EPOXY POLYAMIDE
GREEN PRIMER

TECHNICAL PRODUCT BULLETIN

PRODUCT DESCRIPTION AND USES

PRODUCT DATA

MIL-DTL-24441/20B, Formula 150 Epoxy green primer is intended for use of sandblasted steel, aluminum or fiberglass where a hard, durable, chemically resistant coating is desired. It is suitable for both interior and exterior use as a prime coat with various types of finishes include alkyds, epoxies, polyurethanes, polyaspartics, polysiloxanes, and various shipbottom paints.

This product is approved for use on naval vessels on various areas such as tanks, bilges, underwater hulls, under non-skid coatings, exterior hulls and as a general use primer on interior surfaces. It has found acceptable use on bridges, tanks, structural steel, refineries and oil related use, pipelines and chemical refining and pulp and paper mills.

MIL-DTL-24441/20B is mercury, chromate and lead free. It is suitable for use in areas that require VOC levels of less than 2.8 pounds per gallon or 340 grams per liter.

It has excellent adhesion to properly prepared concrete surfaces and resists oil, gas, hydraulic fluids and other petroleum products.

MIL-DTL-24441/20B meets USDA requirements for use in areas which require incidental contact with food and edible substances.

VOC Content:
2.8 lbs./gal; 340 grams/liter

Type of Material:
Epoxy Polyamide

Volume Solids:
62.5% by volume

Estimated Coverage:
1003 sq. ft./gal @ 1 mil DFT

Recommended Film Thickness:
2-4 mils DFT

Method of Application:
Spray, brush or roller

Number of Coats:
One

Thinner and Clean Up Solvent:
130 Thinner

Shelf Life:
Four years from DOM

Pot Life:
5 hours@ 77°F

Dry Time:
2 hours to touch; 6 hours hard

Flash Point:
100° F SETA

Color and Gloss:
Green; Matte

Mixing Ratio:
1 to 1 by volume

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SURFACE PREPARATION

Before Blasting: Grind smooth to round contour all rough welds and sharp edges. If necessary, de-grease the surface by solvent cleaning to prevent contamination. Remove weld spatter and excessive rust scale by impact tools (preferable).

Blast: Blast to SSPC-SP-10 NEAR WHITE with a minimum surface profile of 1.0 - 2.0 mils. The surface should be free of all visible mill scale, rust, corrosion, oxides, or other foreign matter.

After Blast: Remove blast dust by brushing, compressed air or vacuum. Keep surface clean of all foreign matter prior to coating.

Care must be taken to avoid overcuring of F-150 primer prior to topcoating. Generally, the coat of F-150 should still be tacky at time of recoating. If primer has fully cured, a mist coat must be applied prior to succeeding coats.

APPLICATION INSTRUCTIONS

Apply a wet uniform film maintaining wet film requirements. The best method is to overlap each pass 50% and keep film wet. Cover all welds, seams, corners, rivets, edges, and rough spots.

Air: Airless Graco 30-1 pump, .025 tip.

Brush: Solvent resistant equipment.

Roller: Solvent resistant equipment.

Lower temperatures retard the curing properties of the coatings. Substrate temperature should be above 45' F. at time of application and not dropping.

Do not apply when dew point is within 5' F. of the surface temperature.

Material should be stored between 30' F. and 110' F.

MIXING

This material is supplied in 2 containers of equal parts which are to be mixed 1:1 by volume. Prior to use, mix only that amount which can be used during the expected pot life. Mix thoroughly until components are uniform and allow to stand (induct) 30 minutes after mixing.

This material is for industrial use only. See Material Safety Data Sheets for handling, storage, disposal and use.

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