



Epoxy Polyamide Zinc Rich Primer Formula 159 Type III MIL-DTL-24441/19B(40-DH-6)

Epoxy Polyamide

PRODUCT DESCRIPTION
TYPICAL USES
PRODUCT ADVANTAGES
COLORS
GLOSS
PHYSICAL CONSTANTS
APPLICATION
SHIPPING & STORAGE

A two component, high performance epoxy/polyamide zinc rich primer. Meets the requirements of MIL-DTL-24441/19B Type III.

For industrial, commercial and marine use as a protective maintenance coating designed for application directly to properly prepared or sandblasted steel. Suitable for interior or exterior surfaces. For bilges, tanks, underwater hulls, machinery, piping, structural steel and other surfaces requiring a high performance coating system.

MIL-DTL-24441/19B (40-DH-6) Epoxy Polyamide Zinc Rich Primer Coating is formulated to provide a hard, durable, chemically resistant coating on steel structures that receive severe exposure to adverse weather, moisture, corrosive atmospheres and marine environments. It is recommended for use as a Prime Coat normally in a multiple coat system intended for surfaces in tidal zones, surfaces subject to immersion in fresh or salt water, exposures to chemical splash and spillage, and incidental weather exposed areas. Low VOC and lead free.

Gray

Matte

- Nonvolatile -** By weight - 89.0 ± 2.0%
By volume - 63.0 ± 1.0%
- VOC (Calculated) -** 2.5 lbs./gal.
304 grams/liter
- Flash Point -** (A) 99°F minimum (Setaflash)
(B) 110°F (Setaflash)
- Mixing ratio -** 4:1 by volume
- Weight per gallon -** (A) 7.7 ± 0.2 lbs.
(B) 28.4 ± 0.2 lbs.

- Recommended Film Thickness -** 3.0 mils dry, 4.8 mils wet.
- Theoretical Coverage @ 3.0 mils dry -** 336 sq. ft./gal.
- Method -** Brush, roll, conventional and airless spray.
- Thinner -** MoPoxY™ F159 Thinner 43-EF-117 (Refer to thinning on back)
- Cure time @ 75°F -** To touch - 2 hours max.
To handle - 8 hours max.
To recoat - 24 hours
- Pot life @ 75°F -** 4 hours minimum
- Induction time -** 1/2 hour @ 75°F (See "Mixing" on back)

- Consists of -** 5 Gallon Unit
- Part (A)** 1 gallon
- Part (B)** 5 gallons (short filled)
- Unit Shipping Weight** 125 lbs.
- Shelf Life -** 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

APPLICATION INSTRUCTIONS

Consult your Mobile Paint Representative for the protective coating system best suited for your requirements.

Limitations: Apply in good weather when air and surface temperature are above 50°F and surface temperature is at least 5°F above the dew point. For optimum application properties, material should be between 70 to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40-100°F.

Surface Preparation: Good surface preparation is essential to a satisfactory coating system. Surfaces to be coated should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

New or Unfinished Surfaces - Ferrous Metal: For best performance, application to abrasive blasted and primed surface is recommended. "Commercial Blast Cleaning" SSPC-SP6 is recommended as the minimum. For immersion service "Near White Blast Cleaning" SSPC-SP10 is considered minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of 2.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. If blasting is not feasible, remove rust by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3).

Previously Finished Surfaces - Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7). Remove rust, corrosion products, heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). Spot prime any bare areas as in new work above. If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

Mixing: This is a two component coating supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. (1) Mix the contents of Component A thoroughly with a power agitator. (2) Mix the contents of Component B thoroughly with a power agitator. (3) Combine the entire contents of Component A and Component B and mix thoroughly with a power agitator. Allow a 1/2 hour induction time @ 70°F before using the coating. Usable pot life depends on the temperature of the material. Refer to Pot Life section on front page. Agitate at slow speed during use to prevent zinc dust from settling.

Induction time - @ 50-60°F -- 1½ hours
@ 61-75°F -- 1 hour
@ 76-80°F -- ½ to 1 hour
@ 81-90°F -- ½ hour
above 90°F -- none

Thinning: Material is supplied at airless spray viscosity and should not require thinning. Clean Air Regulations may not allow thinning of this product for certain uses. Do not thin beyond applicable regulations. If thinning is allowed, use MoPoxY™ F159 Thinner 43-EF-117.

Application: Spray application is preferred for proper film build and best performance. Brush application is acceptable for touch up. Roller application may require special care to prevent bubbling and may require more than one coat to attain proper film thickness. Apply at 4.8 mils wet film thickness to achieve 3.0 mils dry film thickness.

Equipment: Conventional spray - DeVilbiss MBC gun with E tip and 30 air cap or equal at 40-45 psi atomizing pressure and 10-15 psi pot pressure, 3/8" ID product hose, double regulated pressure pot with oil and moisture separator. Airless spray - Minimum of 30:1 ratio pump, .017" to .021" tip, 3/8" ID material hose.

NOTE: During lunch, breaks or any period of work stoppage, material should be removed from hoses and equipment. Release pressure from equipment and flush hoses and equipment with MoPoxY™ F159 Thinner 43-EF-117. Do not repressurize equipment until ready to resume work.

Cleanup: Clean all equipment immediately after use with MoPoxY™ F159 Thinner 43-EF-117. Completely flush all spray equipment with this solvent. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

Safety: Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

Notice: The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

40-DH-6(10/03)

LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.