

Randolph Products Company

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**MIL-PRF-81352C AIRCRAFT TOUCH UP COATING – Type 1**

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>An exterior grade acrylic for use on metal surfaces. Specifically formulated to have resistance to diester lubricating oil and heat from aircraft.</p> <p>This product may be used as a topcoat over MIL-PRF-23377 or MIL-PRF-85582 primer.</p> <p>Randolph Products Co. warrants that its Products meet its internal specifications and are of merchantable quality. However, the purchaser is solely responsible for the suitability of the product for any particular application. The purchaser should thoroughly test or qualify the product for serviceability, environmental compliance and health and safety factors prior to use. Further, our total liability is limited to the price of the product or replacement in kind.</p> <p>Randolph Products Company 33 Haynes Circle Chicopee, MA 01020 Phone: 413-592-4191 Fax: 413-594-7321 www.randolphproducts.com</p>	<ol style="list-style-type: none"> 1. Color: SAE-AMS-STD-595/Fed. Std 595 Colors 1XXXX SAE-AMS-STD-595/Fed. Std 595 Colors 2XXXX SAE-AMS-STD-595/ Fed. Std 595 Colors 3XXXX 2. Volume Solids: 22.5 – 27.4% (varies by color) 3. Solids by Weight: 23 - 30% (varies by color) 4. Viscosity: 16 - 25 seconds #4 Ford Cup 5. DFT: 1.7 – 2.3 mils 6. Theoretical Coverage @ 1 mil dft: 360 - 439 ft²/gallon (varies by color) 7. Gloss @ 60° Fed. Std. 595 Colors 1XXXX Gloss: 80 minimum Fed. Std. 595 Colors 2XXXX Gloss: 15 – 45 Fed. Std. 595 Colors 3XXXX Gloss: 5 maximum 8. Dry Time Tack Free: 60 minutes max. Complete Cure: 24 hours Force Dry: 30 minutes at 145°F *Force Drying may affect gloss 9. VOC 2.8 lbs/gallon (340 grams/liter) 10. Shelf Life Two years from date of manufacture 	<p>Steel: Apply over MIL-PRF-23377 or MIL-PRF-85582 primer. Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p>Aluminum: Apply over MIL-PRF-23377 or MIL-PRF-85582 primer. Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p>Galvanized and other metals: Apply over MIL-PRF-23377 or MIL-PRF-85582 primer.</p> <p>Reduction: Reduce with MIL-T-81772 Type 3 as required. Do not exceed VOC limits.</p> <p>Conventional Spray: Atomizing Pressure: 45 – 60 psi Pot Fluid Pressure: 10 – 20 lbs.</p> <p>Airless Spray: Tip Size: 0.011 – 0.013” orifice Atomizing Pressure: 1800 - 2200 psi</p> <p>Clean-up: Clean tools and equipment immediately after use with a blend of Xylene and MIBK or MIL-T-81772 Type 3 thinner.</p> <p>Safety Precautions: This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>