

## MIL-P-23377F CLASS 1 EPOXY PRIMER

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component yellow epoxy primer for application over properly prepared aluminum or steel.</p> <p>This product may be used as a primer for MIL-PRF-22750 and MIL-PRF-85285 topcoats.</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"> <li>1. <b>Color:</b> Yellow</li> <li>2. <b>Volume Solids:</b> 28%</li> <li>3. <b>Solids by Weight:</b> 37%</li> <li>4. <b>Viscosity:</b> &lt; 22 seconds #4 Ford Cup</li> <li>5. <b>DFT:</b> 0.6 – 0.9 mils</li> <li>6. <b>Theoretical Coverage @ 1 mil dft:</b> 449 ft<sup>2</sup>/gallon</li> <li>7. <b>Gloss @ 60°</b> Flat</li> <li>8. <b>Dry Time</b> Tack Free: 1 hour max. Dry Hard: 6 hours max. Complete Cure: 7 days</li> <li>9. <b>Pot Life</b> 4 hours minimum</li> <li>10. <b>Mix Ratio</b> 1:1 by volume 1 part Component A 1 part Component B</li> <li>11. <b>VOC</b> 5.0 lbs/gallon (599 grams/liter)</li> <li>12. <b>Induction Time</b> 30 - 45 minutes</li> <li>13. <b>Shelf Life</b> One year from date of manufacture</li> </ol>	<p><b>Steel:</b> Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p><b>Aluminum:</b> Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p><b>Galvanized and other metals:</b> Clean and remove surface contamination including oxidation. .</p> <p><b>Reduction:</b> Reduce with MIL-DTL-81772 Type 2 or 4. When thinning, do not exceed the VOC limit.</p> <p><b>Conventional Spray:</b>            Atomizing Pressure: 45 – 55 psi            Pot Fluid Pressure: 10 – 20 lbs.</p> <p><b>Airless Spray:</b>            Tip Size: 0.011 – 0.015” orifice            Atomizing Pressure: 1800 - 2200 psi</p> <p><b>Clean-up:</b>            Clean tools and equipment immediately after use with MEK, MAK or MIL-T-81772 Type 2 thinner.</p> <p><b>Safety Precautions:</b>            This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>