

Randolph Products Company

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**MIL-DTL-53022F Epoxy Primer Coating – Type 4**

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component lead and chromate free anticorrosive primer.</p> <p>Qualified under MIL-DTL-53022F, Type IV.</p> <p>This product has been formulated to provide enhanced corrosion protection. It passes 1,000 hours of Salt Spray and 40 cycles of GM 9540 cyclic corrosion testing.</p> <p>This product may be used as a primer under CARC coatings specified in MIL-DTL-53039 or MIL-DTL-64159, MIL-PRF-22750 epoxy topcoats or MIL-PRF-85285 (non aircraft) polyurethane 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"> 1. Color: Lighter than SAE-AMS-STD-595/ Fed. Std.595 26622 2. Volume Solids: 63 +/- 2% 3. Solids by Weight: 76.8 +/- 2% 4. Viscosity: 65 – 80 KU 5. DFT: 1.3 – 1.7 mils 6. Theoretical Coverage @ 1 mil dft: 1010 ft²/gallon 7. Gloss @ 60° 10 – 45 8. Dry Time Set to Touch: 60 minutes max. Dry Hard: 5 hours max. Through Dry: 8 hours max. 9. Pot Life 6 hours maximum 10. Mix Ratio 4:1 by volume 4 parts Component A 1 part Component B 11. VOC 2.02lbs/gallon (243 grams/liter) 12. Shelf Life Two years from date of manufacture 	<p>Steel: Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion. Pretreatment with TT-P-490E Type 1. When blasting the surface a minimum of SSPC-SP6 is required for best performance.</p> <p>Aluminum: Clean with an appropriate cleaner to remove contamination from the substrate. Pretreat the surface with a wash primer or other conversion coating.</p> <p>Galvanized and other metals: Clean and remove surface contamination including oxidation. Treat with a wash primer to improve adhesion to the substrate.</p> <p>Note: Due to wide variations in substrates, surface preparation etc. It is recommended that the customer check adhesion and compatibility.</p> <p>Reduction: Reduce with MIL-DTL-81772 Type 2 or Type 4.. Do not exceed VOC limits.</p> <p>Conventional Spray: Atomizing Pressure: 45 – 55 psi Pot Fluid Pressure: 10 – 20 lbs.</p> <p>Airless Spray: Tip Size: 0.015 – 0.021” orifice Atomizing Pressure: 2800 psi minimum</p> <p>Clean-up: Clean tools and equipment immediately after use with MEK, MAK or MIL-DTL-81772 Type 2 or 4 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>