

MIL-C-22750D EPOXY POLYAMIDE COATING – TYPE 1

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component epoxy polyamide topcoat for spray and brush application with a maximum VOC of 4.7 lbs/gallon (563 grams/liter).</p> <p>This product may be used as a topcoat over MIL-PRF-23377 primer or MIL-DTL-53022 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: 25.9 – 31.6% (For Gloss colors) 29.4 – 33.9% (For Semigloss colors) 27.3 – 35.2% (For Flat colors) 3. Solids by Weight: 32.6 – 40% (For Gloss colors) 36.1 – 44.6% (For Semigloss colors) 37.9 – 46% (For Flat colors) 4. Viscosity: 16 seconds minimum #4 Ford Cup 1 hour after mixing 5. DFT: 1.0 – 1.2 mils 6. Theoretical Coverage @ 1 mil dft: 415 - 565 ft²/gallon (varies by color and gloss) 7. Gloss @ 60° SAE-AMS-STD-595A Colors 1XXXX (80 minimum) SAE-AMS-STD-595A Colors 2XXXX (15 – 30) SAE-AMS-STD-595A Colors 3XXXX (8 maximum) 8. Dry Time Set to Touch: 1 hour max.. Dry Hard: 7 hours max. Complete Cure: 7 days 9. Pot Life 8 hours maximum 10. Mix Ratio 1:1 by volume 	<p>Steel: Surface must be clean and free of grease, dirt, oil, rust and other contaminants that could interfere with proper adhesion.</p> <p>Aluminum: 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: Clean and remove surface contamination including oxidation. .</p> <p>Reduction: Reduce with MIL-DTL-81772 Type 2 or Type 4 as required.</p> <p>Conventional Spray: Atomizing Pressure: 45 – 55 psi Pot Fluid Pressure: 10 – 20 lbs.</p> <p>Airless Spray: Tip Size: 0.011 – 0.015” orifice Atomizing Pressure: 1800 - 2200 psi</p> <p>Clean-up: Clean tools and equipment immediately after use with MEK, MAK or MIL-DTL-81772 Type 2 or Type 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>

Randolph Products Company

33 Haynes Circle

Chicopee, MA 01020

Telephone 413-592-4191

Facsimile: 413-594-7321



1 part Component A
1 part Component B

11. VOC

3.5 – 4.7 lbs/gallon (415 – 565
grams/liter) (varies by color and gloss)

12. Induction Time

1 hour

13. Shelf Life

Two years from date of manufacture