



Simco
We've Got You Covered

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EPOXY-POLYAMIDE TOPCOAT
MIL-DTL-24441
FORMULA 151 THROUGH 158, TYPE-III

1. MIL-DTL-24441/21A (SH) Formula 151, Haze Gray,
2. MIL-DTL-24441/22A (SH) Formula 152, White
3. MIL-DTL-24441/23A (SH) Formula 153, Dark Gray RO1.8
4. MIL-DTL-24441/24A (SH) Formula 154, Dark Gray RO3.6
5. MIL-DTL-24441/25A (SH) Formula 155, Dark Gray RO6
6. MIL-DTL-24441/26A (SH) Formula 156, Red
7. MIL-DTL-24441/27A (SH) Formula 157, Gray No. 50
8. MIL-DTL-24441/28A (SH) Formula 158, Yellow

Description: These are two-part Epoxy-Polyamide, VOC Compliant Coatings specifically formulated for painting particular areas aboard ships such as bridges, exterior under water hull. These coatings are also suitable to be used as topcoats for exterior and interior application on aircrafts and ground support system.

Principal Characteristics:

- Can be applied up to 6.0 Mills DFT.
- Excellent resistance to weather, moisture, petroleum products and mild chemicals.
- Good impact resistance

Technical Data

Color & Finish:	As per Formula No.; Satin to Semi -Gloss Finish
Mass Density:	11.0 ± 0.5 lbs./gal.
Solids by Volume:	Approx. 63 ± 2%
Flash Point (mixed):	Base 99°F (38°C) / Hardener 108°F (42°C)
Theoretical Spreading Rate:	Approx 1,000 sq. ft. /gal. @ 1 Mil D
Recommended DFT	4-5 Mills (100-125 Microns)
Volatile Organic Compound (VOC):	2.50 lbs./gal.; 300 grm./ltr.
Temperature Resistance	250°F (121°C)
Pot Life	4 hours @ 73°F
Shelf Life	12 months
Flash Point:	Base 99°F (38°C) / Hardener 108°F (42°C)
Packaging:	A two Component material with base and curing agent supplied in: 1 & 5 Gallons Containers 1:1 by volume.
Drying Time @ 75°F:	
To touch	2-3 hours
Dry hard	6-8 hours
Max interval before overcoating	7 days
To full cure	7 days

Recommended Substrate Conditions:

Steel: Properly Primed substrate with Zinc Rich Epoxy or Epoxy Polyamide Green Primer, Formula-150. The surface must be perfectly dry.

Instructions for Use:

Power agitate base component to uniform consistency before combining, then again after combining. Do Not vary proportions.

Substrate Temperature:

during application and the first 24 hours of curing, the substrate temperature must be above 41°F (5°C) and at least 5°F (3°C) above the dew point.

Mixing Instructions:

Ratio: base to hardener 54-46 by weight / base to hardener 50-50 by volume

The temperature of the mixture of base and hardener during mixing and application should be above 59 °F (15°C), otherwise more solvents must be used to obtain application viscosity. This results in lower sag resistance and slower cure. Thinner should be added after mixing the components.

Very good mechanical mixing of base and hardener is essential in view of the paste consistency.

Conventional Spray:

Manufacturer:	<u>DeVilbiss</u>	<u>Binks</u>
Gun Model	MBC or JGA	#18 or #62
Tip-Air Cap Combination	704E	66PE

Fluid hose should be 3/8" I.D. with a maximum length of 50 feet. Pot should always have dual regulation and be kept at same elevation as spray gun.

Airless Spray:

Manufacturer:	<u>Graco</u>	<u>Binks</u>	<u>DeVilbiss</u>
Gun Model:	<u>205-590</u>	<u>Model 500</u>	<u>JGN-501</u>
Pump:	<u>Bulldog</u>	<u>Mercury 5C</u>	<u>QFA-519</u>

Hose should be 3/8" I.D. minimum, but 1/4" whip end section may be used for ease of application. A maximum length of 100 feet is suggested. Best results will be obtained using a .018"-.021" tip at 2400-2700 p.s.i.

Thinning Requirement:

- Recommended Thinner : MIL-24441 Thinner
- Airless Spray : 0-10% by Volume
- Conventional Spray : 5-15% by Volume
- Roller And Brush : 0-5% by Volume
- Clean-up Thinner : MIL-24441 Thinner

Safety Precautions:

- (A) Use normal precautions such as gloves, facemasks.
- (B) Adequate ventilation must be maintained.
- (C) Explosion proof lights & electrical equipment.
- (D) Non-Sparking shoes & tools for workers in area.
- (E) This product contains flammable materials. Forbid all flames, smoking and welding in work area.
- (F) Avoid breathing of vapor, contact with skin or eyes. If product comes in contact with skin or eyes, wash thoroughly with water and obtain medical attention.

Non-Warranty:

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