



Simco
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EPOXY POLYAMIDE ZINC PRIMER

MIL-DTL-24441/19B (SH) **FORMULA 159, TYPE-III**

Description: This Epoxy-Polyamide two component Zinc Rich Coating is designed to conform the specific composition and performance requirement of Federal Specification MIL-DTL-24441/19B (SH) Formula-159, Type-III and is recommended to be used for painting land and marine structures.

Principal Characteristics:

- Excellent rust preventative properties in adverse or chemically polluted atmospheres.
- Easy application by airless spray up to 4.0 mils (100 Microns) dry film thickness.
- Good adhesion properties on sandblasted steel where a hard durable chemical resistant nonporous coating is desired.
- Excellent water and weather resistance for interior and exterior use.
- Good impact resistance

Technical Data

Color & Finish:	Gray; Flat
Mass Density (mixed):	Approx 24.0 lbs./gal.
Solids by Volume:	Approx. 65.0%
Zinc Dust Pigment (ASTM D520, TYPE-I):	80%
Flash Point (mixed):	95°F
Theoretical Spreading Rate:	1040 sq. ft./gal. @ 1 Mil D
Recommended DFT	3-4 Mil (75-100 Microns)
Volatile Organic Compound (VOC):	2.5 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 Mix ratio 4:1 by volume.
Drying Time @ 75°F:	
To touch	2 hours
Dry hard	6 hours
Max interval before overcoating	7 days
To full cure	7 days

Recommended Substrate Conditions:

Steel: Blast cleaned to a minimum grade SSPC-SP10 (SA2 ½) 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 4:1 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:

DeVilbiss

Binks

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:

Graco

Binks

DeVilbiss

Gun Model:

205-590

Model 500

JGN-501

Pump:

Bulldog

Mercury 5C

QFA-519

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

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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