



Simco
We've Got You Covered

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MIL-DTL-24441/20A (SH)
GREEN PRIMER FORMULA 150, TYPE-III

Description:

This Epoxy-Polyamide two component lead and chromate free coating is designed to conform the specific composition and performance requirement of Federal Specification MIL-DTL-24441/20A (SH) Formula-150, Type-III and is recommended to be used for painting land and marine structures.

Principle Features:

- Excellent rust preventative properties in adverse or chemically polluted atmospheres.
- Easy application by airless spray up to 6.0 mils (150 Microns) dry film thickness.
- Good adhesion properties on steel, concrete, fiberglass and aluminum where the surface is properly prepared.
- Excellent water and weather resistance for interior and exterior use.
- Good impact resistance.
- Resistance to spill/splash mild chemicals.

Technical Data

Color and Finish:	Green, Flat
Mass Density:	Approx 11.25 lbs./gal.
Solids by Volume:	Approx. 65.0%
VOC:	2.25 lbs./gal. , 270 gm./ltr.
Theoretical Spreading Rate:	1040 sq. Ft. /gal. @ 1 mil
Recommended DFT:	3-4 Mil (75-100 Microns)
Touch dry after:	2 Hrs.
Dry hard after:	6 Hrs.
Max. Interval Before Overcoating:	7 Days
Full Cure after:	7 Days
Temperature Resistance:	250°F (121°C)
Shelf Life:	12 months
Flash Point:	Base 99°F (38°C) Hardener 108°F (42°C)
Package:	A two Component material with base and curing agent supplied in 1 and 5 Gallons Containers. Mix ratio in equal volumes.
Pot Life:	5 Hours At 73 °F (23 °C)

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 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

DeVilbiss
Binks

Model

MBC or JGA
#18 or #62

Air Cap

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

DeVilbiss
Binks
Graco

Model

JGN-501
Model 500
205-590

Pump

QFA-519
Mercury 5C
Bulldog

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

Caution:

Contains flammable solvents. Keep away from sparks and open flames. Use only grounded explosion proof equipment in accordance with the National Electric Code. Workmen must use nonferrous tools; wear conductive and non-sparking shoes in areas where explosion hazards exist. In confined areas, workmen must wear fresh airline respirators, protective clothing and gloves. Avoid contact with skin, breathing of vapor or spray mist ingestion. Keep out of reach of children.

Non-Warranty:

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