



Simco Coatings Inc.

Manufacturer of Military Spec.,
Corps of Engrs. Spec, Industrial, &
Marine Coatings

TECHNICAL DATA SHEET

MILGUARD-24631/1C FORMULA 184 EPOXY BLACK CAMOUFLAGE PAINT FOR SUBMARINES

DESCRIPTION/CONFORMANCE: A two-part epoxy/amine, lead & chromate free, VOC compliant coating designed to conform the specific composition and conformance requirements of Military Specification MIL-DTL-24631/1C (SH), Navy Formula-184, Type-I, Black R0 1.8.

PRINCIPAL CHARACTERISTICS AND SUGGESTED USE:

- Excellent water and weather resistance for interior and exterior use.
- Good impact resistance.
- Resistant to spill/splash mild chemicals
- Easy applications by airless spray up to 4.0 mils (100 Microns) dry film thickness.
- Suitable to be used on areas above the water line where color retention is essential.
- Has excellent adhesion to both rubber and steel substrates and is; therefore, recommended for application at rubber and steel interfaces to maintain continuous camouflage on submarines.

TECHNICAL DATA

COLOR & FINISH:	Black, Lusterless (Camouflage)
GENERIC TYPE:	Epoxy Resins and Amine Curing Agent
% WEIGHT SOLIDS (MIXED):	71.0 ± 1
% VOLUME SOLIDS (MIXED):	60.00
VOLATILE ORGANIC COMPOUNDS (VOC):	2.80 lbs./gallon & or 340 g/l
THEORETICAL SPREADING RATE:	Approx. 900 sq.ft. /gallon
RECOMMENDED DRY FILM THICKNESS:	3-4 Mils
PACKAGING:	A Two Component material with base and curing agent supplied in separate packages. Mix ratio in equal volume
POT LIFE MIN:	3 Hrs.
SHELF LIFE:	12 Months from the date of manufacture.
FLASH POINT:	81°F (27°C)
REDUCER/CLEAN-UP:	Epoxy Thinner # MIL-T-81772, Type II
GLOSS 60 DEGREE SPECULAR %:	<=20

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211 Gunther Ln., Belle Chasse, Louisiana 70037 U.S.A.

Tel: (504) 393-9455 Fax: (504) 433-1406 Toll Free: 1-866-95SIMCO

e-mail: sales@simcocoatings.com web: www.simcocoatings.com



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DRY TIME @ 75°F:

A.) SET TO TOUCH TIME (HRS.)MAX:	6 Hrs.
B.) DRY HARD TIME (HRS.)MAX:	24 Hrs.
C.) TO SERVICE:	
(i) (Non Immersion)	3-4 Days
(ii) (Immersion)	7 Days

SURFACE PREPARATIONS:

All surfaces to be coated must be dry and cleaned free of rust, oil, dirt, soil and other contaminants. For general use steel should be blast cleaned to a minimum of commercial grade SSPC SP-6". For severe service and sustained immersion, "Near White" SSPC SP-10 is recommended.

For best results apply when surface temperature is above 50°F (10°C) and a minimum of 5°F (3°C) above the dew point, and relative humidity is no greater than 85%.

APPLICATION:

Spray recommended. Brush or roller may be used with additional thinning required. Care should be taken to achieve required film build. Thoroughly mix each component, separately. Pour Component B into Component A with constant stirring until 1:1 ratio by volume is achieved. Allow the mixture to stand 30-45 minutes as the induction period before using.

CONVENTIONAL SPRAY: DeVilbiss MBC-510 spray gun "E" Fluid Tip #704, #765 or #78 Air Cap.

AIRLESS SPRAY: Use of spray tips with 0.015" to 0.021" orifice is suggested depending on available pressure and job conditions, with a minimum of 2800 PSI tip pressure.

SAFETY PRECAUTIONS:

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

NON-WARRANTY:

The technical data listed herein has been compiled for your convenience and guidance, and is based upon our experience and knowledge. However, since we have no control over the use of this information or of this product, no warranty, expressed or implied, is intended or given. Simco Coatings, Inc., assumes no responsibility whatsoever for coverage, performance, or any other damages, including injuries resulting from use of this information or of products recommended herein.

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