



Products Techniques, Inc.

Primers – Low VOC

Product: Epoxy Primer MIL-P-23377E – High Strontium Prime-All Primer

Other Products used with: Air Dry Wash primer; Reducer PT-1003 Type 2 or PT-1002

Typical Uses

This is a low VOC epoxy polyamide solvent primer which conforms to MIL-P-23377 Rev. E. This coating is *highly* recommended for use on aluminum and all plated or unplated metallic surfaces to insure maximum protection against corrosion. This primer also insures maximum adhesion of PTI TUF/FILM coating, or any other paint or lacquer finish coats.

Physical Properties

Weight Per Gallon	Component “A” 12.5 to 13.5 Component “B” 9.5 to 10.5
Shelf Life (in a controlled environment)	1 year
Pot Life	8-12 hours

Resistance Properties

Salt Spray per ASTM B117	1000+ Hours
Humidity (Filiform)	1000+ Hours

Chemical Properties

Chemical Resistance:

Lubricating Oil 24 hour immersion @ 250F	No defects
Hydraulic Fluid 24 hour immersion @ 150F	No defects
Methyl Ethyl Ketone-Soaked Cloth 100+rubs	Passes
DS2 (1,5-Dichloropentane)	Passes
Full Chemical Resistance after	7 days

Application

Cleaning

All parts must be cleaned by a recognized cleaning specification (such as Federal Test Method Standard, #141, Method 2013) and pretreated with chemical conversion coating materials to produce a pretreatment coating equivalent to MIL-C-5541 and/or primed with a an acid wash primer equivalent to **MIL-C-8514 (PT-402)**.

Use of Solvent

Acetone can be used as exempt solvent to maintain 340 G/L VOC limitation. If no limitations are required, **PT-1002 or PT-1003 Type II**, may be used.



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Mixing

This primer system consists of Component “A” pigmented or clear resin system and Component “B” hardener.

Stir each component well before mixing.

1. Add 1 volume of Component “A” to 1 volume of Component “B” and mix thoroughly Allow to stand one (1) hour at room temperature before using. Reduce with exempt solvent(s) if required (see use of solvent above).
2. Mix only an amount that can be used in one day.

Method of Application

This low VOC primer builds quickly. Thick films are detrimental to good adhesion. Therefore, spray a thin film, .6 to .9 mils by cross spraying.

Curing

Air dry for minimum of one (1) hour before applying top coat. Do not bake top coats over 400F.

NOTE: The foregoing is accurate to the best of our knowledge. However, conditions of use, storage and handling do affect the performance of the coating. Since these factors are beyond our control we do not guarantee individual results. For satisfactory results, PTI reducers must be used as recommended.