PRODUCT INFORMATION DATA SHEET

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02Y024 (02-Y-24) MIL-P-23377E TY I CL I EPOXY POLYAMIDE PRIMER

Product Information

Specifications **MIL-P-23377E Type I Class I**

Description Chemically cured, strontium chromate, two-component epoxy polyamide primer

Features
- Corrosion inhibiting
- Chemical and Solvent Resistant
- Resistant to immersion in Hydraulic Fluids, Lubricating Oils, Phosphate Ester Based Hydraulic Fluids, Skydrol and Distilled water

Color **Yellow**

Reducer None required. May be reduced with IS-237*

Mix Ratio 1 part 02Y024 base by volume to 1 part 02Y024CAT catalyst by volume

Kit size	02Y024 base	02Y024CAT
GK	1 can filled @ 128oz / 3.8 L	1 can filled@ 128oz / 3.8 L
QK	1 can filled @ 32 oz /946 ml	1 can filled @ 32 oz / 946 ml
PK	1 can filled @ 16 oz / 473 ml	1 can filled @ 16 oz / 473 ml

Pot Life 8 hours at 75° ± 10°F

Viscosity initial: 18±4 seconds, max, # 4 Ford Cup
Pot life: 22 seconds, max, # 4 Ford Cup

Induction Time 30 minutes

Application Thickness 0.6 – 0.9 mils dry film thickness

Storage Stability 1 year from DOM when stored between 35 - 115°F

Recommended Storage Store indoors between 70 – 90°F in original unopened containers.

*Use only if needed and if local and state VOC limits allow.

Characteristics*

Characteristics	Base	Catalyst	Admixed
Weight per gallon (lbs)	10.3	7.00	8.6
% Solids by weight	60.0%	20.3%	43.9%
% Solids by volume	39.5%	17.2%	28.3%
Coatings VOC (g/L)	492	668	580
Coatings VOC (lbs/gal)	4.1	5.6	4.8
Material VOC (g/L)	492	668	580
Material VOC (lbs/gal)	4.1	5.6	4.8

Dry film density:** 1.60g/cc
Theoretical Coverage per gallon as applied:** 452sq. ft.
Theoretical Dry Film Weight per gallon kit as applied: 3.78/sq. ft (0.00833-lbs/sq. ft)

* Characteristics are calculated based on product formulas and ingredient characteristics as reported to Deft, Incorporated by raw material suppliers. Values reported are not specification values. They are presented for general information only.
** Dry film density and theoretical coverage based on proper application of coating at 1 mil dry film thickness and 100% transfer efficiency.

Dry Times

Dry to Topcoat: 6 hours, max **Tack Free: 1** hours, max
Dry Hard: 6 hours, max **Full Cure:** 7 days, max

Note: Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% Relative Humidity. After 8 hours cure, it is recommended to solvent wipe the entire primed surface before top coating. After 24 hours of cure, it is recommended to scuff sand the entire primed surface for optimal inter-coat adhesion. Ref: T.O. 1-1-8 Section 6.12.6.5

Forced Dry Schedule

For dry to stack conditions only. Allow a minimum of 15 minutes flash off time at ambient temperatures* prior to exposing painted parts to high temperatures. Complete testing should be done prior to use. Below are suggested starting points. Other variables may affect these cure schedules.

Temperature	Time
120°F	45 minutes
140°F	30 minutes
160°F	20 minutes
180°F	15 minutes

* Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity.

Mixing and Thinning

GK & QK: Stir or shake the base component to ensure any pigment, which may have settled on the bottom of the can, has been fully incorporated into the base. Do not stir or shake the base component longer than 5 minutes. Slowly add the one volume of catalyst to one volume base component. Mix by hand stirring, paint shaker or mechanical mixing to ensure the base/catalyst mixture is homogeneous. DO NOT SHAKE OR MECHANICALLY MIX MATERIAL FOR LONGER THAN 10 MINUTES. Constant agitation of the material during spray application is recommended.

Application Equipment

Conventional, Air, Air Assisted Airless, HVLP, Electrostatic spray equipment may be used to apply this material. For your application, please contact the equipment manufacturer for more specific information on Conventional, HVLP or Electrostatic spray applications, and recommendations on hose diameter and lengths.

Packaging, Yields, Shipping Weight

This material is available in the follow kit sizes:

Kit size	Approx. Yield (Mixed)	Approx. Shipping Weight
GK	2 gallon (7.6 L)	22.0 lbs (10.0 kg)
QK	2 quarts (1.9L)	6.0 lbs.(2.7 kg)
PK	2 pints (946ml)	3.0 lbs (1.4 kg)

Additional kit sizes are available upon request.

Equipment Cleanup

Use IS-237 Epoxy Reducer (MIL-T-81772B Type II) to remove any liquid or residual primer from equipment. Once material has cured, use an approved chemical paint removal system to strip primer from parts and equipment

Safety

Refer to the product label or Material Safety Data Sheet (MSDS) for each component for Personal Protective Equipment and Proper Handling.

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