

SOCOGLAZE 23377-1-YC2

High Solid Epoxy Primer



Product SOCOGLAZE 23377-1-YC2 High Solid Epoxy Primer

Item Class Epoxy Primer

SOCOGLAZE 23377-1-YC2 is a high solid urethane compatible two component epoxy polyamide primer. In addition to promoting adhesion, it offers an excellent barrier to corrosion. This primer has excellent chemical and solvent resistant properties. It is specially recommended to inhibit and protect against, corrosion of aluminum and other plated and un-plated metallic surfaces. It may also be utilized on composite surfaces.

Specifications This product is qualified to the following specification:

MIL-PRF-23377K Ty I, CI C2

Catalyst & Additives Catalyst/Activator Thinner

| | |
|-----|---------------------|
| 668 | MIL-DTL-81772 Ty II |
|-----|---------------------|

Surface Preparation Prepare substrate per OEM requirements. Contact your local 3Chem representative or distributor for assistance.

Mixing Instructions

| Base | Catalyst/Activator | Thinner (Optional) | Mix Ratio |
|----------------------|--------------------|---------------------|-----------|
| SOCOGLAZE 23377-1YC2 | 668 | MIL-DTL-81772 Ty II | 1:1 |

Shake Comp. "A" (Base) for 10-15 minutes. Mix comp. "A" (Base) and comp. "B" (Catalyst) 1:1 by volume. No induction time is necessary. However, make sure to thoroughly mix admixed material for at least 5 minutes. Admixed material may be reduced to desired viscosity using 3CHEM thinner MIL-DTL-81772 Ty II, using caution as use of solvents will increase VOC. Use of thinner is optional and not required.

Induction Time Although no induction time is needed. Once mixed, ensure that admixed material is continuously stirred for at least 5 minutes before proceeding.

Spraying Viscosity 18-24 Seconds with #2 Zahn cup

Pot Life 10 Hours @ 21° Celsius, 70° Fahrenheit

Film Thickness 0.6 - 0.9 mils DFT for military applications

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Application Instructions

| Temperature and Humidity | Minimum | Maximum |
|--------------------------|---------|---------|
| Temperature Celsius | 11° | 35° |
| Temperature Fahrenheit | 52° | 95° |
| Humidity | 33% | 74% |

Spray Equipment

| Spray Gun Type | Tip/Nozzle Size | Cap Pressure | Pot Pressure |
|------------------|-----------------|----------------|--------------|
| Conventional Air | 1.3 - 1.6 mm | 40 to 60 psi | 10 to 20 psi |
| HVLP | 1.4 - 1.6 mm | 10 psi Maximum | 10 to 20 psi |
| Electrostatic | 1.2 - 1.5mm | 45 to 60 psi | 10 to 40 psi |

Number of Coats:

Apply one even wet coat within film thickness recommendations.

Note: Maximum overcoat window without mechanical reactivation is 48 hours.

Application Instructions Dry times: @ 21° Celsius, 70° Fahrenheit

| Dust Free | Dry to Tape | Dry to Topcoat | Dry Hard | Full Cure |
|------------|-------------|----------------|----------|-----------|
| 30 Minutes | 2 Hours | 1 Hour | 2 Hours | 7 Days |

Force cure option: Dry times may vary slightly depending on drying and application conditions.

Primer may be force cured for up to 30 minutes @ 60°C (140°F)

Theoretical Coverage 469 sq. ft / gallon @ 1 mil 8-9-m2 / liter @1 mil
*Coverage based on 100% transfer efficiency rate

Color Light Green: SOCOGLAZE23377-1YC2G1
Yellow: SOCOGLAZE23377-1YC2Y

Gloss 10 maximum @ 60 degrees

Volatile Organic Compound 5.20 lb/g

Shelf Life 24 Months (When stored in climate-controlled environment between 60-80° F)

Safety Instructions Always read material safety data sheet (SDS) and product label before utilizing this product. Product SDS is available upon request.

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