

# 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, Cl C2

<b>Catalyst &amp; Additives</b>	<b>Catalyst/Activator</b>	<b>Thinner</b>
	668	MIL-DTL-81772 Ty II

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

<b>Mixing Instructions</b>	<b>Base</b>	<b>Catalyst/Activator</b>	<b>Thinner (Optional)</b>	<b>Mix Ratio</b>
	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 @ 70° F (21° C)

**Film Thickness** DFT: 0.6 - 0.9 mils (12-23 microns) per coat

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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 time @ 70° F (21° C)

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

**Force Cure:** Allow primer to air dry for 15 minutes at 77° F (25° C), then cure for 30 minutes at 120° F (49° C).

**Theoretical Coverage** 469 sq. ft / gallon @ 1 mil 11.5 m<sup>2</sup>/l @ 25 microns  
\*Coverage based on 100% transfer efficiency rate

**Color**  
Light Green: SG-23377-1YC2G1  
Dark Green: SG-23377-1YC2G2  
Yellow: SG-23377-1YC2Y

**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 / 16-27° C)

**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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