Formula 156 Topcoat (MIL-DTL-24441 Type IV)

Epoxy

PRODUCT DESCRIPTION

A two pack epoxy finish. Exhibits excellent abrasion, chemical and solvent resistance.

INTENDED USES

For use as a tough cosmetic finish for above/below water areas.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Color	5906-Red (Approx. FSC# 20152)
Finish/Sheen	25 max
Part B (Curing Agent)	5912
Volume Solids	63% ±2% (ASTM D2697-86)
Mix Ratio	1 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	5 mils dry (7.9 mils wet), 4 - 6 mils dry practical range equivalent to 6.4 - 9.5 mils wet
Theoretical Coverage	202 ft²/US gal at 5 mils dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point	Part A 99°F; Part B 102°F; Mixed 99°F (Setaflash) (ASTM D-3278)
Induction Period	2 hours @ 50 - 60°F; 1.5 hours @ 60 - 70°F; 0.5 hours above 70°F.

Drying Information	41°F	50°F	77°F	95°F
Touch Dry [ASTM D1640 7.5.1]	5 hrs	4.5 hrs	3 hrs	45 mins
Hard Dry [ASTM D1640 7.7]	26 hrs	20 hrs	8 hrs	6 hrs
Pot Life			5 hrs	

Overcoating Data - see limitations

	Substrate Temperature							
	41°F		50°F		77°F		95°F	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Formula 156 Topcoat (MIL-DTL-24441 Type IV)	26 hrs	7 days	20 hrs	7 days	8 hrs	7 days	6 hrs	5 days

REGULATORY DATA

VOC 340 g/lt (2.84 lb/US gal) as supplied (EPA Method 24)

Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

MIL SPEC MIL-DTL-24441C/35A(SH), Type IV.

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SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

SURFACE PREPARATIONS

Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other foreign matter by "solvent cleaning" (SSPC-SP1).

Unpainted surfaces:
Prepare surface and apply recommended primer. Apply one or more coats of Formula 156 Topcoat (MIL-DTL-24441 Type IV) as specified. (Consult the relevant primer data sheet for surface preparation and overcoating information.)

Previously Painted Surfaces:
Remove all mill scale, loose rust, loose paint and other foreign matter by "Hand or Power Tool Cleaning" (SSPC-SP2 or SP3, respectively).
Sand or "Brush Blast" (SSPC-SP7) any hard glossy areas until dull. Spot prime bare areas as recommended and apply one or more coats of Formula 156 Topcoat (MIL-DTL-24441 Type IV) as specified. Consult the relevant primer data sheet for specific surface preparation and overcoating information. Check integrity of existing coating system and apply a representative test patch to confirm compatibility. Consult your International Paint representative for procedures.

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APPLICATION	Apply by conventional or airless spray. Application by other methods, brush or roller, may require more than one coat and is suggested for small areas only. Strain material through a minimum 60 mesh screen before application. Apply at 8.0 mils wet which will yield 5.0 mils dry film thickness. Consult the following equipment recommendations or utilize suitable equal.
Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Part A with a power agitator, (2) Agitate Part B with a power agitator, (3) Combine entire contents of Part A and B and mix thoroughly with a power agitator. Allow the coating the appropriate sweat-in period.
Thinner	DO NOT THIN BEYOND YOUR STATE'S COMPLIANCY. Material is supplied at spray viscosity and normally does not need thinning. If thinning is necessary, thin up to a maximum of 8 ounces per gallon with International 5822 thinner.
Airless Spray	Minimum 28:1 ratio pump; 0.015" - 0.019" (381-483 microns) orifice tip; 3/8" (9.5 mm) ID high pressure material hose, 60 mesh tip filter.
Conventional Spray	DeVilbiss MBC-510 gun E tip and 704 air cap; 3/8" (9.5 mm) ID material hose; double regulated pressure tank with oil and moisture separator.
Brush	Use appropriate size China bristle brush.
Roller	Use All Purpose Roller cover with 3/8" (9.5 mm) smooth to medium nap. Prewash roller cover to remove loose fibres prior to use.
Cleaner	International 5822
Work Stoppages and Cleanup	Clean all equipment immediately after use with International 5822 or International GTA415 (USA) thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety & Environmental standards and regulations.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapor concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.
EMERGENCY CONTACT NUMBERS:
USA/Canada - Medical Advisory Number 1-800-854-6813
Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191
R.O.W. - Contact Regional Office

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LIMITATIONS

Apply in good weather when air and surface temperatures are above 41°F. Surface temperatures must be at least 5° F above dew point. For optimum application properties, bring material to 70-81°F prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage between 40 and 100°F.

If more than 7 days elapses between coats, apply 1-2 mils of tack coat of any MIL-DTL-24441 product before topcoating.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
10 US gal	5 US gal	5 US gal	5 US gal	5 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT

Unit Size	Unit Weight
10 US gal	123.7 lb

STORAGE

Shelf Life: 24 months minimum from date of manufacture when maintained in protected storage at 40-100°F. Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY

Consult International Paint.

IMPORTANT NOTE