



TECHNICAL DATA SHEET

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BUTOXY 33RC
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PRODUCT DESCRIPTION:

One type of ready-mixed, single-component Epoxy Based coating. This product is specifically formulated for corrosion control of magnesium and other metals.

TYPICAL PROPERTIES:

- (1). COLORS..... Clear & Full Spectrum.
- (2). **ELONGATION:**
Passes 1/8" conical mandrel method per ASTM D-522-60.
- (3). **SALT SPRAY FOG METHOD ASTM-117-73:** No blistering, cracking, softening or de-lamination of film. No rust creepage at scribe and no rusting at edges after 500+ hours.
- (4). Excellent Corrosion Resistance
- (5). **PENCIL HARDNESS:** 4H
- (6). Excellent Solvent, Chemical and Heat Resistance.
- (7). Cures within 15 minutes at 400 degrees F.
- (8). **WEIGHT/GAL:** 8.23 lbs/gal
- (9). **SOLIDS(Volume):** 34-36%
- (10). **SPRAYING VISCOSITY:** 16-20 Seconds #2 Zahn Cup.

APPLICATION AND REDUCTION:

- (1). Allow part to cool if masking is required. High temperature tape shall be used.
- (2). Place part in oven and heat to 400 degrees F for 30 minutes.
- (3). Cool magnesium castings in air to a temperature of 100 degrees to 120 degrees F maximum.
- (4). Adjust spray or dip consistency with T-77 Thinner by thinning 1:1 by volume and stir well before spraying.
- (5). Coat all surface, both exterior and interior, to a thickness of 0.0002 to 0.0006 inch. Un-machined exterior surfaces may receive a maximum coating thickness of 0.0015 inch.
- (6). Air dry coating for 25-30 minutes, then bake in a **preheated** oven at 400 degrees F for 25 to 30 minutes.
- (7). Cool parts to room temperature and unmask as necessary. Re-oil unmasked areas in accordance with CP5015.



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STORAGE: Store indoors under normal conditions after from heat or flame. Temp: 40-90 Deg Fahrenheit Shelf life under normal conditions is 6 months from Date of Manufacture.