



TECHNICAL DATA SHEET

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MIL-DTL-450D BITUMINOUS
COATING

PRODUCT DESCRIPTION:

A bituminous, asphalt solvent type coating for application on the interior surfaces of ammunition items such as bombs, shells, rockets, and mines prior to being filled with explosives.

TYPICAL PROPERTIES:

- (1). **COLOR**..... Black
- (2). **SHELF LIFE**..... 1 Year From Date of Mfg
- (3). **DRYING TIME:**
 - TYPE I: Tack Free - Within 30 Minutes
 - TYPE II: Tack Free - Within 1 Hour
 - TYPE III: Tack Free - Within 8 Hours

* Drying times will be affected by ambient or substrate temperatures, excessive film build thicknesses, or insufficient ventilation.

- (4). **SOLIDS (WEIGHT)**:..... 45 - 55%
- (5). **VISCOSITY:** (#4 Ford Cup)
 - TYPE I: 15 - 28 Seconds
 - TYPE II: 120 - 190 Seconds
 - TYPE III: 150 - 250 Seconds

APPLICATION AND REDUCTION:

Mix thoroughly before use. Thin with either a blend of TT-N-95 or just TT-X-916 Xylene (Xylol) for brushing or spraying up to 1 pint per gallon or as needed for proper flow and atomization. May be used directly on properly prepared, clean, metal substrates. For conventional spraying, a minimum 3/8" I.D., 50' maximum material hose and .086" I.D. fluid tip and appropriate air cap is recommended. For airless spraying, a minimum 3/8" I.D. material hose and .023-.035" spray tip size, 2300-2500 output psi, is recommended. For brushing, use a medium bristle brush. For rolling, use a lambskin or equivalent quality cover with a short nap(1/4" - 3/8")