



TECHNICAL DATA SHEET

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MIL-DTL-53022D
EPOXY PRIMER

PRODUCT DESCRIPTION:

A fast drying, two component, corrosion inhibiting, lead and chromate free epoxy primer. Meets air pollution requirements (Rule 102) and may be used to replace MIL-P-52192 and MIL-P-23377 where exposure to lead or chromate pigments is not permitted.

TYPICAL PROPERTIES:

- (1). **COLORS**..... White & #26622 Gray
- (2). **TOTAL SOLIDS**..... 60% Minimum
- (3). **PIGMENT**..... 38% Minimum
- (4). **VEHICLE SOLIDS**..... 22% Minimum
- (5). **Excellent Corrosion Resistance**
- (6). **Excellent Solvent, Chemical and Heat Resistance.**
- (7). **GLOSS**..... 10 - 30%
- (8). **DRY-TO-TOUCH**..... Within 5 Minutes
- (9). **DRY HARD**..... Within 90 Minutes
- (10). **DRY THROUGH**..... Within 4 Hours
- (11). **VISCOSITY**..... 63 - 73 KU
- (12). **TY.IV/V.HAPS Free w/ enhanced Corrosion Resistance**
VOC'sS: <60 G/L

APPLICATION AND REDUCTION:

MIL-DTL-53022D is normally applied over well cleaned, bare substrates. Mix FOUR PARTS epoxy primer with ONE PART of the catalyst provided in the kit. Allow 30 to 45 minutes wetting time. Spray one cross coat to achieve a dry film thickness of 0.3 0.5 mils. Use admixed material within 8 hours. Dry to touch in 5 minutes, to handle in 90 minutes. For brushing and rolling, thin with MIL-T-81772B Type 2 as needed for proper flow and ease of application not to exceed 1 pint per gallon. When thinning Ty. IV or Ty. V, it is recommended to use acetone to thin to maintain the HAPS free low VOC nature of the coating.