



# TECHNICAL DATA SHEET

TECHNICAL DATA SHEET  
TT-P-645B  
ZINC MOLYBDATE PRIMER  
(AMS3117)  
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**PRODUCT:** A one-component, alkyd base, corrosion-inhibiting zinc molybdate primer.

**DESCRIPTION:** TT-P-645B Zinc Molybdate Primer is a single component, zinc-molybdate pigmented primer primarily intended for use as a general primer for steel and properly prepared aluminum.

**PROPERTIES:**

SOLIDS(Weight)..... 78.8% Minimum  
SOLIDS(Volume)..... 56% Minimum  
WEIGHT / GALLON..... 13.3 - 13.7 Lbs  
COLORS..... Yellow or Green  
THINNER..... MIL-T-81772B TY.III  
SHELF LIFE..... 1 Year

**DRYING TIME:**

TO TOUCH..... Within 6 Hours  
TO RECOAT..... 6-8 Hours  
TO CURE..... 14 Days

**ADVANTAGES:**

- (1). Corrosion Inhibiting
- (2). High Solids, Low VOC
- (3). Fast Dry
- (4). Use on ferrous and non-ferrous metals
- (5). Meets Government Specification TT-P-645B
- (6). Meets AMS 3117 Specification



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**SURFACE PREPARATION:** *Steel, Non-Ferrous Metals & Galvanizing.*

Surface to be coated must be clean, dry, and free of all foreign contaminants including grease, oil, dirt and paint. Clean in accordance with SSPC-SP-1. Most metals should be sanded, except aluminum, which must have a base coat of pre-treatment wash primer MIL-C-8514C, followed by one wet coat of TT-P-645B. Alloys that oxidize must be lightly sanded to remove all loose material. Dirt and dust are best removed with a stiff bristle brush and by compressed air. For exterior use and non-ferrous metals, it is recommended that TT-P-645B be applied over pre-treatment coating conforming to MIL-C-8514C or DOD-P-15328D. Grease and oil should be removed by cleaning with appropriate solvents such as mineral spirits, lacquer wash thinner or xylene.

**MIXING/APPLICATION INSTRUCTIONS:**

Apply by spray, or brush/roll small areas to deposit a hiding coat of primer. A wet coat is necessary to secure maximum adhesion and corrosion inhibiting properties. For application by spray, thin sparingly with Xylene per TT-X-916 or MIL-T-81772B TY.III only as need for proper atomization. For brush or roller, use at packaged viscosity.

**PRECAUTIONS:**

KEEP OUT OF REACH OF CHILDREN.

USE WITH ADEQUATE VENTILATION.

AVOID CONTACT WITH SKIN AND EYES.

READ MATERIAL SAFETY DATA SHEET BEFORE USING.

CONTENTS ARE FLAMMABLE.