



# TECHNICAL DATA SHEET

## TECHNICAL DATA SHEET HMS15-1100 EPOXY PRIMER

### PRODUCT DESCRIPTION:

One type of two-component epoxy based primer for the aerospace industry. This product is specifically formulated for corrosion control of metals. It is normally used as a primer under HMS15-1100 Epoxy Topcoats. It has excellent solvent, chemical, corrosion and heat resistance.

### TYPICAL PROPERTIES:

- (1). **COLOR**..... #34151 Green
- (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 delamination of film. No rust creepage at scribe and no rusting at edges after 500+ hours.
- (4). **POT LIFE**..... 8 Hours @ Room Temp.
- (5). **PENCIL HARDNESS:** 4H
- (6). **THEORETICAL COVERAGE**..... 450 Sq.Ft/Gallon
- (7). **FLASH POINT:** 23 Degrees Fahrenheit
- (8). **WEIGHT/GAL:** 9.3 lbs/gal (admixed)
- (9). **SOLIDS (Weight):** 38 - 40% (admixed)
- (10). **VOLOATILE ORGANIC CHEMICALS (VOC)**.....388 G/L (Admixed Parts and A B)
- (11). **SPRAYING VISCOSITY:** As required for proper atomization (dependent on equipment being used)
- (12). **Thinner:** T-262A-66 or MIL-T-81772B Ty. II

### APPLICATION AND REDUCTION:

HMS15-1100 Primer is normally applied over well cleaned, bare metal without the use of pretreatment wash primers. By volume, mix one part epoxy primer with one part of the converter provided in the kit. Allow 45 minutes to one hour wetting/induction time. Spray one cross coat to achieve a dry film thickness of 0.8 - 1.0 mils. Use admixed material within 8 hours. Dries set-to-touch in 30 minutes, dry through 6 hours and to recoat or topcoat 2 hours. If thinning is needed, use T-262A-66 or MIL-T-81772B Ty. II Thinner.