



MIL-DTL-24441/24B

F-154, TYPE III
PAINT, EPOXY-
POLYAMIDE, DARK GRAY

TECHNICAL PRODUCT BULLETIN

PRODUCT DESCRIPTION AND USES

MIL-DTL-24441/24B is a two-component epoxy polyamide coating for use as a finish Or intermediate coating over properly prepared and previously coated surfaces.

MIL-DTL-24441/24B is VOC compliant to all currently existing regulations, including EPA NESHAP standards. It can be applied to steel, fiberglass, aluminum and concrete substrates but is generally used over previous coats of epoxy or zinc primers.

Typical usages of this product have been on marine and naval vessels, locks, and dams and as a chemical resistant industrial coating. It has outstanding resistance to petroleum products such as crude oil and various types of fuel.

MIL-DTL-24441/24B has excellent adhesion to concrete surfaces.

This product is very specific in its color requirements for particular use on marine vessels.

PRODUCT DATA

VOC Content:
2.80 lbs/gal; 340 grams/liter

Type of Material:
Epoxy Polyamide

Volume Solids:
64% +/- 2

Estimated Coverage:
1026 sq. ft./gal @ 1 mil DFT

Recommended Film Thickness:
2 - 4 mils DFT

Method of Application:
Spray, brush, or roller

Number of Coats:
One

Thinner and Clean Up Solvent:
130 Thinner

Shelf Life:
One year from DOM @ 75°F

Pot Life:
5 hours @ 77°F mixed

Dry Time:
2 hrs to touch; 6 hrs to hard @ 73° F

Flash Point:
100°F SETA closed cup

Color and Gloss:
Dark Gray; 30% maximum gloss

Mixing Ratio:
1:1 by volume

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SURFACE PREPARATION

MIL-DTL-24441/24B is generally applied over previously coated surfaces. These surfaces must be clean and dry prior to applying succeeding coats. Care must be taken to prevent the previous coat from overcuring. General application over other MIL-P-24441 type products require a recoat period of 8 to 48 hours. For periods that exceed these times, additional applications or cleaning will be required.

MIXING

This material is supplied in 2 containers of equal parts which are to be mixed 1:1 by volume. Prior to use, mix only that amount which can be used during the expected pot life. Mix thoroughly until components are uniform and allow to stand (induct) specified time before application.

Materials should be between temperatures of 60-80° F. prior to mixing. Higher temperatures will reduce potlife and lower temperatures will extend dry times.

APPLICATION INSTRUCTIONS

Apply a wet uniform film maintaining wet film requirements. The best method is to overlap each pass 50% and keep film wet. Cover all welds, seams, corners, rivets, edges, and rough spots.

Air: Airless Graco 30-1 pump, .017 tip.

Brush: Solvent resistant equipment.

Roller: Solvent resistant equipment.

Application of 4.5 mils wet will result in 3.0 mils dry.

Never apply material when dew point is within 5° F. of the temperature of the surface to be coated.

Never apply material when substrate temperature is 40° F. or less and air temperature is dropping

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