



DOD-P-15328D

PRIMER (WASH) PRETREATMENT

TECHNICAL PRODUCT BULLETIN

PRODUCT DESCRIPTION AND USES

DOD-P-15328D is a two component pretreatment primer for ferrous and non-ferrous metals intended to promote adhesion and durability of the coating system.

DOD-P-15328D is not an anti-corrosive primer and should not be used by itself. The solvent and vehicle composition of this product makes usage acceptable in areas which air pollution regulations apply.

This product also conforms to the requirements of SSPC-Paint 27 and MPI # 80.

Application should not be in excess of the recommended film thickness. Excessive film build can cause adhesion loss.

DOD-P-15328D is commonly referred to as Formula 117 Wash Primer.

PRODUCT DATA

VOC Content:
5.95 LBS/GAL.; 714 GRAMS/LITERS

Type of Material:
Vinyl Butyral

Volume Solids ± 2%:
9.9% by volume mixed; 18.5 - 21.0% by weight mixed

Estimated Coverage:
159 square feet per gallon @ 1 mil DFT

Recommended Film Thickness:
0.3 - 0.5 mils DFT

Method of Application:
Spray preferred

Number of Coats:
One

Thinner and Clean Up Solvent:
T-8 alcohol mixture

Shelf Life @ 75°F:
One year prior to mixing

Pot Life:
8 hours

Dry Time @ 75°F:
To touch - 15 minutes; to re-coat - 30 minutes

Flash Point Closed Cup:
55°F minimum

Color and Gloss:
Translucent Green; matte

Mixing Ratio:
4 parts base to 1 part acid

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DIRECTIONS FOR USE OF BASIC ZINC CHROMATE-VINYL BUTYRAL WASH PRIMER

This paint is intended to be used primarily on clean steel free of rust and scale or on clean galvanized metal; but it may be used, when specified, on steel with very slight amounts of rust bloom.

Four volumes of base shall be mixed with one volume of diluent as follows: first, break up the pigment settled in the base with a wooden paddle, mechanical stirrer, or mixer, and mix to distribute the pigment evenly throughout the base. After the base is thoroughly mixed, slowly pour one volume of the diluent into four volumes of the base with constant agitation. Do not pour off the liquid which has separated from the pigment and then add the diluent to the settled pigment to aid mixing. Material which is not mixed properly may gel and be unfit for use. The base shall be mixed with the diluent in quantities which will be applied within six to eight hours after mixing. Primer that cannot be used within a maximum of eight hours after mixing with diluent shall be discarded and not used. Screen paint before applying.

Apply the wash primer by spraying or brushing. Spraying is generally the preferred method, but brushing may be desirable over rough or poorly prepared steel. Roller coating may be used only if specified. Paint brushes should be clean and dry, or wetted with alcoholic solvents. When sprayed, the primer must be deposited on the surface wet; if dusting is encountered, move the gun closer to the surface; if already within six inches (15cm) of the surface, decrease atomizing air pressure or increase the liquid pressure, or add thinner.

Where thinning is desired isopropanol (99% grade) or butanol (normal butyl alcohol) or denatured ethanol should be used. At least 25% thinning is usually necessary to get a uniform application. Use denatured ethyl or isopropyl alcohol to clean equipment.

Apply to a dried film thickness of 0.3 to 0.5 mils (8 to 13 micrometers) dry or approximately 3 to 5 mils (75 to 175 micrometers) wet. Note that at this thickness, which should not be exceeded, the base metal will show through the coating as evidenced by uneven coloring. This is the normal appearance; do not attempt to hide the base metal completely.

When spot treating, cover only spots free of old paint. Slight overlap of existing paints is generally not harmful provided adherence of the wash primer to the old paint is satisfactory and the old paint is not lifted.

The next coat of paint may be applied as soon as the wash primer is dry, usually from one half hour to four hours later, except when otherwise authorized by the inspector.

This wash primer should be applied over clean, dry steel; however, a slightly damp surface may be painted over, provided adequate normal butyl alcohol is used in the thinner. If the surface is excessively wet, the vinyl butyral dried film will turn white, become brittle, and lack adhesion to the steel.

This wash primer is not intended for use as a shop coat for steel, and it should be recoated with the primer coat of paint before exposure, preferably within 24 hours.

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