SHERWIN WILLIAMS

CC-M7

MIL-PRF-23377K, Class C2

2.8 VOC Chromated Epoxy Polyamide Primer

Type I Yellow E90G203
Type II Low IR Green* E90G205
Catalyst V93V230

DESCRIPTION

MIL-PRF-23377K, coatings are a two component 2.8 lb/gal VOC compliant, epoxy polyamide primer. They meet the MIL-PRF-23377K composition and performance specification. They are used as a primer under MIL-PRF-85285 polyurethane topcoats, or polyurethane chemical agent resistant coatings (CARC) specified in MIL-DTL-53039, MIL-DTL-64159 or MIL-PRF-22750 epoxy topcoat.

Advantages:

- 2.8 lb/gal VOC**
- Fast drying
- Excellent chemical, solvent and corrosion resistance
- For aluminum with chromate conversion coating or anodized aluminum, it offers excellent filiform resistance
- Excellent hold out for high gloss topcoats

These products have been approved by the U.S. Naval Air Warfare Center (NAWC) Patuxent River, MD.

***Not Stocked - Special Order Only**

**VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations

CHARACTERISTICS

Gloss 10-20 units (60°)
Volume Solids: 45% Catalyzed
Viscosity: catalyzed
40 seconds (maximum) #4 Ford Cup
Recommended film thickness:
Mils Wet 1.3-2.0
Mils Dry 0.6-0.9
Spreading Rate (no application loss)
802-1203 sq ft/gal @ 0.6-0.9 mils DFT
Drying (0.8 mils dft, 77°F, 50% RH):
Tack Free: 5 hours
Dry Hard 8 hours
To Recoat: 2 hours
Force Dry: to dry hard 45-60 minutes at 140°F
Flash Point: 22°F Pensky-Martens Closed Cup
Mixing Ratio: by volume
3 parts E90G203 or E90G205
1 part V93V230
Induction Time: 30 minutes
Pot Life: 4 hours at room temperature. Higher temperature will shorten pot life
Package Life: 24 months, inside storage

Air Quality Data:
Non-photochemically reactive
Volatile Organic Compounds (VOC)
Part A as packaged, maximum
2.85 lb/gal, 342 g/L
V93V230 as packaged, maximum
2.63 lb/gal, 316 g/L
catalyzed as above, maximum
2.8 lb/gal, 340 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com

SPECIFICATIONS

Aluminum: Clean with acidic cleaner or other appropriate cleaner depending on contamination. Pretreat with chromate conversion coating MIL-DTL-5541, wash primer DOD-P-15328, E90G4, or anodize per MIL-A-8625.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

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APPLICATION

Typical Setups

Reduction: If needed, MIL-T-81722 Type II (R91K210) can be used as a reducer but will raise VOC above 2.8 lbs/gal. To maintain 2.8 lb/gal VOC, no reducer other than acetone or Oxsol 100 may be added.

May be applied by:

Conventional Spray
Airless Spray
Air Assisted Airless
HVLP

Please consult with your Sherwin-Williams sales representative for proper settings for your spray equipment.

Cleanup:

Clean tools/equipment immediately after use with MEK, MIBK, MAK or n-Butyl Acetate, or any other epoxy thinners, such as MIL-T-81772B, Type II Thinner, R91K210.

Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations:

- This product must be properly mixed (catalyzed) before using. (See mixing instruction for details.)
- Surface preparation is important for performance.
- For good adhesion, parts primed need to air dry a minimum of 2 hours before topcoating. If parts have been primed for longer than three days, they must be sanded or recoated with a mist coat before topcoating for good adhesion.
- These primers contain strontium chromate.

Performance Properties:

Meets all the performance properties of MIL-PRF-23377K, Class C2.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.paintdocs.com.

Please direct any questions or comments to your local Sherwin-Williams facility

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