16708TEP/16709CEH

CHROMATE-FREE, HIGH SOLIDS, EPOXY PRIMER
MIL-PRF-23377K, TYPE I, CLASS N
Revision: September 2017

HENTZEN
TECHNICAL BULLETIN

Product Description

AEROPRIME is the trade name for Hentzen's Aerospace High Performance Primers. These products are high solids, epoxy primers that have been formulated to have excellent corrosion resistance and meet all the performance requirements of MIL-PRF-23377K.

Material Qualified to Specifications

MIL-PRF-23377K, Type I, Class N
LMCO FQML-P-23377-7

Surface Preparation

To insure proper adhesion remove all surface corrosion, paint films, and any residue indicated by a lack of a water-break free surface. Optimum adhesion results achieved when applied over a substrate properly cleaned and treated with an approved metal pretreatment process like MIL-DTL-81706.

Mixing / Application

Prior to blending, Component A (Base) must be thoroughly agitated or mechanically shaken vigorously until uniformly dispersed and there is no material left on the bottom of the cans. After agitating, blend 1 volume of Component B into 3 volume(s) of Component A and mix the two components well. Allow to induct 10 minutes minimum before use.

Strain the mixed coating through a fine mesh (100-200 microns) into clean pressure pot or cup gun. Spray-apply a uniform coat to a dry film thickness of 0.6 – 0.9 mils using siphon, air, HVLP, or air assisted airless spray equipment with good atomization.

Allow primer to dry per manufacturers recommendations prior to application of topcoat. If primer dry time exceeds 24 hours, then ScotchBrite® and solvent wipe prior to topcoating is recommended. Force cure and hot environments will shorten recoat window times.

Equipment Cleanup

Clean equipment immediately after use with 00053SST-1 or an equivalent solvent.

Physical Properties

Mix Ratio:	3 : 1 by Volume 3 parts - 16708TEP, Part A 1 part - 16709CEH, Part B
Available Colors:	Tan
Admixed Viscosity:	< 30 seconds, #4 Ford
Pot Life:	4 hours @ 75 ^{o}F
Induction Time:	10 minutes minimum
Application Thickness:	0.6 - 0.9 mils
Theoretical Coverage:	700-800ft^2 @ 1 mil
Gloss:	< 20 @ 60^{o}
Flexibility:	10% minimum elongation
Corrosion Resistance:	Pass, 2000 hours minimum
Filiform Resistance:	Pass, 1000 hours minimum
Fluid Resistance:	Water, JP-8, Lube Oil MIL-PRF-23699, Hydraulic Fluid MIL-PRF-83282, Skydrol®
Admixed VOC*:	< 2.80lbs./gal. (340 g/L) *- May Contain Exempt Solvents
Shelf Life:	18 Months from DOM

Dry Times

Standard Cure - At 60-95^{o}F, 5 hours minimum cure before applying topcoats.

Air Dry Cure Schedule @ 77^{o}F & 50% RH:

Set to Touch:	< 4 hours
Dry Hard:	< 8 hours
Recoat Up to:	72 hours
Full Properties:	7 - 14 days

Force Cure Schedule: (For Dry to Stack Only)
Allow a minimum of 30 minutes flash off time before exposing applied coating(s) to oven heat.

Temperature	Oven Time (minutes)
120F-160F	60 minimum

(Allow to cool to room temp. before stacking)

Precautions & Safety

- Store containers in dry indoor area, away from windows at temperature between 40 – 100 ^{o}F.
- Read all container labels & Safety Data Sheet.
- Keep away from open flame and sparks.
- Do not apply below 50 ^{o}F or above 95 ^{o}F.
- Use proper ventilation and respiratory protection.

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