



TT-P-645B Zinc Molybdate Primer (AMS 3117)

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Description:

A single component, zinc-molybdate pigmented primer primarily intended for use as a general primer for steel and properly prepared aluminum.

Physical Properties:

Solids (Weight):	78.8% Minimum
Solids (Volume):	56% Minimum
Weight / Gallon:	13.3 – 13.7 Lbs
Colors:	Yellow
Thinner:	MIL-T-81772B Type III
Shelf Life:	1 Year
Drying Time:	
To Touch:	Within 6 Hours
To Recoat:	6 – 8 Hours
To Cure:	14 Days

Application Characteristics:

- (1) Corrosion Inhibiting
- (2) High Solids, Low VOC
- (3) Fast Dry
- (4) Use on ferrous and non-ferrous metals
- (5) Meets Government Specification TT-P-645B
- (6) Meets AMS 3117 Specification



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SURFACE PREPARATION: Surface to be coated must be clean, dry, and free of all foreign contaminants including grease, oil, dirt and paint. Clean in accordance with SSPC-SP-1. Most metals should be sanded, except aluminum, which must have a base coat of pre-treatment wash primer MIL-C-8514C, followed by one wet coat of TT-P-645B. Alloys that oxidize must be lightly sanded to remove all loose material. Dirt and dust are best removed with a stiff bristle brush and by compressed air. For exterior use and non-ferrous metals, it is recommended that TT-P-645B be applied over pre-treatment coating conforming to MIL-C-8514C or DOD-P-15328D. Grease and oil should be removed by cleaning with appropriate solvents such as mineral spirits, lacquer wash thinner or xylene.

APPLICATION & REDUCTION: Apply by spray, or brush/roll small areas to deposit a hiding coat of primer. A wet coat is necessary to secure maximum adhesion and corrosion inhibiting properties. For application by spray, thin sparingly with Xylene per TT-X-916 or MIL-T-81772B TY.III only as need for proper atomization. For brush or roller, use at packaged viscosity.

PRECAUTIONS:

KEEP OUT OF REACH OF CHILDREN.

USE WITH ADEQUATE VENTILATION.

AVOID CONTACT WITH SKIN AND EYES.

READ MATERIAL SAFETY DATA SHEET BEFORE USING.

KEEP FROM FREEZING