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Technical Data Sheet

STIC-KOTE 8000 Series
Epoxy Polyamide, Two-Component System
(MIL-DTL-24441D, Type III)

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DESCRIPTION

STIC-KOTE 8000 Series (MIL-DTL-24441D, Type III) is a two-component Epoxy-Polyamide Coating System, specially formulated for immersion applications and to protect surfaces from environmental elements. Type III is a three-coat system.

These paints are intended for use on sandblasted steel, aluminum, or fiberglass where a hard, durable, chemically resistant, non-porous coating is desired. This product is available in formulations as a primer, interior top coat, or exterior top coat. For painting particular areas aboard ship, such as bilges, tanks, and exterior underwater hull, refer to applicable Navy directives or technical manuals for instructions and selection of coating system.

MILITARY SPECIFICATION - QPD-24441-43

STIC-KOTE 8000 Series complies with Military Specification: MIL-DTL-24441D(SH), dated: 8/27/2009 and is listed on QPD/QPL-24441-43 as STIC-KOTE 8000, dated: 9/20/2008.

APPLICATION PROPERTIES

1) Volatile Organic Compound: Less than 340 g/L, 2.8 lb/gal
(VOC EPA Method 24 Mixed System)

2) Mix Ratio (by volume): 1:1
Component A = (Polyamide): 1 part
Component B = (Epoxy): 1 part

3) Pot Life (@ 23 ºC (73 º F)): 5 hours, minimum

4) Drying Times (@ 23 º C (73 ºF)): 8 hours, maximum

5) Volume Solids:

Color	Formula	Volume Solids
Green Primer	Formula 150	60.0 ± 2%
Haze Gray	Formula 151	59.0 ± 2%
White	Formula 152	58.3 ± 2%
Dark Gray Ro 1.8	Formula 153	58.9 ± 2%
Dark Gray Ro 3.6	Formula 154	58.8 ± 2%
Dark Gray Ro 6.0	Formula 155	58.8 ± 2%
Red	Formula 156	62.1 ± 2%
Gray	Formula 157	64.5 ± 2%
Yellow	Formula 158	64.0 ± 2%

USE PROPERTIES

1) Shelf Life: 2 years from date of manufacture (if unopened)

2) Flash Point (SETA): Part A: 99°F (37° C)
Part B: 100°F (38° C)

3) Reducer: Do not reduce

4) Tinting: Do not tint

5) Clean Up: Aromatic Naptha

6) Brush and Roller Recommendation:
Natural bristle brush
3/8" woven roller cover with solvent resistant core

7) Application Temperature: 40°-90°F (4.4°-32.2° C) for surface and ambient air; >60°F for paint
NOTE: need to be at least 5°F above dew point

8) Application Humidity: Maximum of 85% relative humidity

9) Storage: Store product in accordance with local, state and federal regulations. Keep container tightly sealed and store indoors in dry conditions at 50˚-80˚F (10˚-26.7˚C).

RECOMMENDED COATING SYSTEMS

Steel and Aluminum: 1 coat MIL-DTL-24441D Type III Primer, applied at 3-4 mils (75-100 microns) dry thickness; and
2 coats MIL-DTL-24441D Type III Epoxy Paint, applied at 2-3 mils (50-75 microns) dry thickness.

Steel: 3 coats MIL-DTL-24441D Type III Epoxy Paint, applied at 2-4 mils (50-100 microns) dry thickness

Steel (non-immersion application): 1 coat MIL-DTL-24441D Type III Primer, applied at 3-4 mils (50-75 microns) dry thickness; and
2 coats MIL-PRF-24635E Silicone Alkyd Enamel, applied at 1.5-2.5 mils (40-63 microns) dry thickness.*

* can also use 2 coats MIL-DTL 24607B Chlorinated Alkyd Enamel, applied at 1.5-2.0 mils (40-50 microns)

SURFACE PREPARATION

Surface must be clean, dry and in sound condition, free from loose mill scales, dirt, dust, rust, oil and grease. Remove all loose scales, peeling, flaking paint, rust, corrosion and chalk from the surface before painting.

1) Steel, Iron

Non-immersion use surface prep: Solvent clean per SSPC-SP1 (removing oil, grease, dirt, and other foreign material); then prepare surface by Commercial Blast Cleaning per SSPC-SP6/NACE No. 3. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils/50 microns). For best results, follow surface prep instructions for immersion use.

Immersion use surface prep: Solvent clean per SSPC-SP1 (removing oil, grease, dirt, and other foreign material); then prepare surface by Near-White Metal Blast Cleaning per SSPC-SP10/NACE No. 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils/50 microns).

Prime bare steel within 8 hours or before flash rusting occurs.

2) Aluminum

Recommended surface prep: Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material); then prepare surface by Brush-Off Blast Cleaning per SSPC-SP7/NACE No. 4.

RECOMMENDED COVERAGE PER COAT (DRY FILM)

1) Coverage	ft^2/gal	m^2/L
Minimum:	300 ± 20 sq.ft.	7.4 ± 0.5 sq. meters

Maximum:	420 ± 20 sq.ft.	10.3 ± 0.5 sq. meters
2) Dry Film Thickness per coat:	2.0 - 4.0 mils (min/max)	50 - 100 microns (min/max)
3) Theoretical Coverage of Dry Film:		
Dry film thickness	1 mil	900 ft^2/gal
Dry film thickness	25 micron	22 m^2/L

Note: Brush or roller application may require multiple coats to achieve maximum film thickness.

RECOAT SCHEDULE @ 3 mil (100 microns) DRY FILM - 5 mil (150 microns) WET FILM

1) Temperature:	50 ± 10 ºF (10 ± 5 ºC)	70 ± 10 ºF (21 ± 5 ºC)	90 ± 10 ºF (32 ± 5 ºC)
2) Time: (minimum)	18 ± 1.0 hr	12 ± 1.0 hr	8 ± 1.0 hr
3) Cure time: (minimum)	5 Days	4 Days	3 Days

RECOMMENDED THREE COAT SYSTEM

		Dry Film Thickness (mils)	Dry Film Thickness (microns)
1ST Coat:	MIL-DTL-24441 Type III Primer	3.0 – 4.0	75 – 100
2nd Coat:	MIL-DTL-24441 Type III Topcoat	2.0 – 4.0	50 – 100
3rd Coat:	MIL-DTL-24441 Type III Topcoat	2.0 – 4.0	50 – 100

SAFETY

Refer to the Material Safety Data Sheet (MSDS) before using this product, for safe use, handling and storage.

OTHER INFORMATION

HEALTH AND SAFETY INFORMATION:
Refer to Material Safety Data Sheet for health and safety information before using this product. Also, for additional information, please visit the website at **www.sticadhesive.com.**

LIMITATION OF REMEDIES AND LIABILITY:
If the STIC-ADHESIVE product is proved to be defective, the exclusive remedy, at STIC-ADHESIVE'S option, shall be to refund the purchase price or replace the defective product. STIC-ADHESIVE shall not otherwise be liable for loss or damages, regardless of the legal theory, including but not limited to contract, negligence, warranty, or strict liability.

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