

STIC-ADHESIVE Products Co., Inc.

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Technical Data Sheet

TT-P-645B Primer, Paint, Zinc-Molybdate, Alkyd Type - Formula 84 Corrosion inhibiting primer for metal and aluminum (meets Federal Specification TT-P-645B(SH) dated August 9, 2006)

1-29-2010

DESCRIPTION

TT-P-645B is a zinc-molybdate based primer for use as a corrosion inhibiting primer on metal surfaces, such as steel and aluminum. This product is particularly suited for surfaces in marine environments, such as marine vessels (both interior and exterior), offshore platforms, and coastal structures. It may be applied by brush or spray, and is suitable as an after-blast or after-pickling primer for plating, as an undercoat for alkyd enamels, and for equipment where a quick-drying primer is not required.

MILITARY SPECIFICATION

TT-P-645B complies with Military Specification TT-P-645B(SH), Formula 84, dated August 9, 2006.

APPLICATION PROPERTIES

- | | |
|--|---------------------------------|
| 1) Volatile Organic Compound (VOC)
(EPA Method 24): | Less than 340 g/L (2.8 lb/gal) |
| 2) Color: | Yellow (other colors available) |
| 3) Finish: | Flat |
| 4) Weight Solids: | 78.6% (minimum) |
| 5) Volume Solids: | 56% (minimum) |

USE PROPERTIES

- | | |
|-------------------------------------|---|
| 1) Shelf Life: | 1 year from date of manufacture (if unopened) |
| 2) Flash Point (SETA): | 101°F (38.3° C) |
| 3) Reducer: | Do not reduce |
| 4) Tinting: | Do not tint |
| 5) Clean Up: | Mineral Spirits |
| 6) Brush and Roller Recommendation: | Natural bristle brush
3/8" woven roller cover with solvent resistant core |
| 7) Application Temperature: | 50°-90°F (10°-32.2° C) for surface, paint, and ambient air
NOTE: need to be at least 5°F above dew point |

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- 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

- PRIMER: 1 coat TT-P-645B on aluminum or steel, applied at 1.8-3.5 mils (45-88 microns) dry thickness.
- TOP COAT: 1-2 coats of any of the following: (1) MIL-PRF 24635; (2) MIL-DTL-24607; or (3) MIL-DTL-24441. Apply top coat applied at 1.5-2.0 mils (40-50 microns) dry thickness.

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
- Minimum surface prep: Hand Tool Cleaning per SSPC-SP2
- Additional surface prep: Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material)
- Better performance surface prep: 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)
- 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)
- 3) Previous Painted Surfaces
- If previous paint is significantly weathered or peeling, remove the previous paint and clean the surface. If the previous paint is in good condition, clean the surface of any dust, dirt, rust, oil and grease. Abrade any smooth, hard or glossy surfaces to a dull appearance to promote adhesion. Apply first to a test area, and test adhesion after one week. If adhesion is weak, or this product degrades the original finish, remove previous coating for best performance.

APPLICATION INSTRUCTIONS

- 1) Complete surface preparation as indicated prior to application of product.
- 2) Mix paint thoroughly with low speed power agitation prior to use.
- 3) Apply paint at the recommended film thickness and spreading rate. Applying the paint above maximum or below minimum recommended spreading rate can have negative effects on performance.

RECOMMENDED SPREADING RATE PER COAT

- | | | |
|-------------------------|---------------------------|------------------------|
| 1) Approximate Coverage | <u>ft²/gal</u> | <u>m²/L</u> |
| Minimum: | 250 ± 20 sq.ft. | 6.1 ± 0.5 sq. meters |
| Maximum: | 500 ± 20 sq.ft. | 12.2 ± 0.5 sq. meters |
| 2) Wet mils | <u>mils</u> | <u>microns</u> |

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Minimum:	3 mil	75
Maximum:	6 mil	150
3) Dry mils		
Minimum:	1.8 mil	45
Maximum:	3.5 mil	88

Application by brush or roller may require multiple coats to lay down the maximum film thickness and to achieve a uniform appearance.

DRYING TIME

	@50°F (10°C)	@77°F (25°C)*
To Touch:	7-8 hours	5-6 hours
To Recoat:	9-10 hours	7-8 hours
To Cure:	14 days	14 days

NOTE: These times are approximations and will change depending on temperature, humidity, and thickness of applied film. * - Tested at 50% relative humidity.

ORDERING INFORMATION

Sizes:	1 gallon can, 5 gallon can (3.78L, 18.9L)
SKU:	645B-GL, 645B-CN
Website:	www.milspeccoating.com

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.

DISCLAIMER:

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