



## V-2339/V-2017 MIL-P-23377 HI SOLIDS EPOXY PRIMER

## TECHNICAL DATA SHEET

**PRODUCT DESCRIPTION:** A two component, epoxy polyamide, chemical resistant primer formulated for spray application and compatible with aliphatic polyurethane topcoats. This coating provides excellent chemical resistance, as well as being extremely resistant to abrasion and direct impact.

**INTENDED USES:** V-2339/2017 is for priming exposed structural and miscellaneous steel. Its primary is a fast dry high performance primer for corrosive environments.

**SURFACE PREPARATIONS:** For best results it is important that all surface contaminants, such as moisture, oil, dirt, rust and mill scale be removed before application of the primer. Can be applied to either blasted steel, also hand or tool cleaned steel. A minimum of SSPC-2 hand tool cleaning.

### PRODUCT CHARACTERISTICS:

**SOLIDS BY VOLUME:** 51% after mixing

**SOLIDS BY WEIGHT:** 74% after mixing

**RECOMMENDED DFT:** 2-4 mils

**THEORETICAL COVERAGE:** 450 sq ft @ 2mils

**PENCIL HARDNESS:** >2H

**ABRASION RESISTANCE:** 100 milligram loss

**SALT FOG RESISTANCE:** 1000 hours 4F blister

**HUMIDITY RESISTANCE:** 1000 hours 6M blisters

**POT LIFE:** 8 hours @ 72f

### DRYING TIME @ 72 F

**TO TOUCH:** 1-2 Hours

**TO RECOAT:** 4-6 Hours

### REGULATORY DATA

**FLASHPOINT:** 60 F

**PRODUCT WEIGHT:** 11.95 Lbs. for primer  
10.05 Lbs. for catalyst

**MATERIAL VOC:** 3.16 POUNDS PER GALLON / 379 GRAMS PER LITER

**COATING VOC:** 3.16 POUNDS PER GALLON / 379 GRAMS PER LITER



## APPLICATION

## TECHNICAL DATA SHEET

**MIXING:** This material is a two-component coating and should always be mixed thoroughly with a power agitator before application.

**MIX RATION:** 1-1

**WORKING POT LIFE:** 8 Hours @ 72F

**AIRLESS SPRAY:** Suitable

Tip Range 15-17 thou (0.38-0.43mm)  
total output fluid pressure at spray tip not less than 2,500 P.S.I.

**AIR SPRAY:** Suitable  
(Pressure Pot)

Gun	DeVilbiss	MBC or JGA
Air Cap	704	
Tip	E	

**BRUSH:** N/A

Typically 1.5-2.0 mils can be achieved. Care should be taken to avoid under application.

**ROLLER:** N/A

Typically 1.5-2.0 mils can be achieved. Care should be taken to avoid under application.

**THINNER:** M.E.K.

Do not thin more than allowed by local environmental legislation when applicable.

**CLEANER:** M.E.K.

**WORK STOPPAGES:** Thoroughly flush all equipment with M.E.K.. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or viscosity increase of the material after storage. Material should be filtered prior to use.

**CLEAN UP:** Clean all equipment immediately with M.E.K.. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations legislation.

## SYSTEM COMPATIBILITY:

The following Topcoats are recommended for this primer:

Polyurethanes

Epoxies

## SHIPPING & STORAGE

**NUMBER OF COMPONENTS:** 2

**PACKAGED IN:** 5 Gallon Pails, and 1 Gallon Cans.

**STORAGE TEMPERATURE:** Minimum 20 F. Maximum 110F