



HENTZEN COATINGS, INC.

16708TEP

MIL-PRF-23377K Type I, Class N

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

AEROPRIME is the trade name for Hentzen's Aerospace High Performance Primers. This product is a high solids, chromate-free primer that has been formulated to have excellent corrosion resistance and meet all the performance requirements of MIL-PRF-23377K Type I, Class N. Approved and QPL listed.

PHYSICAL CHARACTERISTICS

16708TEP-HG Aeroprime Epoxy Primer - Component A:

Weight per Gallon: 12.7 lbs. \pm 0.2

16709CEH Curing Agent - Component B:

Weight per Gallon: 7.5 lbs. \pm 0.2

Admixed Characteristics:

Catalyzation Ratio:	3:1 by volume
Weight per Gallon:	11.4 lbs. \pm 0.2
Weight Solids:	70.5% \pm 1.0
Volume Solids:	56.3% \pm 1.0
Viscosity:	21 - 25" #4 Ford
Theoretical Coverage -	900 sq. ft./gal. @ 1.0 mil dry film thickness
Induction Time:	10-15 minutes
Pot Life:	4 hours
Gloss @ 60° Meter:	15 - 35 @ 1.0 mil DFT
Color:	Honeywell Green

ENVIRONMENTAL REPORT

Volatile Content (Wt.%):	29.5%
Organic Volatile Content (Wt.%):	27.5%
Exempt Content (Wt.%):	2.0%
Exempt Content (Vol.%):	3.6%
VOC Minus Exempt:	2.83 lbs./gallon or 340 grams/liter maximum

HANDLING & STORAGE

Shelf Life: 18 months from Date of Manufacture

- Store containers indoors at 60 - 90°F.
- Do not apply at temperatures below 50°F.
- Read all container labels.
- Read Material Safety Data Sheet.
- Keep away from open flame and sparks.

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The information contained here is to our knowledge true and accurate but all suggestions are made without guarantee since conditions of use are beyond our control. Nothing contained herein shall be construed as a recommendation to use any product in conflict with existing patents covering any material or use.

TECHNICAL BULLETIN**Page 2****DIRECTIONS FOR USE**

Mix Ratio by Volume: 3 Parts A to 1 Part B
No Induction time required before use.

Component A should be thoroughly agitated or shaken for a minimum of 15 minutes prior to blending. After agitating Component A, mix 3 volumes of Component A to 1 volume of Component B and mix the two components well. Use up admixture within 4 hours after mixing under ambient temperature to maintain coatings optimum properties.

APPLICATION DIRECTIONS

Substrate: Aluminum, Steel, or Composites

Preparation: Service Life of coating is directly related to the surface preparation. The surface to be coated must be properly prepared, dry, clean, and free of contamination.

Equipment: By HVLP, Air Spray, or Air-Assisted Airless.

	BINK'S MACH 1 HVLP	GRACO Pro 3500 Air Spray	GRACO Pro AA4000 AA-Airless
Tip Size:	#91, #94	1.2-1.5 mm	#611, #613
Pot Pressure:	15-35 psi	15-35 psi	700-900 psi
Atomization Air:	9-10 psi	50-60 psi	40-50 psi

Application: Apply one uniform coat of primer to a dry film thickness of 0.6-0.9 mils. Topcoats may be applied after 4-5 hours minimum cure time at 77°F.

DRYING SCHEDULE

Cure Schedule - Air Dry @ 77°F & 50% Relative Humidity:

Tack Free:	1-2 hours
Dry to Topcoat	4 hours minimum
Dry to Tape	6-8 hours
Dry Hard:	8-10 hours
Full Resistance Properties:	7-10 days

Cure Schedule - Oven @ 150°F:

Flash Off	15 -30 min. @ Room Temp.
Dry to Topcoat:	30-60 minutes
Dry to Hard:	2-4 hours
Full Resistance Properties:	24 hours

CLEAN-UP

Clean equipment immediately after use with MIL-T-81772, Type II Thinner, MEK, or equivalent solvent.

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