



TECHNICAL DATA SHEET

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MIL-P-46105 ZINC RICH PRIMER
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PRODUCT: A single package, heat convertible/curing epoxy-based, zinc-rich primer for use on ferrous metal surfaces prior to spot welding. Protects steel galvanically, thus preventing below film corrosion.

DESCRIPTION: A high zinc content, heat curable epoxy primer formulated for excellent characteristics over a wide range of chemical and atmospheric conditions. Typical uses: Underground pipes, off shore drilling rigs (above splash zone), water lines, refineries, structural steel and severe corrosive and chemical environments.

PROPERTIES: COLOR..... Gray
PIGMENT (Weight)..... 75% Minimum
VOLATILES (Weight)..... 20% Maximum
THEORETICAL COVERAGE..... 225 sq.ft.@ 2 mil
FILM THICKNESS..... 2.5 to 3.0 mils p/coat
DRYING TIME-AT 75 DEGREES F
TO TOUCH..... Within 10 Minutes
DRY HARD..... Within 20 Minutes
BAKE HARD..... 45-60 Minutes @ 250 Deg F
WEIGHT/GAL 19 lbs min.
PIGMENT TYPE..... Metallic Zinc
Dust VEHICLE TYPE..... Heat Curable Epoxy

TOPCOATS: Acrylics, Alkyds, Chlorinated Rubber, and many other maintenance coatings, **consult your TriCom Coatings Technical Rep.**

- USES:**
- (1). Underground Pipes
 - (2). Off Shore Rigs (Above splash zones)
 - (3). Water Lines
 - (4). Severe Corrosive Environments
 - (5). Refineries
 - (6). Tank Exteriors
 - (7). Structural Steel



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APPLICATION:

Spray is the best method of application. Use air spray with agitated pressure pot or airless spray with continuous material mixing setup. Use brush for touch up and small areas only. Reduce with MIL-T-81772B Ty. III Thinner or TT-X-916 Xylene, approximately 1 pint of thinner to 1 gallon of mixed primer. Allow material to flash dry for 30-60 minutes, place in a pre-heated oven for 45-60 minutes at 250 degrees Fahrenheit.

SURFACE PREPARATION: FERROUS METAL

SSPC-SP6 Commercial Blast or SSPC-SP10 Near White Blast. If drying time prior to recoating exceeds 48 hours at temperatures above 70 Degrees F, the dry coating must be brush-sandblasted to achieve proper adhesion of new coat. Surface must be clean and free of all oil, grease and foreign material. Badly rusted or pitted steel should be cleaned by commercial sandblasting (SSPC-SP6) and primed the same day.

PRECAUTIONS:

Contents are Flammable

Store inside @ 78 F. out of direct sunlight. Keep away from heat and open flame.

Shelf life 6-9 months from date of Mfg.

KEEP OUT OF THE REACH OF CHILDREN.

Do not take internally.

Avoid breathing vapor or mist.

Do not use in tank or pit without proper protection.

Read Material Safety Data Sheet before use of this product.