HENTZEN COATINGS, INC.

TECHNICAL BULLETIN

04488WEP-4/04489CEH-4
Two Component Off-White High Solids Epoxzen Primer per MIL-P-53022B, Type II

PRODUCT DESCRIPTION

EPOXZEN is the trade name for Hentzen's Epoxy Coatings. This two component primer meets the requirements of MIL-P-53022B.

HANDLING & STORAGE

The containers should be stored away from direct sunlight and heat. Freezing is not harmful if reheated gently to room temperature prior to use.

PHYSICAL CHARACTERISTICS

04488WEP-4 Off-White Epoxzen - Component A:

Weight per Gallon:	12.85 lbs. ± .35
Weight Solids:	75.26 ± 1.00%
Volume Solids:	54.17 ± 1.00%
Viscosity:	65 - 75 KU's

04489CEH-4 Epoxy Hardener - Component B:

Weight per Gallon:	8.02 lbs. ± .25
Weight Solids:	39.29 ± 1.00%
Volume Solids:	33.86 ± 1.00%
Viscosity:	40 - 50" @ #3 Zahn

Admixed Characteristics:

Catalyzation Ratio:	4:1 by volume
Weight per Gallon:	11.88 lbs. ± .35
Weight Solids:	70.41 ± 1.00%
Volume Solids:	50.11 ± 1.00%
VOC:	3.41 maximum
Viscosity:	22 - 32" @ #3 Zahn
Theoretical Coverage - sq. ft./gl.	
@ 1.0 mil dry film thickness:	803.8

Useable Pot Life: Approximately 4 - 8 hours to 1½ times initial viscosity. To extend the pot life, regulations permitting, some additional thinner may be required to reduce the viscosity. A fresh mixture of Component A and B could also be added to lower the pot viscosity.

Gloss @ 60º Meter:	10 - 30 @ 1.0 mil DFT
Cure Schedule - Air Dry @ 77ºF & 50% Relative Humidity:	
Set to Touch:	10 - 20 minutes
Dry Hard:	1 - 1½ hours
Dry Through:	24 hours
Recoat:	2 - 24 hours
Full Resistance Properties:	7 days
Force Cure Recommendation:	20 - 30 minutes @ 180ºF

ENVIRONMENTAL REPORT

Volatile Content (Wt.%):	29.58
Organic Volatile Content (Wt.%):	28.08
Density of Organic Volatile (Wt./Gl.):	6.88
Density of Solid Content (Wt./Gl.):	16.70
Exempt Solvent Content (Wt.%):	1.51
Exempt Solvent Content (Vol.%):	2.31
VOC Minus Water:	3.41 maximum

DIRECTIONS FOR USE

Component A should be thoroughly agitated prior to blending. After agitating Component A, mix 4 volumes of Component A to 1 volume of Component B and mix the two Components well. Allow the admixed product 30 minutes to induct prior to spraying. No further reduction is necessary. Mix only what you will use in 4 hours. After that time, the product will have gained viscosity and will eventually gel.

PRECAUTIONS & SAFETY

- Do not apply at temperatures below 50ºF.
- Read all container labels.
- Read Material Safety Data Sheet.
- Keep away from open flame and sparks.

CLEAN-UP

Clean equipment immediately after use with 00212SST-1 Solvent Blend or equivalent.

January 20, 2004

6937 WEST MILL ROAD • MILWAUKEE, WI 53218-1225 • TELEPHONE 414-353-4200 • FAX 414-353-0286 • EMAIL coatings@hentzen.com