



## TT-P-645B / AMS 3117 ZINC MOLYBDATE ALKYD PRIMER

### DESCRIPTION

This primer, meeting Military Specification TT-P-645B, Formula 84 is a zinc molybdate, alkyd primer formulated for use as a general primer on steel and aluminum where a fast drying primer is not required. The typical areas of application for these coatings include marine and industrial environments.

### PERFORMANCE CHARACTERISTICS

<b>COLOR:</b>	Light Yellow	<b>GLOSS:</b>	Flat
<b>VOLUME SOLIDS:</b>	Minimum 56%	<b>WEIGHT SOLIDS:</b>	Minimum 78%
<b>DRY TIMES</b>		<b>COVERAGE:</b>	800 Sq. Ft./gal @ 1 mil DFT
	3.0 Mils DFT, 77°F, 50% RH	<b>VOC:</b>	2.8 lbs./gal - 340 g/l
	-To Touch		6 Hours Max
	-Recoat		8 Hours Max
	-Full Cure:		2 Weeks

**SHELF LIFE:** (50-75°F, ~50% Relative Humidity) 1 Year from DOM, Unopened

#### **RECOMMENDED APPLICATION:**

Wet 2.50 – 5.0 mils  
Dry 1.50 - 3.0 mils

### APPLICATION INFORMATION

**MIXING:** Stir paint thoroughly before use.

**THINNING:** No reduction is recommended.

**APPLICATION:** This material may be applied by conventional spray methods, airless spray, brush and roller. Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

**STORAGE:** Product should be stored in accordance with federal, state and local regulations. Recommended storage conditions: Containers should be tightly sealed, kept indoors in dry conditions at ambient temperatures (50-75°F).

## **SURFACE PREPARATION**

**SURFACE PREP:** All surfaces to be coated must be free of dirt, oils, greases, polishing compounds, fingerprints, and any other foreign matter including oxidation products.

**FOR IRON AND STEEL:** Minimum surface preparation is to Hand Tool Clean per SSPC-SP2. Remove all oil and greases from surface by Solvent Cleaning per SSPC-SP1. For improved performance, use Commercial Blast Cleaning per SSPC-SP6, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). All bare steel surfaces should be primed within 8 hours or before flash rusting occurs.

**ALUMINUM:** Remove all oil and greases from surface by Solvent Cleaning per SSPC-SP1.

**PREVIOUSLY PAINTED SURFACES:** If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry for one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of previous is necessary.

## **SAFETY & HANDLING INFORMATION**

**FIRE & EXPLOSION DATA:** In case of fire use foam, CO<sub>2</sub>, or dry chemical firefighting apparatus. The use of self-contained breathing apparatus is recommended for firefighters. Water may be unsuitable as an extinguishing media, but helpful in keeping adjacent containers cool. Avoid spreading burning liquid with water used for cooling purposes.

### ***HEALTH & FIRST AID:***

**EYES:** Safety glasses, chemical goggles, and/or face shields are recommended to safeguard against potential eye contact. If this product comes in contact with the eyes, flush with large quantities of water for at least 15 minutes. Seek medical attention.

**SKIN:** The use of impermeable gloves is advised to prevent skin irritation on sensitive individuals. If this product comes in contact with the skin, wash with a mild soap and large quantities of water. Seek medical attention if irritation persists.

**INHALATION:** The use of respiratory protection depends on vapor concentrations above the time-weighted TLV; use a NIOSH approved cartridge respirator or gas mask. If breathing difficulties, dizziness, or lightheadedness occur when working in areas with high vapor concentrations, seek fresh air. If difficult breathing continues, administer oxygen until medical assistance can be rendered. If breathing stops, begin artificial respiration and seek medical attention.

**HANDLING:** General mechanical ventilation may be sufficient to keep vapor concentrations within specified TLV ranges. If general ventilation proves inadequate, supplemental local exhaust may be required. Keep product containers cool, dry and away from sources of ignition. Use and store this product with adequate ventilation, and sufficiently ground containers when transferring this material. Dispose of this product in accordance with applicable local, county, state, and federal regulations.

**NOTE:** The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, primer, application and testing requirements for their specific job.