



710 Forest Avenue | P.O. Box 102
 Sheboygan Falls, WI 53085 | USA
 800-558-7596 | 920-467-8674 FX
 sales@torginol.com | www.torginol.com

Epoxy Resin Paints

MIL-PRF-22750F

High Solids Epoxy Topcoat

Federal Standard 595B Specification Color:
595B-10032
Drak Brown, Gloss

DESCRIPTION

MIL-PRF-22750F High Solids Epoxy Topcoat is a 340 grams/liter (2.8 lb/gal) VOC compliant polyamide, high solids two component epoxy topcoat. This epoxy coating is intended for use as a topcoat for interior military ground equipment, aircraft, marine equipment, offshore rigs and platforms, corrosive environments, storage tanks and other industrial applications. **This product is intended to be applied over specified epoxy primers** (see *Specifications*). Reduction is NOT recommended.

Torginol, Inc. is a Qualified Product List (QPL) approved manufacturer of the **MIL-PRF-22750F** products above, tested by the Naval Air Warfare Center (NAWC), Patuxent River, MD. Copies of approval letter are available upon request.

CHARACTERISTICS

MIL-PRF-22750F

595B-10032
 Drak Brown, Gloss

Sheen:

Gloss
 90+ units @ 60°Gloss Meter

Volume Solids:

Component A: 59 - 68%
 Component B: 69 - 75%
 Admixed: 65 - 72%

Viscosity:

Admixed: < 50 Sec, #4 Ford

Film Thickness:

Mils Wet: 2.8 - 3.7 mils
 Mils Dry: 1.8 - 2.3 mils
 Minimum 1.8 dft per MIL-C-22750F

Spreading Rate:

1.8 mils dft: 750 sq ft / gal
 5 mils dft: 250 sq ft / gal

Drying Time:

Set to Touch: 4 hours max
 Dry Hard: 8 hours max
 Complete Cure: 7 days
 Force Dry: 30 min at 145°F
 *Force drying may lower gloss below specification minimum.
 *Thicker films or lower temperature will increase cure time.

Flash Point:

20°F Pensky Martens (Closed Cup)

Mixing Ratio (1:1 by Volume):

1 Part Component A
 1 Part Component B

INDUCTION TIME: 30 minutes

Pot Life:

6 - 8 hours at room temperature

Shelf Life:

1 year, inside storage

SPECIFICATIONS

Steel: Surface must be clean and free of grease, dirt, oil, rust, fingerprints, and other contaminants to insure optimum adhesion and performance properties. Chemical pretreatment, zinc phosphate or DOD-P-15328 wash primer gives best adhesion and performance results. Where blasting is appropriate, blast in accordance with SSPC-SP6. For optimum adhesion, pretreat blasted surface immediately. Prime with wash primer within two hours after blasting.

Aluminum: Clean with acidic cleaner or other appropriate cleaner depending on contamination. Pretreat with chromate conversion coating (MIL-C-5541), wash primer DOD-P-15328 or anodize per MIL-A-8625.

Galvanized and other metals: Clean and remove oxidation contamination on surface, followed by treatment with DOD-P-15328 wash primer. Due to the variability in these surfaces, testing adhesion on each situation is recommended.

Primers must be applied under the topcoat. For **ferrous** substrates, use MIL-P-53022B primer.

For **non-ferrous** substrates, use MIL-P-23377F, MIL-P-23377G or MIL-P-53022.

Check the product data sheet of each primer for recoat time of topcoat.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

Performance Properties:

Meets all the performance properties of MIL-PRF-22750F.



APPLICATION

Reduction: Reduction is not recommended. Optimum sag resistance is obtained without reduction. If required, use MIL-T-81772, Type II Reducer. **Note:** Maximum reduction of MIL-T-81772, Type II is 6% to maintain 2.8 VOC. No reduction is permitted to maintain 2.8 VOC. **Warning:** Reduction with various solvents may adversely affect sheen, dry-time and other specification properties and is therefore NOT recommended.

Conventional Spray:

Air Pressure: 45-60 psi
Tip: 070"

Air Assisted Airless:

Air Assist Pressure: 30 psi
Fluid Pressure: 1800-2200 psi
Tip: 011"

HVLP:

Atomizing Air: 65 psi
Fluid Pressure: 5-10 psi
Tip: 070"

Cleanup:

Clean tools/equipment immediately after use with MIL-T-81772, Type II Thinner or other reducer. A blend of MIBK and Xylene works well also.

Follow manufacturer's safety recommendations when using any solvent.

CAUTIONS

Thoroughly review product label and Material Safety Data Sheet for safety and cautions prior to using this product.

LABEL CAUTIONS

SEE CONTENTS STATEMENT ON LABEL
Contents are EXTREMELY FLAMMABLE. Keep away from heat, sparks, and open flame. Vapors will accumulate readily and may ignite explosively. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. VAPOR HARMFUL. Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage. FIRST AID: IF INHALED: If affected, remove from exposure. Restore breathing. Keep warm and quiet. If on Skin: Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately. SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution. DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE. Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. This product must be mixed with other components before use. Before opening the packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS. WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN. FOR INDUSTRIAL USE ONLY. SEE MATERIAL SAFETY DATA SHEET FOR THIS PRODUCT.

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under control, Torginol, Inc. cannot make any warranties as to the end result.

LIMITATIONS

Product Limitations:

- MIL-PRF-22750F coatings (Component A) must be catalyzed with Catalyst (Component B), at a 1:1 mix ratio by volume.
- Do not use other catalysts.
- Do not vary catalyst mixing ratio.
- Component A must be well agitated prior to use.
- Agitate entire mixture, Component A, Component B, and Reducer well before spray.
- Potlife will be shorter with warmer temperatures.
- Force drying will lower the gloss of this product.
- This coating is recommended for INTERIOR APPLICATION ONLY.