

III. MIXING PROCEDURE: **NOTE: Incorrectly mixed material will not cure properly**

(a) MIXING RATIO BY WEIGHT - 20 : 1 (Base to hardener)
 BY VOLUME - 9 : 1 (Base to Hardener)

(b) INDUCTION TIME - None

(c) RECOMMENDED SOLVENT - THINNING - Not Authorized
 CONFINED AREAS - N/A
 NON CONFINED AREAS - N/A

CLEAN UP - 1) Propylene Glycol Ether
 2) N-Methyl Amyl Ketone (MAK)
 3) Aromatic Naphtha

(d) THINNING REQUIREMENTS (RATIO) - Not Applicable

(e) POT LIFE -

4 Hrs @	90° F (32C)
8 Hrs @	70° F (21C)
12 Hrs @	50° F (10C)

(f) SPECIAL INSTRUCTIONS – Pre-mix Part A, base component, to ensure all materials which may have settled during storage are lifted from the bottom. **Mix Part A and Part B components together for a minimum of 3 to 5 minutes ensuring the mixed material assumes a uniform color and appearance.**

IV. APPLICATION: **NOTE: Environmental conditions must be taken into consideration when determining curing time of epoxy coatings. Cooler temperatures extend curing times, warmer temperature shortens curing times.**

(a) ENVIRONMENTAL LIMITATIONS: Do not apply when surface temperature is under 40°F or over 120°F.
 AIR TEMP. MIN. 40°F MAX. 100°F
 % RELATIVE HUMIDITY MIN. 0% MAX. 85°F

(b) AVERAGE FILM THICKNESS (SSPC PA2-73T) WET MIN. N/A WET MAX. N/A
 DRY MIN. 30 mils DRY MAX. 70 mils
Note: Spread rate per gallon is subject to variation due to environmental conditions and applicator technique.

(c) DRY TIMES (ASTM D1650) - RECOAT MIN. 48 Hrs @ 90°F (32C) @ 50 % R.H.
 MIN. 96 Hrs @ 70°F (21C) @ 50 % R.H.
 MIN. 180 Hrs @ 50°F (10C) @ 50 % R.H.

MAX. ___ Hrs @ ___ °F (___ °C)

-TO HANDLE MIN. 12 Hrs @ 90°F (32C) @ 50 % R.H.
 MIN. 24 Hrs @ 70°F (21C) @ 50 % R.H.
 MIN. 48 Hrs @ 50°F (10C) @ 50 % R.H.

-FOR IMMERSION MIN. 72 Hrs @ 90°F (32C)
 MIN. 96 Hrs @ 70°F (21C)
 MIN. 180 Hrs @ 50°F (10C)

MAX. ___ Hrs @ ___ °F (___ C)

(d) **EQUIPMENT REQUIREMENTS** (INCLUDE PREFERRED, SUITABLE AND NOT SUITABLE REQUIREMENTS): Phenolic hard core roller with extended handle; #3/4", 3/4 HP, 450 RPM power mixer capable of mixing heavy, mastic materials.

SPECIAL INSTRUCTIONS: 1) Do not apply when surface temperature is under 40°F or over 120°F. 2) At time of application, in accordance with MIL-PRF-24667A/B, MATERIAL TEMPERATURE should be no lower than 50°F or higher than 90°F. 3) Caution should be taken that the surface temperature is at least 5° F above the dew point at application.

NOTE: MS-375G is formulated to be applied within the parameters listed on this document. MIL-PRF-24667A/B QPL applications may adjust the environmental and application procedures recommended by this ASTM-F718.