



30-Y-94™ NON-SANDING MIL-SPEC MIL-P-23377D, TYPE 1, CLASS 1 ANTI-CORROSIVE EPOXY PRIMER: S9001/S3001

Features & Uses

A two component anti-corrosive, strontium chromate epoxy primer for aluminum and steel with excellent chemical and solvent resistance. Do not use below the waterline.

Specification Data

Type: Epoxy Polyamide, Strontium Chromate, meets Mil-P-23377D

Packaging: Available in 1 gallon and 1 quart containers

Theoretical Coverage: Sq. Ft./Gallon

*298 Sq. Feet at one mil dry

*198-496 Sq. Feet at recommended dry film thickness

*Calculated for mixed base and converter, reduced 50%.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size, and application environment.

Recommended Wet Film Thickness: 3-7.5 mils (75-175 microns)

Recommended Dry Film Thickness: 0.6-1.5 mils (15-37 microns)

Recoatibility: At 77F/50% R.H. minimum 2-4 hours. Maximum without sanding is 24 hours. Plan your work schedule to eliminate having to sand

30-Y-94™. May be overcoated with AWLGRIP™/AWLCRAFT™ 2000 Topcoats, 545 Epoxy Primer, High Build Epoxy Primer, AWL-QUIK™ Sanding Surfacer, and ULTRA-BUILD™ Epoxy Primer.

Product Components, Reducers, Additives, and Auxiliary Components

Base - Yellow	S9001
Acid Converter	S3001
Reducer	T0006
Equipment Cleaning	T0006 or T0002 Reducers or M.E.K.

Application Equipment

Conventional or airless spray.





Surface Preparation

Aluminum: Sandblast/Grind to 100% clean silver colour or treat with ALUMIPREP™ 33/ALODINE™ 1201. Steel: Sandblast/Grind SSPC-SP5-85. Do not apply over Zinc Chromate Wash Primer (G9072/G3014).

Mixing and Reduction

Mix by volume 1 part S9001 with 1 part S3001. When a smooth homogenous mixture is obtained, reduce up to 50% with T0006. Overall mix is 1:1:1 by volume.

Example: 8 oz. S9001, 8 oz. S3001, 8 oz. T0006.

Tip: You will get a smoother application by inducting the mixed S9001/S3001 30-45 minutes before adding the reducer. Stir the S9001/S3001 mixture every 10-15 minutes while inducting.

Induction Time after Mixing: 15 Minutes

Anticipated Pot Life at 77°F/50% R.H: 8 Hours

Application Instructions

Spray only. Apply one smooth wet coat. Cross coating or double coating is acceptable on very rough surfaces. Substrate may be visible through the dry film. Too thick a film may split and peel.

Do not apply paint materials to surfaces warmer than 105°F or colder than 55°F. Do not attempt to cure products at temperatures below 55°F.

