

STIC-ADHESIVE Products Co., Inc.

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Technical Data Sheet

MIL-DTL-24607B Chlorinated Alkyd Enamel Nonflaming (Dry), Interior, Semigloss

(meets Detail Specification MIL-DTL-24607B dated October 12, 2010)

3-8-2012

DESCRIPTION

MIL-DTL-24607B is a semi-gloss, Chlorinated Alkyd enamel for interior use in marine and industrial environments. Once dry, this product is flame resistant and formulated to not burst into flame when directly exposed to shipboard fire conditions. This product is particularly suited for use on primed, interior surfaces of marine vessels and offshore platforms. It may be applied by brush, roller or spray to smooth metal, glass reinforced plastic (GRP), wood, and composite/plastic surfaces. Dry characteristics of this product include good retention of color and gloss as well as maintaining flexibility over time. This paint is a lead-free, non-chromate, and non-asbestos product.

MILITARY SPECIFICATION

MIL-DTL-24607B complies with Detail Specification MIL-DTL-24607B, dated October 12, 2010.

APPLICATION PROPERTIES

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| 1) Volatile Organic Compound (VOC)
(EPA Method 24): | Less than 250 g/L (2.08 lb/gal) |
| 2) Color: | Available in most Fed. Std. 595 colors |
| 3) Finish: | Semi-gloss |
| 4) Weight Solids: | 77% ± 2% depends on color |
| 5) Volume Solids: | 63% ± 2% depends on color |

USE PROPERTIES

- | | |
|-------------------------------------|--|
| 1) Shelf Life: | 1 year from date of manufacture (if unopened) |
| 2) Flash Point (SETA): | 101°F (38.3° C) |
| 3) Reducer: | Do not reduce |
| 4) Tinting: | Do not tint |
| 5) Clean Up: | Mineral Spirits |
| 6) Brush and Roller Recommendation: | Natural bristle brush
3/8" woven roller cover with solvent resistant core |
| 7) Application Temperature: | 50°-90°F (10°-32.2° C) for surface, paint, and ambient air |

TECHNICAL DATA SHEET

NOTE: need to be at least 5°F above dew point

- 8) Application Humidity: Maximum of 85% relative humidity
- 9) Storage: Store product in accordance with local, state and federal regulations. Keep container tightly sealed and store indoors in dry conditions at 50°-80°F (10°-26.7°C).

RECOMMENDED COATING SYSTEMS

Steel and Aluminum: 1 coat TT-P-645B or MIL-DTL-24441D/formula 150 applied at 1.8-3.5 mils (45-88 microns) dry thickness.
2 coats MIL-DTL-24607B applied at 1.5-2.0 mils (40-50 microns) dry thickness.

Wood, Previous Painted Material:
2 coats MIL-DTL-24607B applied at 1.5-2.0 mils (40-50 microns) dry thickness.

SURFACE PREPARATION

Surface must be clean, dry and in sound condition, free from loose mill scales, dirt, dust, rust, oil and grease. Remove all loose scales, peeling, flaking paint, rust, corrosion and chalk from the surface before painting.

1) Steel, Iron

- Minimum surface prep: Hand Tool Cleaning per SSPC-SP2
- Additional surface prep: Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material)
- Better performance surface prep: Commercial Blast Cleaning per SSPC-SP6/NACE No. 3. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils/50 microns)

Prime bare steel within 8 hours or before flash rusting occurs.

2) Aluminum

- Recommended surface prep: Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material). Use primer.

3) Galvanized Steel

- Weathered for greater than 6 months: Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material).

New or treated with chromates or silicates:

Solvent Cleaning per SSPC-SP1 (removing oil, grease, dirt, and other foreign material). Apply first to a test area, and test adhesion after one week. If adhesion is weak, brush-off blast per SSPC 7/NACE No. 4.

- Rusted: Hand Tool Cleaning per SSPC-SP2. Use primer once dry.

4) Wood

Sand smooth. Surface must be clean and dry. Do not paint in wet or foggy conditions. Priming is not necessary.

5) Previous Painted Surfaces

TECHNICAL DATA SHEET

If previous paint is significantly weathered or peeling, remove the previous paint and clean the surface. If the previous paint is in good condition, clean the surface of any dust, dirt, rust, oil and grease. Abrade any smooth, hard or glossy surfaces to a dull appearance to promote adhesion. Apply first to a test area, and test adhesion after one week. If adhesion is weak, or this product degrades the original finish, remove previous coating for best performance.

APPLICATION INSTRUCTIONS

- 1) Complete surface preparation as indicated prior to application of product.
- 2) Mix paint thoroughly with low speed power agitation prior to use.
- 3) Apply paint at the recommended film thickness and spreading rate. Applying the paint above maximum or below minimum recommended spreading rate can have negative effects on performance.

RECOMMENDED SPREADING RATE PER COAT

1) Approximate Coverage	<u>ft²/gal</u>	<u>m²/L</u>
Minimum:	450 ± 20 sq.ft.	11.0 ± 0.5 sq. meters
Maximum:	640 ± 20 sq.ft.	15.7 ± 0.5 sq. meters
2) Wet mils	<u>mils</u>	<u>microns</u>
Minimum:	2.5 mil	63
Maximum:	3.5 mil	88
3) Dry mils		
Minimum:	1.5 mil	40
Maximum:	2.0 mil	50

Application by brush or roller may require multiple coats to lay down the maximum film thickness and to achieve a uniform appearance.

DRYING TIME

	<u>@50°F (10°C)</u>	<u>@77°F (25°C)*</u>
To Touch:	3 hours	2 hours
To Recoat:	10 hours	6-8 hours
To Cure:	14 days	14 days

NOTE: These times are approximations and will change depending on temperature, humidity, and thickness of applied film. * - Tested at 50% relative humidity.

ORDERING INFORMATION

Sizes:	1 gallon can, 5 gallon can (3.78L, 18.9L)
SKU:	24607-[Fed std color number]-GL, 24607-[Fed std color number]-CN
Website:	http://www.milspeccoating.com

SAFETY

Refer to the Material Safety Data Sheet (MSDS) before using this product, for safe use, handling and storage.

OTHER INFORMATION

TECHNICAL DATA SHEET

HEALTH AND SAFETY INFORMATION:

Refer to Material Safety Data Sheet for health and safety information before using this product. Also, for additional information, please visit the website at www.sticadhesive.com.

LIMITATION OF REMEDIES AND LIABILITY:

If the STIC-ADHESIVE product is proved to be defective, the exclusive remedy, at STIC-ADHESIVE'S option, shall be to refund the purchase price or replace the defective product. STIC-ADHESIVE shall not otherwise be liable for loss or damages, regardless of the legal theory, including but not limited to contract, negligence, warranty, or strict liability.

DISCLAIMER:

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