

## 4500-P-23 (B,G,Y)

Strontium Chromate Epoxy Primer

4500-P-23 is a fluid and corrosion resistant epoxy/polyamide primer. It is specifically designed for the aerospace industry's demanding performance requirements for interior components.

### SPECIFICATION

(B) **DHMS.C4.01 Type 2, Grade A**  
(G, Y) **BAMS 565-001, GR.A, Cat.1, Ty. 1**

### OUTSTANDING CHARACTERISTICS

- Excellent Adhesion
- Excellent Hydraulic Fluid Resistance (Skydrol)
- Outstanding Solvent Resistance
- Superb Corrosion

### PHYSICAL DATA

Finish:	Flat primer finish
Colour:	B-Green (FS 34258), G-Green (BAC 452) and Y-Yellow (BAC 377)
Weight Solids:	52.06% ± .5%
Volume Solids:	34.76% ± .5%
V.O.C.	557 g/L
Density:	9.75 lbs/USG
Dry Film Weight:	0.009 lbs/ft <sup>2</sup> /mL 1.81 g/m <sup>2</sup> /μ

### RECOMMENDED SYSTEMS

- 6600, 6700, 6800 - Lines DHMS C4.04 Ty. 4
- 4600, 4700, 4800 - Lines DHMS C4.04 Ty. 2
- 7600, 7700, 7800 - Lines BAMS 565-002

Note: all physical and chemical resistance tests conducted after one week cure time at 20-25°C (70-75°F) on properly cleaned substrate.



### SURFACE PREPARATION

Chemical conversion coating per MIL-C-5541 Class 1A, or BAPS 160-020.

-OR-

Chromic acid anodize and seal per MIL-A-8625 Type I or BAPS 160-010



### INSTRUCTIONS FOR USE

Components:	Two
Cure:	4500-C-23
Mix Ratio:	1:1 by volume, Base / Cure
Induction Time:	15-30 minutes
Pot Life:	8 hours @ 25°C (75°F)
Reducer:	4500-S-23/23X



### MIXING INSTRUCTIONS

Mix 1:1 by volume Base/Cure, reduce as required to reach required spray viscosity. We recommend using a squirrel mixer or equivalent and mix thoroughly for 5 minutes minimum. Allow 15 - 30 minutes induction time before using. Mix only sufficient material to use within a 8-hour period. Always add Cure component to Base component - **NEVER THE REVERSE**. Never mix coating or individual component from one vendor with that of another vendor.



### SPRAYING VISCOSITY

14-23 seconds #2 EZ Zahn



### APPLICATION METHOD

Allow for application loss and surface irregularities.

Application:	Conventional or HVLP
Reduction:	Reduce with 4500-S-23/23X

## RESISTANCE TABLE

<b>Impact Resistance</b>	No flaking or cracking when subjected to 50 inch pounds Impact direct and 30 inch pounds reverse.
<b>Hardness</b>	Pencil Hardness F minimum
<b>Fuel Resistance</b>	Withstands immersion of Jet A1 Fuel for 14 days at ambient Temperatures without showing any defects. After a 24 hour recovery period, the primer regains its pretest hardness.
<b>Lubricating Oil Resistance</b>	Withstands immersion in lubricating oil at 25°C for 14 days without showing any softening, blistering, or loss of adhesion.
<b>Hydraulic Fluid Resistance</b>	Withstands immersion in Skydrol hydraulic fluid without showing any defects after 30 days.
<b>Salt Spray Resistance</b>	With a scribed film at an angle of 6°, it exhibits no blistering, lifting of the primer, or substrate corrosion after exposure to 5% salt spray following ASTM B117 on treated aluminum substrate 3000 hours.
<b>Water Resistance</b>	No blistering or loss of adhesion after 14 hours immersion in distilled water at ambient temperature. Regains its pretest hardness after a recovery period of 24 hours.

## SUBSTRATES:

- Aluminum



## EQUIPMENT

Using a Binks Mach I HVLP with a 93P or 92AP air cap and a #92 Fluid tip, inlet pressure should be approximately 70-80 PSI (9 PSI at air cap) and 10-12 PSI on the pressure pot. Accuspray 19 or 12 series HVLP, use a #36 or #43 fluid tip and needle with a #6 air cap with approx 22 to 40 PSI inlet pressure (5-9 at the air cap) and 10-12 PSI on the pressure pot. For Accuspray 10 series HVLP cup gun use a #36 or #43 fluid tip and needle with a #6 air cap with approx 5-9 inlet pressure. Devilbiss JJ502 conventional spray gun uses a 765-air cap and a .0425 needle nozzle with 45-55 PSI gun pressure and 10-12 on pressure pot.



## RECOMMENDED FILM BUILD THICKNESS & COVER RATE

Total Dry Film Recommendation 0.5 – 0.8 Mils (12.5 - 20 microns)  
Calculated Coverage at:

1.0 Mils:	551 ft <sup>2</sup>
25 Microns:	51.20 m <sup>2</sup>



## ENVIRONMENTAL CONDITIONS

Temperature: 15 - 35°C (59 - 95°F)  
Relative Humidity: 10 - 80%

Note: Substrate and air temperature must be a minimum of 3°C (5°F) above the Dew Point



## DRY TIME

Dry time at 24°C ± 3°C (75°F), 50% relative humidity.

To Touch:	10 mins
Tack Free:	< 1 hour
To Recoat:	1 - 2 hours
Dry Through:	< 8 hours
Dry hard:	< 24 hours

May be forced dried: Flash off is 15 - 30 minutes at R/T  
Force Dry 60 - 90°C (140 - 200°F) for 20 - 30 minutes



## CLEAN UP

Cleaner: 20-4301, 4500-S-23/23X, S-10



## STORAGE & SHIPPING

Flash Point: 2°C  
Shelf Life: 24 months unmixed for unopened cans



## SAFETY PRECAUTIONS

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only.