

XE-7156
Zinc Chromate Primer



Intended Uses:

XE-7156 is a Zinc Chromate, low- moisture sensitive, Corrosion Inhibiting Primer designed for application to aluminum that has been surface treated or coated with MIL-C-8514C or DOD-P-15328D wash primers. This primer meets the performance of TT-P-1757A.

Physical Properties

Color:	Yellow	Substrate Tested:	Pretreated Aluminum
Gloss:	<6 at 60°	Salt Spray (B117): Q-Steel panels prepared at a combined primer/top coat system of 3.0-4.0 dft	1000 hrs
Volume Solids:	35 +/- 2%	Humidity:	N/A
Weight Solids:	56 +/- 2%	Pencil Hardness:	3B
Weight Per Gallon:	10.6 +/- 0.3 lbs/gallon	Impact Direct/Indirect:	20 inch-pounds
Theoretical Coverage:	554 sq ft/gal @ 1 mil dft	Crosshatch Adhesion:	Pass 5
VOC:	4.7 lbs/gallon		
Recommended Film Thickness:	0.9-1.2 mil above profile		
Viscosity:	40 - 60 seconds #4 Ford.		
Conductivity:	5.0 - 20 Megaohms		

Application Characteristics

Mix Ratio:	Single Component			
Reducer:	Xylene, Aromatic 100 or T-394 MIL-T-81772B Type III reducer			
Cleaning Solvent:	Xylene, MEK, or Acetone			
Pot Life:	N/A			
Dry Times:	Touch: 15 min	Recoat: After 1 hour	Handle: 3-4 hrs	Pack/Ship: 24 hrs
Force Cure:	This product can be force cured, call for specific recommendations			
Full Cure:	1 week			
Note: Test Performed @ 77° F 50% Relative Humidity				

Recommended Primers

Substrate	Recommended Primer
Aluminum/Galvanized Steel/Stainless Steel:	B-875/T-63 or N-8564A/B Wash Primer
Ductile or Grey Iron Castings:	Apply the XE-7156 directly to clean steel.
Plastics:	Due to the wide variety of plastic/fiberglass substrates, the system performance should be tested and confirmed on actual substrate.
Previously Painted Surfaces:	Surface should be intact and sound. All loose and flaking material removed and bare spots primed with an appropriate primer. An area should be tested with the coating to assure compatibility.
Steel:	Apply the XE-7156 directly to the clean steel.
Wood:	Due to the wide variety of wood substrates, the system performance should be tested and confirmed on actual substrate.

Technical Data Sheet



Application Equipment

Conventional Electrostatic:	Air Pressure: N/A	Fluid Pressure: N/A	Cap: N/A Tip:
Conventional Spray:	Air Pressure: 10 - 30 psi	Fluid Pressure: 20 - 40 psi	Cap: Tip: 1.5
HVLP Spray:	Air Pressure: 10 psi	Fluid Pressure: 20 - 40 psi	Cap: Tip: 1.5
Air Assisted Airless:	Air Pressure: 20 - 40 psi	Fluid Pressure: 950 psi	Cap: Tip: 0.011 - 0.013"
Airless:	Pressure: 3000 psi	Tip: 0.013"	
Brush and Roll: The use of natural china chip bristle brushes or 1/4" maximum nap mohair type rollers is highly recommended to limit the amount of orange peel.			
Note: The above parameters are to be used as a guideline only. Customer specific equipment may require a different set-up			

Surface Preparation

Do not apply if the application surface temperature is below 45°F (7°C) or above 110°F (43°C), or if the surface temperature is within 5°F of the dew point. It is highly recommended that sound practices as set forth by SSPC or NACE be followed when preparing a substrate for painting. At a minimum the surface should be clean of all grease, dirt, oil, rust and foreign material that would be detrimental to proper adhesion and desired performance of the coating system being applied.

Safety Precautions

This product is intended for professional use in an industrial environment only! Consult the Material Safety Data Sheet prior to application for detailed information on the health and safety hazards.

Shelf Life & Storage Conditions

Shelf life (protected from atmospheric moisture): 12 months from the date of manufacture. This product must be stored in accordance with local, state, and national regulations. Preferred storage conditions: Keep containers in a dry space with adequate ventilation.

Comments

Use of a mechanical mixer is highly recommended. For additional information contact your NCP Coatings, Inc. Sales Representative, Customer Service Representative, or visit our website: www.ncpcoatings.com

Note

The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, application and testing requirements for their specific job!