

TECHNICAL DATA SHEET

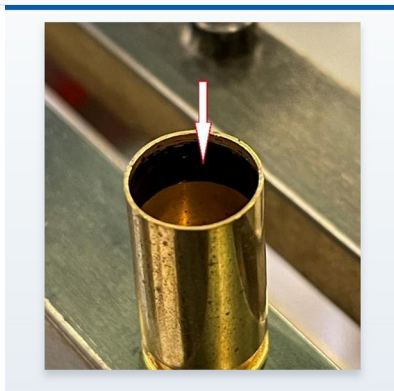
B4204 | Bitumen Varnish (case-mouth sealing)

PRODUCT DESCRIPTION

Kind of product	Solvent-based, single-coat varnish in accordance with: MIL-C-450B, Type 1 (spraying) and Type 2 (brushing) MIL13783C NATO AEP-97, AOP-4090 and AOP-4172 German TL8010
Product USP	Adjustable drying time (4 min to 72 h) Long-term shelf-life guarantee in accordance with NATO AOP-4172, Chapter 19a, and AEP-97 Vol. 13 climatic storage test (-55°C) Passed all bullet pull-out strength tests (ISO 10123) Passed the watertightness test in accordance with AEP-97 for all calibre sizes
Properties	Sealing compound with chemical resistance and long-term flexibility; remains flexible at low temperatures (NATO: -55°C) Ignition temperature > 260°C
Field of application	Sealing between the cartridge case neck and bullet (case-mouth sealing) in accordance with NATO standard AEP-97, as well as coating the interior of the cartridge
Colour	Black
Gloss level	Glossy (DIN EN ISO 2813-2)
Packaging units	1/2/5/10/20/25 kg drums

TECHNICAL DATA

Total solids	Type 1: 40%; Type 2: 50% (1 = spraying, 2 = brushing)
Density at 20°C	approx. 0.85-1.0 g/cm³
Viscosity	30-45 sec, adjustable (DIN 4 mm cup)
Flash point	< 27°C (DIN EN ISO 1523)



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APPLICATION

Substrate pre-treatment	The substrate should be clean, dry and free from contamination.
Substrate condition	Phosphatised steel should be overcoated as soon as possible.
Application temperature	Room, material and substrate temperatures: 15-30°C
Use	Stir thoroughly before use
Application	Spraying: Depending on film thickness, application technique and temperature, add up to 10% thinner. Brushing: Add up to 10% thinner if necessary.
Spray settings	Material pressure (bar): pressure-controlled 0.5-1.0; air-pressure - Spray pressure (bar): pressure-controlled 3-4; air-pressure 3-4 Nozzle size (mm): pressure-controlled 1.2-2.0; air-pressure 1.2-2.0
Thinner	T67 André Thinner T70 André Thinner
Recommended dry film thickness	25 µm
Theoretical yield (consumption)	20 m²/kg (50 g/m²)
Drying conditions	At the recommended dry film thickness 20°C / 60% relative humidity Dust-free: > 5 min Tack-free: > 30 min
Cleaning of tools	Rinse tools with André Thinner T67 / T70 immediately after use.

SPECIAL ADVICE

Safety instructions	See MSDS (Material Safety Data Sheet)
Storage	Approx. 1 year or longer when stored in a cool, dry place For further instructions, see MSDS Section 7
Date of issue	Rev. Feb 2025