

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy primer
Description	A high solids epoxy primer for steel and concrete. It is used to increase adhesion and reduce the potential for outgassing on concrete substrates. It can also be used to prevent abrasive blasted steel from developing rust bloom prior to the application of a coating or lining system.
Features	<ul style="list-style-type: none"> • Tolerant to moisture vapor transmission (<5 lbs per 1000 ft² / <24.4 g/m²) • Meets most VOC Requirements • Low Odor • User Friendly
Typical Uses	<ul style="list-style-type: none"> • Secondary Containment • Storage Tanks • Structural Steel • Pump Housings and Floors (Spillage)
Color	Clear (0000)
Dry Film Thickness	3 - 4 mils (76 - 102 microns) per coat
Solids Content	By Volume 84%
Theoretical Coverage Rate	1347 ft ² /gal at 1.0 mils (33.1 m ² /l at 25 microns) 449 ft ² /gal at 3.0 mils (11.0 m ² /l at 75 microns) 337 ft ² /gal at 4.0 mils (8.3 m ² /l at 100 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 120 g/L
Topcoats	Epoxies and urethanes. Topcoat selection will depend on exposure
Application	For maximum performance, all steel surfaces should be primed. Concrete, however, must always be primed to aid in the “wetting out” required for good adhesion.

SUBSTRATES & SURFACE PREPARATION

General	<p>With all epoxies after priming and before each additional coat, examine the surface for amine blush (oily film). If present, remove by washing with warm water and detergent.</p> <p>Concrete shall be designed, placed, cured, and prepared per NACE No. 6/SSPC-SP 13, latest edition. Abrade to remove all laitance, loose concrete, etc. and to create surface profile in accordance with ICRI CSP 2 or greater.</p>
Concrete	<p>The prepared surface should have a tensile strength of 250 PSI per ASTM D-7234.</p> <p>All concrete substrates must be checked for moisture prior to product application using the Plastic Sheet Test, ASTM D-4263. If moisture is present the use of Vapor Stop Primer may be required. Consult your Dudick representative for further information about moisture vapor transmission or specific profile requirements which are dependent on the selected topcoat.</p>

Primer 67

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Ferrous Metal	Surfaces must be abrasive blasted to an appropriate finish according to the topcoat's product data sheet or System Information Sheet. If not listed, minimums are below: <u>Immersion and heavy spillage service:</u> White Metal SSPC SP-5 or NACE No.1, 3.0 mil minimum profile. <u>Heavy, non-immersion service (i.e. fumes and spillage):</u> Near white SSPC SP- 10 or NACE No.2, 2.0 mil minimum profile. <u>Atmospheric service:</u> Commercial SSPC SP-6 or NACE No.3, 2.0 mil minimum profile.
Non-Ferrous Metals	Surface profile should be a dense angular 1.5 - 3 mils and is best achieved through abrasive blasting in accordance with SSPC-SP16 for atmospheric exposure, or SSPC-SP17 for immersion environments.

PERFORMANCE DATA (TYPICAL VALUES)

Test Method	Results
Adhesion to Concrete ASTM D7234	Cohesive Failure of concrete
Adhesion to Steel ASTM D4541	2,200-2,500 PSI (15.2-17.2 MPa)
Tensile Elongation ASTM C-307	20-25%
Tensile Strength ASTM C307	2,000 - 2,500 PSI (15.2-17.2 MPa)

MIXING & THINNING

Mixing	Mix Part A with power mixer. Then mix the pre-measured unit of Part A with Part B until homogenous.
Thinning	DO NOT THIN
Ratio	1:1 by volume (A:B)
Pot Life	The pot life will depend on the temperature. To prevent material waste and avoid damage to equipment, do not mix more material than can be used according to the following: 90 minutes @ 50°F (10°C) 60 minutes @ 75°F (24°C) 30 minutes @ 90°F (32°C) Do not attempt to store mixed material. Residual material should be properly disposed of at the end of each work period.

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

General | Brush and/or roller

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Spray Application	Pump Ratio: 30:1 or greater, capable of at least 1 GPM. Filters: 60 mesh filters Material Hose: 3/8" I.D. (min.), 3000 psi or greater rated. Tip Size: 0.15-0.19" Output PSI: 2500-3000 psi (min.) Gun: Airless gun rated for at least 3000 psi. When siphon feed is used, change the pail out as frequent as necessary to avoid exotherm of the catalyzed material.
Brush & Roller (General)	Use a short-nap mohair roller cover with solvent resistant core. For best results, condition roller before application to minimize lint or loose fibers. A high quality solvent resistant brush may be used for hard to reach areas.

APPLICATION PROCEDURES

General	Prime all surfaces to be coated at 3-4 mils (76-102 microns). Do not allow the primer to puddle. At stated minimum recoat times, primer may still be tacky. To optimize intercoat adhesion, it is recommended to apply the basecoat over primer that is tacky. If this is not possible, adhere to maximum recoat times referenced in the curing schedule.
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APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	60°F (16°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	80°F (27°C)	110°F (43°C)	110°F (43°C)	90%

Substrate temperature must be 5°F (3°C) above dew point.

CURING SCHEDULE

Surface Temp.	Minimum Recoat Time	Maximum Recoat Time	Cure for Service
50°F (10°C)	4 Hours	5 Days	5 Days
75°F (24°C)	2 Hours	3 Days	3 Days
90°F (32°C)	1 Hour	2 Days	2 Days

- To optimize intercoat adhesion Primer 67 may be top coated once it is dry enough to be tacky but does not transfer when touched.
- Application in direct sunlight may lead to blistering, pinholes, or wrinkling due to outgassing of air in the concrete and high substrate temperatures. Double priming, shading, or evening application may be required.
- Exposure of the primer to direct sunlight or heat will considerably shorten the recoat times.
- If recommended recoat times are exceeded, sanding or abrasive blasting may be required before further coats can be applied.

TESTING / CERTIFICATION / LISTING

General	Dudick flooring systems can be built to meet or exceed the requirements of Static or Dynamic Coefficient of Friction testing per installation to meet static coefficient of friction requirements for ANSI B101.1 of >0.6 and dynamic coefficient of friction (DCOF)* – Wet ANSI A326.3 of >0.42.
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PRODUCT DATA SHEET



CLEANUP & SAFETY

Cleanup	Use S-10 Cleaning Solvent or Carboline Thinner 2 to clean tools and equipment.
Safety	Read and follow all caution statements on this product data sheet and on the SDS. Employ normal safety precautions. Keep container closed when not in use.
Ventilation	Ventilation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. Use MSHA/NIOSH approved air respirators as needed.
Caution	Fire and explosion hazards: This product contains less than 1% volatile components, however, vapors are heavier than air and can travel long distances, ignite and flash back. Eliminate all ignition sources. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Packaging	1 Gallon Kits: Part A: 0.5 Gallons (in a 1 gal can) Part B: 0.5 Gallons (in a 1 gal can) <hr/> 5 Gallon Kits: Part A: 2.5 Gallons (in a 5 gal pail) Part B: 2.5 Gallons (in a 3.5 gal pail)
Shelf Life	Part A: 12 months Part B: 12 months When stored in their original, unopened containers. Exposure to excessive heat may cause premature gelling, reduce working time and shelf life.
Storage	All products should be stored in a cool, dry area away from open flames, sparks or other hazards. Warning: All Dudick, Inc. products classified by DOT with either white, yellow or red labels, must not be mixed or stored together as an explosive reaction can occur.
Shipping Weight (Approximate)	1 Gallon Kit (3.79 liter kit): 14.6 lbs (6.6 kg) 5 Gallon Kit (18.9 liter kit): 49.4 lbs (22.4 kg)

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.