



Industrial
&
Marine
Coatings

RECOATABLE EPOXY PRIMER

4.45

PART G B67A5 GRAY
PART G B67H5 TAN
PART G B67R5 RED OXIDE
PART H B67V5 HARDENER

PRODUCT INFORMATION

Revised 8/05

PRODUCT DESCRIPTION	RECOMMENDED USES																												
<p>RECOATABLE EPOXY PRIMER is a rust inhibitive high build catalyzed polyamide/bisphenol A epoxy primer designed for fast dry and quick or extended recoatability.</p> <ul style="list-style-type: none"> • Meets Class A requirements for Slip Coefficient .50 • Long pot life • High build coating for economical application • One year recoatability • Low temperature application - down to 35°F • Corrosion resistant 	<p>For use as a shop or field applied epoxy primer where a variable recoat window is required due to construction schedules, distribution logistics and environmental considerations. Allows flexibility in projects when completion schedules cannot be specified.</p> <ul style="list-style-type: none"> • Primer for structural steel • Paper mills • Power plants • Suitable for use in USDA inspected facilities • Marine applications • Storage tanks 																												
PRODUCT CHARACTERISTICS	PERFORMANCE CHARACTERISTICS																												
<p>Finish: Flat</p> <p>Color: Red Oxide, Tan, Gray</p> <p>Volume Solids: 65% ± 2%, mixed</p> <p>Weight Solids: 81% ± 2%, mixed</p> <p>VOC (EPA Method 24): Unreduced: <320g/L; 2.87 lb/gal mixed Reduced 5%: <340 g/L; 2.88 lb/gal mixed</p> <p>Mix Ratio: 1:1 by volume</p> <p>Recommended Spreading Rate per gal: Wet mils: 6.0 - 9.0 Dry mils: 4.0 - 6.0 Coverage: 175 - 250 sq ft/gal approximate</p> <p>NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.</p> <p>Drying Schedule 6.0 mils wet @ 50% RH:</p> <table border="1"> <tr> <th>Temp</th> <th>35°F</th> <th>77°F</th> <th>120°F</th> </tr> <tr> <td>To touch:</td> <td>1 hour</td> <td>15 minutes</td> <td>10 minutes</td> </tr> <tr> <td>Tack free:</td> <td>2 hours</td> <td>30 minutes</td> <td>15 minutes</td> </tr> <tr> <td>To recoat:</td> <td>8 hours</td> <td>2 hours</td> <td>30 minutes</td> </tr> <tr> <td>minimum:</td> <td>1 year</td> <td>1 year</td> <td>1 year</td> </tr> <tr> <td>maximum:</td> <td>14 days</td> <td>14 days</td> <td>2 days</td> </tr> <tr> <td>To cure:</td> <td>8+ hours</td> <td>8 hours</td> <td>3 hours</td> </tr> </table> <p>Pot Life: 1 hour 30 minutes 10 minutes if maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</p> <p>Shelf Life: 36 months, unopened Store indoors at 40°F to 100°F.</p> <p>Flash Point: 80°F, PMCC, mixed</p> <p>Reducer/Clean Up: Below 80°F - Reducer #54, R7K54 Above 80°F - Reducer #100, R7K100</p>	Temp	35°F	77°F	120°F	To touch:	1 hour	15 minutes	10 minutes	Tack free:	2 hours	30 minutes	15 minutes	To recoat:	8 hours	2 hours	30 minutes	minimum:	1 year	1 year	1 year	maximum:	14 days	14 days	2 days	To cure:	8+ hours	8 hours	3 hours	<p>System Tested: (unless otherwise indicated)</p> <p>Substrate: Steel</p> <p>Surface Preparation: SSPC-SP6/NACE 3</p> <p>1 qt. Recoatable Epoxy Primer @ 6.0 mils dft</p> <p>Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load Result: 200 mg loss</p> <p>Accelerated Weathering - QUV, Acrolon 218 HS topcoat: Method: ASTM D4587, QUV-A, 5,000 hours Results: passes</p> <p>Adhesion: Method: ASTM D4541 Result: 1050 psi</p> <p>Corrosion Weathering: Method: ASTM D5894, 13 cycles, 4,368 hours Result: Rating 10 per ASTM D714 for blistering Rating 7 per ASTM D610 for rusting</p> <p>Direct Impact Resistance: Method: ASTM D2794 Result: 160 in. lbs.</p> <p>Dry Heat Resistance: Method: ASTM D2485 Result: 250°F (discolor)</p> <p>Flexibility: Method: ASTM D522, 180° bend, 1" mandrel Result: Passes</p> <p>Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 2000 hours Result: Passes, no cracking or delamination</p> <p>Pencil Hardness: Method: ASTM D3363 Result: 3H</p> <p>Salt Fog Resistance, Acrolon 218 HS topcoat: Method: ASTM B117, 5,600 hours Result: Passes, no cracking or delamination</p> <p>Slip Coefficient, Red Oxide: Method: AISC Specification for Structural Joints Using ASTM A325 or ASTM A490 Bolts Result: Class A, 0.50</p> <p>Epoxy coatings may darken or yellow following application and curing. Provides performance comparable to products formulated to federal specifications: MIL-P-23377, MIL-P-53022</p>
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