

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy primer
Description	A high solids epoxy primer for steel and concrete. Designed 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"> • Meets most VOC Requirements • Low Odor • User Friendly • Tolerant to moisture vapor transmission (<5 lbs per 1000 ft² / <24.4 g/m²)
Color	Clear
Dry Film Thickness	3 - 4 mils (76 - 102 microns) per coat
Typical Uses	Primer for epoxy and urethane systems
Solids Content	By Volume 85%
Theoretical Coverage Rate	1363 ft ² /gal at 1.0 mils (33.5 m ² /l at 25 microns) 454 ft ² /gal at 3.0 mils (11.2 m ² /l at 75 microns) 341 ft ² /gal at 4.0 mils (8.4 m ² /l at 100 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 120 g/L
Topcoats	Topcoat selection will depend on exposure Contact Dudick for recommendations.
Application	For maximum performance, all steel surfaces should be primed. Contact a Dudick representative for system recommendations. Concrete, however, must always be primed to aid in the “wetting out” required for good adhesion.

SUBSTRATES & SURFACE PREPARATION

General	Important - 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.
Steel	Surfaces must be abrasive blasted to an appropriate finish. Immersion and heavy spillage service: White Metal SSPC SP-5 or NACE # 1, 3.0 mil minimum profile. Heavy, non-immersion service (i.e. fumes and spillage): Near white SSPC SP- 10 or NACE #2, 2.0 mil minimum profile. Atmospheric service: Commercial SSPC SP-6 or NACE #3, 2.0 mil minimum profile.
Concrete	Refer to System Information Sheet where Primer 67 is being used for concrete surface preparation requirements.

Primer 67

PRODUCT DATA SHEET



PERFORMANCE DATA (TYPICAL VALUES)

Test Method	Results
Adhesion to Concrete ASTM D-7234	Cohesive Failure of concrete
Adhesion to Steel ASTM D-4541	2,200-2,500 PSI (15.2-17.2 MPa)
Tensile Elongation ASTM C-307	20-25%
Tensile Strength ASTM C-307	2,000 - 2,500 PSI (15.2-17.2 MPa)

MIXING & THINNING

Mixing | Mix Component A with power mixer. Then mix the pre-measured units of Primer 67 Component A with Component B.

Thinning | DO NOT THIN

Ratio | 1:1, by volume

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)

At 75°F (24°C) the pot life will be shortened by the addition of Accelerator #1 as follows: Ozs./ Accelerator #1 per mixed gallon Primer 67:

36 minutes with 3-4 oz

15 minutes with 6-7 oz

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 | Recommended application for Primer 67 shall be brush or roller.

Spray Application | Contact Dudick representative for recommendations for spray applications.

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.

APPLICATION CONDITIONS

Condition	Surface	Humidity
Minimum	50°F (10°C)	0%
Maximum	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
50°F (10°C)	12 Hours	8 Days
75°F (24°C)	6 Hours	5 Days
90°F (32°C)	4 Hours	3 Days

Dry to Touch time with 3-4 oz of Accelerator #1 is 4 hours, with 6-7 oz of Accelerator #1 is 2 hours.

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. Consult a Dudick representative.

Exposure of the primer to direct sunlight will considerably shorten the recoat times. If recommended recoat times are exceeded, consult a Dudick Representative; sanding or abrasive blasting may be required before the coating, lining or floor topping 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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CLEANUP & SAFETY

Cleanup | Use S-10 Cleaning Solvent 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.

PACKAGING, HANDLING & STORAGE

Packaging	1 Gallon Kit (3.79 liter kit) 5 Gallon Kit (18.9 liter kit)
Shelf Life	6 months @ 50-75°F (10°C-24°C) 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)

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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.