Primer 67DTO

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy primer
Description	A high solids epoxy primer for concrete and steel that has previously been exposed to oils, grease, or fats. Specially designed to increase adhesion and reduce the potential for outgassing in high performance containment and linings systems
Features	• Meets most VOC Requirements • Distinct, Low Odor • User Friendly • Tolerant to moisture vapor transmission (<5 lbs per 1000 ft^2 / <24.4 g/m^2)
Color	Translucent Grey
Dry Film Thickness	4 - 6 mils (102 - 152 microns) per coat
Typical Uses	Primer for epoxy and urethane systems
Solids Content	By Volume 85%
Theoretical Coverage Rate	1363 ft²/gal at 1.0 mils (33.5 m²/l at 25 microns) 341 ft²/gal at 4.0 mils (8.4 m²/l at 100 microns) 227 ft²/gal at 6.0 mils (5.6 m²/l at 150 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	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. Consult your Dudick representative for more information about the right surface profile for your coating system

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	10-15%
Tensile Strength ASTM C-307	1,400 - 2,200 PSI (9.7 - 15.2 MPa)

MIXING & THINNING

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

Thinning | DO NOT THIN

Ratio | 1.8:1, 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 @ 50ºF (10ºC)
40 minutes @ 75ºF (24ºC)
25 minutes @ 90ºF (32ºC)

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 DTO should be by brush, roller, or squeegee.

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 4-6 mils. Do not allow the primer to puddle.
At stated minimium 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	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	20%
Maximum	90°F (32°C)	110°F (43°C)	90°F (32°C)	90%
Optimum	75°F (24°C)	75°F (24°C)	75°F (24°C)	50%

Substrate temperature must be 5ºF (3ºC) above Dew Point.

CURING SCHEDULE

Surface Temp.	Minimum Recoat Time	Maximum Recoat Time
50°F (10°C)	14 Hours	72 Hours
75°F (24°C)	8 Hours	48 Hours
90°F (32°C)	4 Hours	24 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 or higher temperatures will considerably shorten the recoat times. If maximum recoat times are exceeded, sanding or abrasive blasting may be required before the coating, lining or floor topping can be applied.
At lower temperatures cure times will be longer. Final cure will take place in 5-7 days. When using as a primer for coving material the coving should be applied into wet or tacky primer or, if they are to be applied onto a tack free primer, a sand broadcast should be applied to ensure the mortar does not slip during application.

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.

CLEANUP & SAFETY

Cleanup | Use S-10 Cleaning Solvent, MEK, or Acetone 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): 13.94 lbs (6.3 kg)
- 5 Gallon Kit 18.9 liter kit): 49.4 lbs (22.8 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.