



PRODUCT GUIDE: CATALYZED PRIMERS

Version: 08.07.17



PRODUCT DATA

305

Zinc Rich Epoxy Polyamide Primer

Description: 305 is a user friendly zinc-rich epoxy primer formulated for use as a primer under acrylic, epoxy, and urethane finish coats.

Typical Uses: Zinc-rich epoxy primer to applied over abrasive blast cleaned surfaces or as a field maintenance primer. May be used to repair itself or inorganic zinc primers. Zinc pigment provides cathodic protection and film undercutting resistance to corrosion. Performance similar to hot-dipped galvanizing.

Dry Temperature Limits: 225 deg.F

Surface Cleanliness: NACE No.3/SSPC-SP 6 Commercial Metal Blast

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.3 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Mixing: Mix only complete units. Power mix the activator and base separately, then combine. After mixing activator and base gradually sift in the zinc dust portion under constant agitation. Never dump the zinc dust portion into the activator as it will lump up and be unusable. Do not thin until all components have been mixed together thoroughly. Strain through 30 to 60 mesh screen into agitator-equipped container and immediately turn agitator on at slow speed. Maintain constant agitation during use.

Application Equipment: Airless or conventional spray using agitated containers. Conventional Spray: Binks Model 18 Gun with 67 Fluid Nozzle, 67PB Air Nozzle, and 67 Needle. Airless Spray: Minimum 30:1 ratio pump with teflon packings, a 60 mesh filter and .017" to .019"(432-483 microns) orifice tip on gun. Supply lines should not exceed 50 feet. For longer supply lines use 1/2" I.D. airless lines

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a

Thinner: T-35 Thinner up to 1/2 pint per gallon

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: matte

Color: reddish gray

Volume Solids: 54% +/- 2%, (mixed)

VOC: 3.2 lbs./gal. (374 g/l), (mixed)

Mixing Ratio: mix only complete units

Dry Film Thickness: 2.5 mils

Wet Film Thickness: 4-1/2 mils

Theoretical Coverage: 866 sq.ft./gal. @ 1 mil

Induction Time: none required

Pot Life Time: 7 hours @ 77 deg.F

Shelf Life Time: 1 year

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch	15 min.s
Dry to Handle	1 to 2 hours
Dry to Recoat	2 to 8 hours, varies with temperature

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PRODUCT DATA

1312

Zinc-Rich Ethyl Silicate Primer

Description: 1312 is a two component, zinc-rich ethyl silicate primer formulated for use as a primer for galvanic (cathodic) protection of ferrous surfaces. The zinc pigment sacrificially oxidizes to protect iron in ferrous substrates.

Typical Uses: zinc-rich primer to protect ferrous surfaces, such as bridges, tanks, and structural steel. Zinc pigment provides cathodic protection and film undercutting resistance to corrosion. Performance similar to hot-dipped galvanizing.

Special Qualifications: n/a

Dry Temperature Limits: 750 deg.F

Surface Cleanliness: for atmospheric exposure abrasive blast clean to NACE No.3/SSPC-SP 6 Commercial Metal Blast Cleaning, for immersion service abrasive blast clean to a NACE No. 2/SSPC-SP 10 Near-White Metal Blast Cleaning. For salt contaminated surfaces best results are obtained by first pressure washing the surface using a commercially available chloride remover.

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.3 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Mixing Instructions: Stir liquid portion first using mechanical agitation (jiffy power mixer). Discard the desiccant bag from the zinc powder, gradually stir the zinc dust into the liquid component under constant agitation. Filter through a 50 mesh screen after mixing. Never add the liquid portion to the zinc dust component. Continuous agitation is required.

Application Equipment: 45:1 ratio pump with 0.017 (617) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 2,400 psi recommended minimum fluid pressure at tip to obtain proper atomization. For whip lines greater than 50 feet, use 1/2 inch I.D. Flush all equipment with thinner to remove any moisture that may be present. An artist brush can be used for touchup of small repair areas less than 1 square foot.

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Metal temperature above 20 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 20 deg.F
- Humidity less than 95% but greater than 40%
- Material temperature above 20 deg.F

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Flat Gloss

Color: gray/green

Volume Solids: 77% (void content method)

Zinc Content: 85% zinc in dry film

Zinc Type: ASTM D-520, Type II (98% zinc in powder component), or Type III (99% zinc in powder component) when specified

VOC: 3.4 lbs./gal. (420 g/l), (mixed)

Flash Point: 66 deg.F

Dry Film Thickness: 2 to 4 mils

Theoretical Coverage: 1232 sq.ft./gal.@ 1 mil

Induction Time: none required

Pot Life Time: 8 hours @ 75 deg.F

Shelf Life Time: 1 year, if stored indoors at 65 to 85 deg.F

Dry Time: @ 75 deg.F

Set to Touch 20 min.

Dry to Handle 2 to 4 hours

Recoat generally 5 to 18 hours, depending on temperature and relative humidity, although may be topcoated, when dry film will pass a 50 MEK rub test without removing any zinc.

Thinner: T-67

Clean Up Solvent: T-40 MEK

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PRODUCT DATA

1356 HS

Description: A two component, high performance modified polyamide cured epoxy primer with corrosion inhibitors designed for effective corrosion protection on metal surfaces. Recommended for general use as a primer beneath epoxy finishes for atmospheric exposure in corrosive environments. Lead and chromate-free. High volume solids and low VOC.

Typical Uses: For industrial and commercial use for the protection of structural steel, tank exteriors, bridges and other surfaces exposed to corrosive environments.

Dry Temperature Limits: to 250 deg.F

Surface Cleanliness: Surfaces should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means. Abrasive blast clean according to SSPC-SP 6/NACE No. 3 *Commercial Blast Cleaning* to remove mill scale, rust, coating, oxides, corrosion products, and other foreign matter.

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.5 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Application Equipment: Brush, Roller, Airless or Conventional spray. To obtain maximum edge protection and film build, spray application is recommended.

Application Conditions:

- Noncontaminated surface, free of all oil, grease, mildew, other contamination
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a

Thinner: T-35 Thinner as required

Clean Up Solvent: T-35 Thinner

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to

Finish: Eggshell

Color: Gray, other colors available subject to minimum order.

Volume Solids: 61 +/- 2.0% (mixed)

Flash Point: 56 deg.F

Mixing Ratio: 1:1 by volume

Dry Film Thickness: 1-1/2 to 3 mils

Wet Film Thickness: 2-1/2 to 5 mils

Theoretical Coverage: 978 sq.ft./gal. @ 1 mils

Induction Time: 30 minutes

Pot Life Time: 16 to 20 hours @ 75 deg.F

Shelf Life Time: 12 months

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch 1 hour

Dry to Recoat 3 hours

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PRODUCT DATA

1357 HS

Epoxy Primer

Description: A two component, DTM mastic coating designed to permit application to rusty steel. For use in areas where higher performance is needed than can be obtained with conventional coatings, and only hand or power tool cleaning can be performed. Recommended for touchup and protection of weathered aluminum or hot-dipped galvanizing. May be topcoated with epoxy or urethane coatings up to 60 days after application. High volume solids and low VOC.

Typical Uses: For use as a maintenance coating over existing alkyd, epoxy, and zinc rich coatings, which are in sound condition and tightly adherent to the substrate. Useful for the protection of structural steel, piping, bridges, tank exteriors, equipment and other surfaces exposed to corrosive atmospheric or industrial environments.

Dry Temperature Limits: up 200 deg.F

Surface Preparation: Surfaces should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Application Equipment: Brush, roller, airless or conventional spray. To obtain maximum edge protection and film build, spray application is recommended.

Application Conditions:

- Noncontaminated surface, free of all oil, grease, mildew, other contamination
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Allow a 30 minute induction time for temperatures below 50 deg. F. (air, surface & material)
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a, self-prime

Thinner: No thinning normally recommended for brush application. For spray application, thin up to 1 pint per gallon with elite T35 as required

Clean Up Solvent: T-33

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Low sheen

Color:

Volume Solids: 60% +/- 2.0% (mixed)

VOC: 0.76 lbs./gal. (mixed)

Flash Point: 60 deg.F

Mixing Ratio: 1:1 by volume

Dry Film Thickness: 2 to 5 mils

Wet Film Thickness:

Theoretical Coverage: 962 sq.ft./gal. @ 1 mils

Induction Time: none

Pot Life Time: 16-20 hours @ 75 deg.F

Shelf Life Time: 12 months +

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch 1 hour

Dry to Recoat 1 hour for spray

24 hours for brush

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PRODUCT DATA

7500

Elite High Solids Epoxy Mastic

Description: A two component, high performance modified polyamine cured epoxy coating designed for high build application and effective corrosion protection on metal surfaces, where optimum surface preparation may not be feasible. A multipurpose, direct-to-metal, surface tolerant coating with excellent corrosion resistance and **indefinite recoatability**. Lead and chromate-free. High volume solids and low VOC.

Typical Uses: For industrial, commercial, and marine use for the protection of structural steel, tank exteriors, hulls, decks, bulkhead, and offshore structures and other surfaces exposed to corrosive atmospheric or industrial environments.

Dry Temperature Limits: up 200 deg.F

Surface Preparation: Commercial blast in accordance with SSPC-SP-6. Remove all oil, grease or other contamination by solvent or detergent cleaning or other effective means prior to application

Application Equipment: Brush, roller, airless or conventional spray. To obtain maximum edge protection and film build, spray application is recommended.

Application Conditions:

- Noncontaminated surface, free of all oil, grease, mildew, other contamination
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a

Thinner: Mek T-40 Thinner

Clean Up Solvent: Mek T-40 Thinner

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Eggshell

Color: Off white

Volume Solids: 68 +/- 1.0% (mixed)

VOC: 2.29 lbs./gal. (274 g/l), (mixed)

Flash Point: 80 deg.F

Mixing Ratio: 4:1 by volume

Dry Film Thickness: 6 to 8 mils

Wet Film Thickness: 9 to 12 mils

Theoretical Coverage: 136 sq.ft./gal. @ 8 mils

Induction Time: none required

Pot Life Time: 3-1/2 hours @ 75 deg.F

Shelf Life Time: 12 months

Dry Time: @ 77 deg.F (25 deg.C)

Set to Touch 1 hour

Tack-Free 5 hours

Dry Hard 12 hours

Dry to Recoat 8 hours

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PRODUCT DATA

7510

Aluminum Epoxy Mastic

Description: A two component, DTM mastic coating designed to permit application to rusty steel. For use in areas where higher performance is needed than can be obtained with conventional coatings, and only hand or power tool cleaning can be performed. Recommended for touchup and protection of weathered aluminum or hot-dipped galvanizing. May be topcoated with epoxy or urethane coatings up to 60 days after application. High volume solids and low VOC.

Typical Uses: For use as a maintenance coating over existing alkyd, epoxy, and zinc rich coatings, which are in sound condition and tightly adherent to the substrate. Useful for the protection of structural steel, piping, bridges, tank exteriors, equipment and other surfaces exposed to corrosive atmospheric or industrial environments.

Dry Temperature Limits: up 200 deg.F

Surface Preparation: Surfaces should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Application Equipment: Brush, roller, airless or conventional spray. To obtain maximum edge protection and film build, spray application is recommended.

Application Conditions:

- Noncontaminated surface, free of all oil, grease, mildew, other contamination
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a, self-prime

Thinner: T-33

Clean Up Solvent: T-33

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: low sheen

Color: metallic gray

Volume Solids: 91 +/- 1.0% (mixed)

VOC: 0.76 lbs./gal. (mixed)

Flash Point: 105 deg.F

Mixing Ratio: 1:1 by volume

Dry Film Thickness: 5 to 7 mils

Wet Film Thickness: 6 to 8 mils

Theoretical Coverage: 1460 sq.ft./gal.@ 1 mils

Induction Time: none

Pot Life Time: 5 hours @ 75 deg.F

Shelf Life Time: 12 months +

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch 4 hours

Dry Tack-free 12 hours

Dry to Recoat 24 hours

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PRODUCT DATA

8800

Elite Extreme Polyamide Epoxy

Description: A two component, high performance modified polyamide cured epoxy coating designed for effective corrosion protection on metal surfaces, where optimum surface preparation may not be feasible. A multipurpose, direct-to-metal, surface tolerant coating. Lead and chromate-free. High volume solids and low VOC.

Typical Uses: For industrial, commercial, and marine use for the protection of structural steel, tank exteriors, hulls, decks, bulkhead, and offshore structures and other surfaces exposed to corrosive atmospheric or industrial environments. Designed for long service protection of interior areas exposed to corrosive conditions, such as salt and fresh water immersion and corrosive environments. Provides excellent protection to structures subject to mechanical abuse.

Dry Temperature Limits: up 200 deg.F

Surface Preparation: Surfaces should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Application Equipment: Brush, roller, airless or conventional spray. To obtain maximum edge protection and film build, spray application is recommended.

Application Conditions:

- Noncontaminated surface, free of all oil, grease, mildew, other contamination
- Dry, dust-free metal surface
- Metal temperature above 60 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity less than 90%
- Material temperature between 70 and 90 deg.F

Primer: n/a

Thinner: T-40 Thinner

Clean Up Solvent: mek T-40Thinner

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Eggshell

Color: Full range of colors available

Volume Solids: 65 +/- 1.0% (mixed)

VOC: 2.36 lbs./gal. (284 g/l), (mixed)

Flash Point: 115 deg.F

Mixing Ratio: 4:1 by volume
part A (3002-XXX) with part B (3002-999)

Dry Film Thickness: 8 mils

Wet Film Thickness: 12 mils

Theoretical Coverage: 131 sq.ft./gal.@
8 mils

Induction Time: 15 minutes

Pot Life Time: 5 hours @ 75 deg.F

Shelf Life Time: 12 months

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Recoat 4 hours

Dry to Hard 9 hours

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PRODUCT DATA

TT-P-641G

Zinc Dust Metal Primer

Description: An alkyd zinc dust primer, which exhibits excellent protection of ferrous and hot-dipped galvanized metal surfaces. Contains in excess of 65% metallic zinc in the dry film.

Typical Uses: A primer for ferrous and hot-dipped galvanized surfaces. May be topcoated with alkyd and acrylic coatings.

Special Qualifications: Federal Specification TT-P-641G Type II, and ASTM A 780

Dry Temperature Limits: 250 deg.F

Surface Preparation: Surfaces should be clean and dry. Remove all oil, grease, mildew or other contamination by solvent or detergent cleaning or other effective means.

Thinner: T-160 Thinner

Mixing: Mix liquid portion with an agitator before slowly adding the zinc dust. Mix thoroughly. Do not pour liquid portion into the dust portion. Mix complete units only.

Application Equipment: brush, roller, or airless spray using a 45:1 ratio pump with 0.017 (617) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 2,400 psi recommended minimum fluid pressure at tip to obtain proper atomization. An artist brush can be used for touchup of WFT marks and other small repair areas.

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Metal temperature above 40 deg.F
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 40 deg.F
- Humidity less than 90%
- Material temperature between 40 and 90 deg.F

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: semi-gloss

Color: light gray

Volume Solids: 49.4 +/- 2%

VOC: 3.27 lbs./gal. (392 g/l), (mixed)

Flash Point: 105 deg.F

Dry Film Thickness: 2 mils

Wet Film Thickness: 4 mils

Theoretical Coverage: 792 sq.ft./gal. @ 1 mil

Dry Time: @ 77 deg.F (25 deg.C)

Dry to Touch 9 hours

Dry to Recoat 24 hours

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PRODUCT DATA

P-139

Low V.O.C.

Inorganic Zinc Primer

Description: P-139 is a two component, zinc-rich ethyl silicate primer formulated for use as a primer for galvanic (cathodic) protection of ferrous surfaces. The zinc pigment sacrificially oxidizes to protect iron in ferrous substrates.

Typical Uses: zinc-rich primer to protect ferrous surfaces, such as bridges, tanks, and structural steel. Zinc pigment provides cathodic protection and film undercutting resistance to corrosion. Performance similar to hot-dipped galvanizing.

Special Qualifications: AASHTO M-300, Types I & IA, and for high-strength bolts (ASTM B-490, Class B) slip coefficient of 0.59

Dry Temperature Limits: 750 deg.F

Surface Cleanliness: for atmospheric exposure abrasive blast clean to NACE No.3/SSPC-SP 6 Commercial Metal Blast Cleaning, for immersion service abrasive blast clean to a NACE No. 2/SSPC-SP 10 Near-White Metal Blast Cleaning. For salt contaminated surfaces best results are obtained by first pressure washing the surface using a commercially available chloride remover.

Profile Depth: average 1.5 to 2.0 mils (visual comparator), maximum 2.3 mils (Testex replica tape)

Profile Texture: sharp and angular (viewed under magnification)

Mixing Instructions: Stir liquid portion first using mechanical agitation (jiffy power mixer). Discard the desiccant bag from the zinc powder, gradually stir the zinc dust into the liquid component under constant agitation. Filter through a 50 mesh screen after mixing. Never add the liquid portion to the zinc dust component. Continuous agitation is required.

Application Equipment: 45:1 ratio pump with 0.017 (617) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 2,400 psi recommended minimum fluid pressure at tip to obtain proper atomization. For whip lines longer than 50 feet, use 1/2 inch I.D. Flush all equipment with thinner to remove any moisture that may be present. Striping must be done following spray application. Thin 50% for touchup and striping.

Application Conditions:

- Noncontaminated profile (pretreat and blast contaminated surfaces)
- Dry, dust-free metal surface
- Hot metal temperatures will retard cure.
- Metal temperature at least 5 deg. above the dew point
- Ambient temperature above 50 deg.F
- Humidity greater than 40% and less than 90%
- Material temperature between 50 and 90 deg.F

Safe Application Conditions: Consult MSDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

Finish: Flat

Color: gray/green

Volume Solids: 80% (void content method)

VOC: 3.4 lbs./gal. (404 g/l), (mixed)

Flash Point: 56 deg.F

Dry Film Thickness: 3 mils

Wet Film Thickness: 4 mils

Theoretical Coverage: 1291 sq.ft./gal.@ 1 mil

Induction Time: none required

Pot Life Time: 8 hours @ 75 deg.F

Shelf Life Time: 9 months. Do not use past nine months.

Dry Time: @ 75 deg.F

Set to Touch 15 min.

Recoat generally 24 hours, depending on temperature and relative humidity, although may be topcoated, when dry film will pass a 50 MEK rub test without removing any zinc.

Thinner: T-163

Clean Up Solvent: T-40

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