

TECHNICAL BULLETIN

TUFF-POXY PRIMER #3

TWO-COMPONENT, LOW VOC, EPOXY PRIMER/SEALER

PRODUCT DESCRIPTION

COMPOSITION: TUFF-POXY PRIMER #3 is a two-component, high solids, liquid applied, epoxy-polyamine primer. TUFF-POXY PRIMER #3 is a low viscosity, quicker drying version of the TUFF-POXY PRIMER #1. The special blend of polyamine with small amounts of solvent gives unique penetrating characteristics and a rapid cure. It has a low viscosity and improved adhesion to most substrates.

TYPICAL USES

TUFF-POXY PRIMER #3 is an epoxy- polyamine primer suitable for use in all FLEXSTONE Deck Coating Systems. It is specifically formulated to improve polyurethane elastomeric membrane adhesion to concrete and plywood and to properly treated metal. TUFF-POXY PRIMER #3 is a solvent-based primer and does retain a light solvent odor for a short period of time.

DRY TIMES, PACKAGING & STORAGE

PACKAGING: The TUFF-POXY PRIMER #3 is packaged in kit form. The VOLUME MIXING RATIO is 2 Parts Side-A to 1 Part Side-B (Side-A / Side-B = 2:1). It is available in fifteen (15) gallon, (1-½) gallon and (¾) gallon kits.

SHELF LIFE: Twelve (12) months after manufacture when continuously stored indoors in the original unopened containers.

COLOR: Side-A: Clear Side-B: Light Amber

INSTALLATION

SURFACE REQUIREMENTS: Successful bonding requires structurally sound and clean substrates. The substrate must be cleaned to ensure that it is free of all oils, any laitance, greases or other contaminants, such as concrete curing compounds, which may cause poor adhesion of TUFF-POXY PRIMER #3. After cleaning, the surfaces should be rinsed thoroughly to remove loose particles and dust created during shot-blasting or grinding and traces of any cleaning chemicals which may have been used. Primers or detailing, membranes, etc. should not be applied until the surface is dry.

MIXING INSTRUCTIONS: If needed, this primer may be diluted with small amounts of Xylene or Toluene, to the extent allowed by the local Air Quality Management authority. Addition of solvent extends the work life of the mixture and provides better surface penetration. TUFF-POXY PRIMER #3 Side-A and Side-B should be thoroughly agitated prior to mixing to ensure a homogeneous material. TUFF-POXY PRIMER #3 must always be mixed in the ratio of two parts Side-A with one part Side-B (Side-A: Side-B = 2:1). The combined components should be thoroughly mixed for at least 2 minutes. No Induction time is required.

NEW FAST-CURING FORMULATION: The TUFF-POXY PRIMER #3 now comes with a 'fast hardener'. It is used in place of the standard hardener and has the same mix ratio. TUFF-POXY PRIMER #3 Fast Hardener will decrease the typical tack free time to about 3 hours when applied at 70-75°F. The pot life will be decreased to about 10-15 minutes. Application methods remain the same as when standard hardener is used. Please be sure to take short pot life into consideration while planning application strategy for your project.

APPLICATION: TUFF-POXY PRIMER #3 should be applied at the rate of 1 gallon per 300-400 square feet. It can be applied using a brush, airless spray or by phenolic core roller.

CURING: Allow TUFF-POXY PRIMER #3 to become tacky to the touch (Usually, a typical dry time of 30-90 minutes at 77°F) before filling cracks, joints, or applying the base or detail coating. Note: Temperature will affect the curing time of TUFF-POXY PRIMER #3. Higher temperatures will significantly accelerate the cure time while colder temperatures will significantly retard the cure time. To improve cure/bond time in cooler temperatures, TUFF-POXY PRIMER #3 may be pre-mixed and allowed to sit in the container for 10 to 15 minutes (the cooler the temperature, the longer the induction times) before application. In hot

temperatures, the pot life of the primer / sealer is significantly reduced therefore the residence time in the container, after mixing, should be kept very short. Recommended application temperature is greater than 45°F.

EQUIPMENT CLEANUP: Equipment should be cleaned immediately after use with an environmentally-safe solvent, as permitted under local regulations. The primer is difficult to remove after it has cured.

TECHNICAL SERVICE

Technical Assistance is available by contacting:

FLEXSTONE COATINGS INC
1230 W 75th Avenue, Vancouver, BC
Phone: (604) 222-8453
Email: info@flexstones.ca

TECHNICAL DATA

PHYSICAL PROPERTY	TYPICAL VALUE	TEST METHOD
Coverage Rate	300-400 ft ² /gal	
Film Thickness per Coat	4 ± 1 mils	
Hardness	70 ± 5 Shore D	
Shelf Life	12 months	
Specific Gravity	Side A 1.05 Side B 1.02	
Solids Content (Mixed)	92 ± 2%	ASTM D-1353
VOC Content	100 gm/l	Calculated
Viscosity at 24°C (75°F) Side A	150 ± 50 cps	
Side B	300 ± 50 cps	

PRECAUTIONS

This product contains Epoxy Resin, Polyamine Hardeners and flammable solvent. Personnel applying these coatings should wear protective clothing, safety goggles and gloves. Avoid contact of material with skin or eyes and avoid breathing the solvent vapors. Mix and apply in well-ventilated areas and observe normal safety precautions required for solvent containing epoxy materials. Read the Safety Data Sheet (SDS) before using this product.

THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

LIMITED WARRANTY

FLEXSTONE Coatings Inc warrants this product to be free of defects in workmanship and materials only at the time of shipment from our factory. If any Flexstone materials prove to contain manufacturing defects that substantially affect their performance, FLEXSTONE will, at its option, replace the materials or refund its purchase price.

This limited warranty is the only warranty extended by FLEXSTONE with respect to its materials. There are no other warranties, including the implied warranties of merchantability and fitness for a particular purpose. FLEXSTONE specifically disclaims liability for any incidental, consequential, or other damages, including but not limited to, loss of profits or damages to a structure or its contents, arising under any theory of law whatsoever.

The dollar value of FLEXSTONE's liability and buyer's remedy under this limited warranty shall not exceed the purchase price of the FLEXSTONE material in question

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