



Corporate Offices  
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**SCRATCH-COAT 800**

**TROWEL OR SQUEEGEE APPLIED,  
 VINYL ESTER FILL MATERIAL FOR  
 CONCRETE AND PITTED STEEL  
 APPLICATIONS.**

**FEATURES**

Easy to Apply  
 Suitable for Steel & Concrete Substrates

**RECOMMENDED APPLICATIONS**

Concrete Substrates  
 Pitted Steel

**PHYSICAL PROPERTIES**

Adhesion to Concrete ASTM D-4541	Cohesive Failure of Concrete
Adhesion to Steel ASTM D-4541	1,500 PSI

**SPECIFICATIONS**

**Scratch-Coat 800** shall be a vinyl ester based fill material for concrete and pitted steel applications as manufactured by Dudick, Inc. Material shall be trowel or squeegee applied in accordance with the manufacturer's recommended practices.

**THE SCRATCH-COAT 800 SYSTEM**

**Scratch-Coat 800** uses a primer and a vinyl ester resin with inert mineral fillers to achieve a smooth non-slumping fill material.

The system is formulated to improve the integrity and continuity of a prepared metal or concrete substrate prior to the application of a Dudick polyester or vinyl ester lining or coating system.

**ESTIMATING QUANTITIES AND  
 ORDER BILL OF MATERIAL**

APPROXIMATE SQUARE FEET PER GALLON	
	Scratch-Coat 800
Primer 27	150-200 ft. <sup>2</sup>
Scratch Coat	125-150 ft. <sup>2</sup>
S-10 Solvent	500 ft. <sup>2</sup>

\*Quantities shown are for estimating purposes only. Actual material requirements can be more accurately determined after abrasive blasting and examination of the surface profile.

**During manufacturing, some air entrapment occurs in the more viscous lining systems. During storage and transportation, settling can occur when entrapped air escapes this mix indicating less than 100% volumetric fill. All products are priced and sold by weight and not necessarily by volume**

**APPLICATION INSTRUCTIONS**

**SURFACE PREPARATION**

**Metal:** Abrasive blast to a white metal finish and a 3.0 mils minimum profile according to SSPC SP 5 or NACE # 1.

**Concrete:** Refer to specific product bulletin where **Scratch-Coat 800** is being used for concrete surface preparation requirements.

**APPLICATION SPECIFICATIONS**

Substrate temperature for both concrete and metal must be between 50°F and 110°F.

Relative humidity must not exceed 90%.

Substrate temperature must be 5°F above the Dew Point.

## Hardener Amount / Gallon Resin

### Scratch-Coat 800

Hardener	Substrate Temperature	Primer 27	Scratch-Coat 800
PH-1	50°F - 60° F	4-5 oz.	4-5 oz.
PH-1	60°F - 70° F	3-4 oz.	3-4 oz.
PH-1	70°F - 90° F	2-3 oz.	2-3 oz.

The Pot Life of the mixed materials will depend on the temperature. To avoid material waste do not mix more than can be used according to the following table:

Temperature	POT LIFE
	Primer 27/ Scratch-Coat 800
50°F	60 min.
75°F	45 min.
90°F	30 min.

### SCRATCH COAT 800

#### PRIMER 27

Add the correct amount of **PH-1 Hardener** for each gallon of **Primer 27** and mix thoroughly for 1-2 minutes.

Prime all metal or concrete surfaces at 3-4 mils WFT using a brush, spray, or roller. The scratch-coat may be applied over tacky primer. Do not allow the primer to puddle.

#### SCRATCH-COAT

Using the correct amount of **PH- 1 Hardener** for each gallon of **Scratch-Coat 800** liquid, mix for 1-2 minutes. Then gradually add the **G-2 Filler** to achieve a trowelable, putty consistency.

Through the **Scratch-Coat 800** is a trowel or squeegee applied material, it is not intended to be utilized as a surface "coating". The compound should be spread firmly, forcing the material into deep voids and pinholes. Use the trowel blade to scrape excess material from flat, void-free surfaces. The consistency of the mortar provides excellent non-slumping characteristics for vertical or overhead use. This normally allows completion of the surface preparation following only one application.

Allow the **Scratch-Coat 800** to cure until firm before proceeding with the specified basecoat and topcoat. Excessive trowel marks and/or rough areas should be sanded smooth.

Application of **Scratch-Coat 800** 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.

**In order to prevent curing problems with styrenated products, air movement and/or ventilation must be maintained not only during application but also after application until the system has totally cured. This will prevent high concentration of styrene inhibiting/retarding the cure of the system.**

### Scratch Coat 800 Cure Cycle

TEMPERATURE	RECOAT TIME		CURE TIME
	MIN.	MAX.	
50°F	8 hrs.	8 days	96 Hrs.
75°F	3 hrs.	5 days	24 Hrs.
90°F	1.5 hrs.	3 days	16 Hrs.

If these recoat times are exceeded, consult a Dudick representative; sanding or abrasive blasting may be required before the next coat. Recoat times are dramatically reduced when **Scratch-Coat 800** is exposed to direct sunlight.

### CLEANING

Use **S-10 Cleaning Solvent** to clean tools and equipment. **DO NOT USE ACETONE.**

### SHIPPING

Refer to Material Safety Data Sheets.

### STORAGE

**Warning:** All Dudick products classified by DOT with either white, yellow or red labels must not be mixed or stored together as an explosive reaction may occur.

All products should be stored in a cool, dry area away from open flames, sparks or other hazards.

When properly stored in their original, unopened containers at 50°F-75°F, **Primer 27** and **Scratch-Coat 800** will have a shelf life of three- months or less. At temperatures above 75°F, two months or less. PH-1 Hardener will have a six-month shelf life at 50°F-75°F. Exposure to excessive heat may cause premature gelling, reduce working time and shelf life.



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### SAFETY

**M.S.D.S.: Material Safety Data Sheets must always be read before using products. Scratch-Coat 800** is intended for application by experienced, professional personnel. Dudick, Inc. can supply supervision to help determine that the surface has been properly prepared, the ingredients correctly mixed, and the materials properly and safely applied.

If **Scratch-Coat-800** is to be applied by your own personnel or by a third party contractor, please be sure that they are aware of the following safety precautions:

- Exposure to resins and hardeners through direct skin contact and/or inhalation may cause severe dermatitis reactions in some people. Cleanliness of the skin and clothing is critical and must be of paramount concern.
  - Fumes are flammable and heavier than air. Proper ventilation should be maintained to minimize breathing of concentrated fumes.
  - Suitable respirators should be used during application.
  - Safety glasses, gloves, and suitable protective clothing must be worn at all times during application.
  - If contact with hardeners occurs, remove any clothing involved and flush the skin with flowing water. Discard the clothing. Do not attempt to wash and reuse it. **Scratch-Coat 800** liquid can be removed with S-10 Cleaning Solvent, MEK, or lacquer thinner. **DO NOT USE ACETONE.**
  - Keep open flames and sparks away from the area where materials are being mixed and applied.
  - If a rash occurs, remove the individual from the work area and seek a physician's care for dermatitis.
- In case of eye contact, flush with water for at least 15 minutes and consult a physician.
  - If swallowed, do not induce vomiting; call a physician immediately.

**NOTE:** Dudick, Inc. ("Dudick") warrants all goods of its manufacture to be as represented in its catalogs and that the manufacture of its products by its employees or sub-contractors shall be performed in a workmanlike manner. Dudick's sole obligation under this warranty shall be to replace any material which its examination shall disclose to be defective. Dudick makes no warranty concerning the suitability of its product for application to any surface, it being understood that the goods have been selected and the application ordered by the Purchaser. DUDICK, INC. MAKES NO WARRANTY, EXPRESS OR IMPLIED, THAT THE GOODS SHALL BE MERCHANTABLE OR THAT THE GOODS ARE FIT FOR ANY PARTICULAR PURPOSE. THE WARRANTY OF REPAIR OR REPLACEMENT SET FORTH HEREIN IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES ARISING BY LAW OR OTHERWISE; AND DUDICK INC. SHALL NOT BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES, INCLUDING BUT NOT LIMITED TO LOST PROFITS, DOWN TIME, DAMAGES TO PROPERTY OF THE PURCHASER OR OTHER PERSONS, OR DAMAGES FOR WHICH THE PURCHASER MAY BE LIABLE TO OTHER PERSONS, WHETHER OR NOT OCCASIONED BY DUDICK'S NEGLIGENCE. This warranty shall not be extended, altered or varied except by written instrument signed by Dudick and Purchaser.

5/10/10