



**Dudick inc.**

Corporate Offices  
1818 Miller Parkway  
Streetsboro, OH 44241  
330-562-1970  
330-562-7638 FAX  
www.dudick.com

**PROTECTO-COAT 325**

**100% Solids, High Build Epoxy Coating  
12-16 mils (.4 mm)**

**FEATURES**

Meets all VOC Requirements  
Low Odor  
Environmentally Safe

**RECOMMENDED APPLICATIONS**

Chemical Plant Process Piping  
Foundations and Steel Decks  
Structural Steel Components  
All Concrete Surfaces

**CHEMICAL RESISTANCE**

Sodium Hydroxide  
Salt & Brine Solutions  
Mineral Oils

**TEMPERATURE LIMITS  
(METAL APPLICATIONS)**

Immersion up to 120°F  
Dry - 250°F - Continuous  
300°F - Intermittent

**COLORS:** Standard Color Chart  
available upon request.

**PHYSICAL PROPERTIES**

Tabor Abrasion ASTM C-4060	92 mg.
WVT ASTM E-96	0.0018 perm. in.
Tensile Elongation ASTM C-307	10%
VOC ASTM C-3960	0
Tensile Strength ASTM C-307	2,870 PSI

**SPECIFICATIONS**

**Protecto-Coat 325** shall be an epoxy coating applied in two 6-8 mil coats as manufactured by Dudick, Inc. Materials shall be applied by brush, roller, or spray in accordance with the manufacturer's recommended practices.

**THE PROTECTO-COAT 325 SYSTEM**

**Protecto-Coat 325** uses a moisture-tolerant primer and one or two coats of low odor epoxy resin to achieve high build and provide protection for metal and concrete substrates.

**Primer 67** is designed to prevent abrasive-blasted steel from developing rust bloom prior to the application of the **Protecto-Coat 325**.

For maximum performance, all metal surfaces should be primed, but primer may not be needed for mild, non-immersion service. Concrete must be primed to aid in the "wetting out" required for good bonding.

**Primer 67C** is designed for applications on concrete where spark testing is required or specified.

**Basecoat/Topcoat:** The unique hybrid binder in **Protecto-Coat 325** provides the low permeability, high film integrity, and excellent chemical resistance required for prolonged substrate protection.

For atmospheric exposure, a single 6-7 mil DFT application of **Protecto-Coat 325** may be sufficient. Total DFT (with primer) should be 7-8 mils, minimum.

For heavy spillage or total immersion areas, two 6-7 mil finished coats must be applied over primer to achieve a DFT of 12-16 mils.





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damage to equipment, do not mix more material than can be used according to the following table:

TEMPERATURE	POT LIFE
50°F	75 min.
75°F	50 min.
90°F	25 min.

Do not attempt to store mixed material. Residual material should be properly disposed of at the end of each work period.

**FINISH COAT**

Except for areas where only mild atmospheric exposure is anticipated, surfaces should be protected with two coats of **Protecto-Coat 325** applied in equal thickness to achieve the following recommended minimum DFT:

Atmospheric and Mild Splash Service	6 mils DFT
Fumes	6 - 15 mils DFT
Immersion Service	15 mils DFT

**SPRAY SPECIFICATIONS**

Consult Dudick representative for recommendation for spray application.

Brush or roller application may require additional coats to meet the specified dry film thickness.

**CURE CYCLE**

TEMP	RECOAT TIME		CURE TIME
	MIN.	MAX.	
50°F	7-9 hrs.	120 hrs.	96 hrs.
75°F	5-6 hrs.	72 hrs.	24 hrs.
90°F	3-4 hrs.	48 hrs.	20hrs.

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 the coating is exposed to direct sunlight.

Application of **Protecto-Coat 325** in direct sunlight may lead to blistering, pinholes, or wrinkling due to out-gassing of air in concrete and high substrate temperatures. Double priming, shading, or evening application may be required. Consult a Dudick representative.

**TESTING**

If spark testing is required, use a DC spark/holiday tester set to the appropriate voltage to achieve a minimum 100 volts per mil of applied coating. An AC tester can be used, but is not as effective as a DC tester. Mark and repair all pinholes, using **Protecto-Coat 325**. Retest only the repairs.

**CLEANING**

Use S-10 Cleaning Solvent to clean tools and equipment.

**SHIPPING**

Refer to Material Safety Data Sheets.

**STORAGE**

**Warning:** All Dudick products classified by DOT with white, yellow or red labels must not be mixed or stored together as an explosive reaction can 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, the **Primer 67** and the **Protecto-Coat 325** have a six-month shelf life. **Primer 67C** will have a thirty-day shelf life. Storage in direct sunlight or excessive heat will reduce working time and shelf life.

## SAFETY

**M.S.D.S: Material Safety Data Sheets must always be read before using products. Protecto-Coat 325** systems are 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 **Protecto-Coat 325** materials are 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. **Protecto Coat 325** liquid can be removed with S-10 Cleaning Solvent, MEK, or lacquer thinner.
- 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.

11/11/20