



Corporate Offices
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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.

ESTIMATING QUANTITIES AND ORDER BILL OF MATERIAL

APPROXIMATE SQUARE FEET PER GALLON		
	CONCRETE	STEEL
PRIMER 67	150-200 ft. ²	250-300 ft. ²
PRIMER 67C	100-150 ft. ²	-----
Protecto-Coat 325		
Actual 1st Coat 6 MIL DFT	190-215 ft. ²	225-240 ft. ²
Theoretical 6 MIL DFT	267 ft. ²	267 ft. ²
S-10 Solvent	500 ft. ²	500 ft. ²

*Quantities shown are for estimating purposes only. Actual field usage may vary.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Metal: Metal surfaces must be abrasive blasted to an appropriate finish.

Immersion and heavy spillage service: White Metal, SSPC SP 5 or NACE #1, minimum 3.0 mil profile. Heavy non-immersion service (i.e. fumes and spillage): Near white, SSPC SP 10 or NACE #2, minimum 2.0 mil profile. Atmospheric service: Commercial SSPC SP 6 or NACE #3, minimum 2.0 mil profile.

Concrete: Concrete must be mechanically prepared to remove surface laitance. Oils, grease or other contaminant must be removed prior to surface preparation. Concrete must be free of curing compounds and form release agents. Surface texture should be similar to 40-60 grit sandpaper or the visual standard, CSP-5 from the International Concrete Repair Institute **with exposed pea gravel**. The prepared surface should have a minimum tensile strength of 250 PSI per ASTM D-7234.

All concrete substrates must be checked for moisture prior to product application using the Plastic Sheet Test, ASTM D-4263.

Additional surface preparation will be required if a 60-80 grit texture is not achieved and the surface laitance not completely removed with the first mechanical preparation procedure.

Mechanical preparation removes laitance, exposing honeycombs or voids beneath the surface which must be filled with **Scratch Coat 300**. (Refer to separate product bulletin).

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.

PRIMER 67/67C MIX RATIOS (BY VOLUME)

Primer 67	Component A	1 gallon
Primer 67	Component B	1 gallon

Primer 67C	Component A	1 gallon
Primer 67C	Component B	29 fl. oz.

Important: Primer 67C Component A must be mechanically mixed for 1-2 minutes prior to adding the correct amount of **Component B**.

Primer 67C must be roller applied. Use brush application for small touch-up or repair work only.

PRIMER 67/67C POT LIFE

TEMPERATURE	PRIMER 67	PRIMER 67C
50°F	90 min.	110 min.
75°F	60 min.	90 min.
90°F	30 min.	50 min.

PRIMING

The following Primers are compatible with **Protecto-Coat 325**: Primer 67, Primer 67LV, Primer 67DPLV, Primer 67DTO & Primer 60.

PROTECTO-COAT 325 MIX RATIO (BY VOLUME)

Component A	1 gallon
Component B	67 fl. oz.

Then, add the correct amount of **Component B** to **Protecto-Coat 325 Component A** and mix thoroughly until a uniform color is achieved.

Apply at the recommended thickness using a brush, spray or roller.

Pot life of the mixed **Protecto-Coat 325** will depend on the temperature. To prevent material waste and avoid



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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 twelve-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.

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