



Dudick inc.

Corporate Offices
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PRIMER 67LV
LOW VOC
HIGH SOLIDS, MOISTURE TOLERANT
EPOXY PRIMER FOR STEEL AND
CONCRETE 3-4 MILS (0.1 mm)

FEATURES

Low VOC
Low Odor
User Friendly

RECOMMENDED APPLICATIONS

Concrete Substrates
Steel Substrates
Primer for Epoxy Systems

PHYSICAL PROPERTIES

Tensile Strength 2,000 - 2,500 PSI
ASTM C-307
Tensile Elongation 20-25 %
ASTM C-307
Adhesion to Concrete Cohesive Failure
ASTM D-7234 of concrete
Adhesion to Steel 2,200-2,500 PSI
ASTM D-4541
VOC Content 30-35 g/l
ASTM D-2369

SPECIFICATIONS

Primer shall be 3-4 mils thick, high solids epoxy cured with an amine hardener as manufactured by Dudick Inc. **Primer 67LV** shall be brush, roller or spray applied in accordance with the manufacturer's recommended practices.

PRIMER 67LV

Primer 67LV is designed to prevent abrasive blasted steel from developing rust bloom prior to the application of a Dudick coating or lining system. For maximum performance all steel surfaces should be primed, but primer may not be needed for mild, non-immersion service. Concrete, however, must always be primed to aid in the "wetting out" required for good adhesion.

ESTIMATING QUANTITIES AND ORDER BILL OF MATERIAL

APPROXIMATE SQUARE FEET PER GALLON		
	CONCRETE	STEEL
Primer 67LV	150-200 ft. ²	250-300 ft. ²

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

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

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

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

Atmospheric service: Commercial SSPC SP-6 or NACE #3, 2.0 mil minimum profile.

Concrete: Refer to specific product bulletin where **Primer 67LV** 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 Dew Point.

PRIMER 67LV MIX RATIO (BY VOLUME)

Primer 67 LV Component A 73 fl.oz.
Primer 67LV Component B 55 fl.oz.

The pot life of the mixed **Primer 67LV** will depend on the temperature. To prevent material waste and avoid damage to equipment, do not mix more material than can be used according to the following table:

PRIMER 67LV POT LIFE

TEMPERATURE	PRIMER 67LV POT LIFE
50°F	90 min.
75°F	60 min.
90°F	30 min.

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

PRIMING

Metal: Mix the pre-measured units of **Primer 67LV Component A** with **Component B**. Prime all metal surfaces to be coated with **Primer 67LV** at 3-4 mils WFT.

Concrete: Mix the pre-measured units of **Primer 67LV Component A with Component B**. Prime all concrete surfaces to be coated with **Primer 67LV** at 3-4 mils WFT. Do not allow the primer to puddle. Epoxy basecoats may be applied over primer that is **“tacky”**. **Urethane basecoats should be applied only after the Primer 67LV has cured a minimum 24 hours.**

Important - With all epoxies after priming and before each additional coat, examine the surface for amine blush (oily film). If present, remove by washing with warm water and detergent.

Cure Cycle for Primer 67LV

Temperature	Minimum* Recoat Time	Maximum Recoat Time
50°F	12 hrs.	8 Days
75°F	6-8 hrs.	5 Days
90°F	4-5 hrs.	3 Days

***Minimum recoat time is 24 hours @ 75°F for urethanes**

Application of **Primer 67LV** 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.

To optimize intercoat adhesion, we recommend application of the basecoat while the **Primer 67LV** is tacky. If this is not possible, the above recoat times must be observed. Exposure of the primer to direct sunlight will considerably shorten the recoat times.

If recommended recoat times are exceeded, consult a Dudick Representative; sanding or abrasive blasting may be required before the coating, lining or floor topping can be applied.

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 either 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 stored in their original, unopened containers, at 50°F-75°F the following shelf life periods will apply: **Primer 67LV** components will have a six-month shelf life. Exposure to excessive heat may cause premature gelling, reduce working time and shelf life.

SAFETY

M.S.D.S: Material Safety Data Sheets must always be read before using products. Primer 67LV 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 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.



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- 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. **Primer 67LV** liquids 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.

6/28/17