



Corporate Offices
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PRIMER 67/67C

**HIGH SOLIDS, MOISTURE TOLERANT
 EPOXY PRIMER FOR STEEL AND
 CONCRETE 3-4 MILS (0.1 mm)**

FEATURES

Meets most VOC Requirements
 Low Odor
 User Friendly

RECOMMENDED APPLICATIONS

Concrete Substrates
 Steel Substrates
 Primer for Epoxy and Urethane 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
 Electrical Properties (**PR 67C**) < 25,000 ohms
 NFPA #99,
 ASTM F-150

To insure surface resistivity properties, the components of **Primer 67C** must be applied within 30 days of product manufacture. Please refer to storage instructions.

SPECIFICATIONS

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

PRIMER 67

Primer 67 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.

PRIMER 67C - CONDUCTIVE PRIMER

Primer 67C is a high solids, two component epoxy primer designed to be used over concrete whenever the coating or lining system must be spark tested.

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	-----

**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 67/67C** 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.

CONTINUITY TESTING

Spark testing is generally conducted at 100 volts per mil, thickness of coating, using a high voltage holiday detector.

PRIMER 67/67C MIX RATIO (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.

Pre-mix Primer 67C Component A for 1-2 minutes to disperse the conductive fillers 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.

The pot life of the mixed **Primer 67/67C** 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 67/ 67C POT LIFE

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

At 75°F the pot life and thin film cure of **Primer 67** can be decreased by the addition of Accelerator #1 as follows:

Ozs./Accelerator #1 per mixed gallon Primer 67	Pot Life	Thin Film Cure
3-4	36 min.	4 hrs.
6-7	15 min.	2 hrs.

Do not use Accelerator #3 in Primer 67.

At 75°F the pot life and thin film cure of **Primer 67C** can be decreased by the addition of Accelerator #3 as follows:

Ozs./Accelerator #3 per mixed gallon Primer 67C	Pot Life	Thin Film Cure
4	60 min.	7-8 hrs.
7	40 min.	5-6 hrs.

Do not use Accelerator #1 in Primer 67C.

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 67 Component A** with **Component B**. Prime all metal surfaces to be coated with **Primer 67** at 3-4 mils WFT.

Concrete: Mix the pre-measured units of **Primer 67/67C Component A with Component B**. Prime all concrete surfaces to be coated with either **Primer 67** at 3-4 mils or **Primer 67C** at 6-8 mils WFT. The basecoat may be applied over primer that is “tacky”. Do not allow the primer to puddle. **Primer 67C should be tack-free before basecoat applications.**

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 67/67C:

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



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Application of **Primer 67/67C** 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 67** 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 67 components will have a six-month shelf life.
Primer 67C components will have a thirty-day 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 67/67C** 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.
- 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 67/67C** 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.

12/30/2014