



# TECHNICAL DATA

## TUFF-POXY PRIMER #2

### TWO-COMPONENT, LOW VISCOSITY, EPOXY PRIMER/SEALER

#### PRODUCT DESCRIPTION

**COMPOSITION:** TUFF-POXY PRIMER #2 is a two-component, solvent borne epoxy primer/sealer. It is a high penetration primer/sealer for use with urethane deck coating and waterproofing membrane systems where solvent based primers can be tolerated.

**BASIC USES:** TUFF-POXY PRIMER #2 is also used as a primer/sealer for porous substrates such as wood, plywood, concrete and for surface treated (pre-primed) metal. It is insensitive to humid application conditions and will cure well in the desert as well as tropical environments. Tests have shown that the use of TUFF-POXY PRIMER #2 as a barrier coat significantly reduces the incidence of pinholing and surface imperfections in polyurethane waterproofing installations as compared to similar applications on an untreated substrate. TUFF-POXY PRIMER #2 enhances the long-term adhesion of the polyurethane membrane to the substrate. It is also an excellent coating for dust proofing concrete. TUFF-POXY PRIMER #2 also has good adhesion to properly cleaned ferrous metal.

**COLOR:** Side-A: Clear  
Side-B: Amber

**PACKAGING:** TUFF-POXY PRIMER #2 is packaged in kit form. The VOLUME MIXING ratio is 1 part Side-A to 1 part Side-B (**Side-A / Side-B** = 1:1). TUFF-POXY PRIMER #2 is available in kits of two (2) and ten (10) gallons.

**WARNING:** The A & B-Sides of this product are considered Dangerous Goods. They are classified as: **RESIN SOLUTION, Class 3, UN 1866, PG II, FLAMMABLE LIQUID.**

#### PRE-APPLICATION PRECAUTION

**LIMITATIONS:** Once the material is mixed together, it must be used within one (1) hour at 77°F since TUFF-POXY PRIMER #2 cures and solidifies rapidly when the two parts interact. Unmixed containers which are left open must also be used within several days since TUFF-POXY PRIMER #2 contains solvents which evaporate when exposed to air. TUFF-POXY PRIMER #2 should not be diluted. Surfaces to be coated with TUFF-POXY PRIMER #2 must be dry, clean, and free of all foreign matter.

**PRECAUTION:** TUFF-POXY PRIMER #2 is a component of the TUFFLEX Decking Systems. It should primarily be used as stipulated in the various TUFFLEX SPECIFICATIONS. Results occurring from use other than what is stipulated in the TUFFLEX SPECIFICATIONS is not tested or guaranteed by TUFFLEX.

Ensure that the decking substrate is properly prepared prior to application.

**SURFACE PREPARATION:** All surfaces to be coated with TUFF-POXY PRIMER #2 must be free of all contamination including visible water, curing compounds, oils, grease, paint, and dirt. Concrete surfaces should be free of roughness which will show through and be noticeable in the completed application. Concrete can be cleaned by shot blasting, hydroblasting or acid etching (followed by neutralizing and thorough rinsing with a pressure-washer) and allowed to completely dry.

**MIXING INSTRUCTIONS:** TUFF-POXY PRIMER #2 Side-A and Side-B should be thoroughly agitated prior to mixing to ensure a homogeneous material. TUFF-POXY PRIMER #2 must always be mixed using equal amounts of Side-A and Side-B. The combined components should be thoroughly mixed using a mechanical mixer at slow speed for a couple of minutes or mixed for at least 5 minutes if mixed by hand.

**OPTIONAL:** (If odor or the use of flammable solvents is not a concern.) Additional small amounts of solvent can be added if desired and if allowed by local VOC regulations. Contact the factory to determine the amount of solvent which can be added in fluid ounces per gallon of mixed A & B. Blend with a mechanical mixer (explosion proof) for 3 minutes. Induction time is not required.

**APPLICATION:** TUFF-POXY PRIMER #2 Side-A and Side-B must be mixed thoroughly and in the proper ratios to assure proper curing. The mixed viscosity is suitable for roller coating, brushing, or spraying with a pressure pot. TUFF-POXY PRIMER #2 should be applied at a rate of 300-350 square feet per gallon depending upon the profile, texture and porosity of the surface being primed. Cure time will vary with temperature and weather and if exposed to direct sunlight. The higher the temperature and greater the exposure to sunlight, the faster the cure. A typical cure of 3-4 hours at warm daytime temperatures in shady areas is recommended or two hours if exposed to hot direct sunlight. The coating must be applied over the cured primer the same day for proper adhesion.

**EQUIPMENT CLEANUP:** Equipment should be cleaned with an environmentally-safe solvent, as permitted under local regulations, immediately after use. The primer is difficult to clean up after it has cured.

#### TECHNICAL DATA

PROPERTY	TYPICAL VALUE	TEST METHOD
Solids Content (Mixed)	80 ± 2%	ASTM D-1353
Weight per Gallon		ASTM D-1475
Part A (Resin)	8.5 lbs.	
Part B (Hardener)	8.2 lbs.	
Viscosity, Mixed Material	200 cps	ASTM D-562
VOC Content	200 gm/liter	Calculated
Flash Point (Mixed)	55° F	ASTM D-56
Mix Ratio, By Volume	1 to 1	----
Pot Life, 1 Pint @ 77°F	1 hour	ASTM D-2471
Cure Time @ 77°F		
Firm to Touch	3-4 hours	----
Tack Free	2-3 hours	-----
Coverage, Per Gal.	300-350 sq. ft.	-----
Cured Film Impact	Passes 60 in. lbs.	Reverse Impact

**PRECAUTIONS:** This product contains flammable solvents. Keep these materials away from heat, sparks and flames. Personnel applying these primers and coatings should wear protective clothing, use respiratory protection, safety goggles and gloves. Avoid contact of material with skin or eyes and avoid breathing the solvent vapors. Mix and apply in well-ventilated areas and observe normal safety precautions required for solvent containing materials. Read the Safety Data Sheet (SDS) before using this product. THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

**LIMITED WARRANTY:** TUFFLEX Polymers (TUFFLEX) warrants this product to be free of defects in workmanship and materials only at the time of shipment from our factory. If any TUFFLEX materials prove to contain manufacturing defects that substantially affect their performance, TUFFLEX will, at its option, replace the materials or refund its purchase price.

This limited warranty is the only warranty extended by TUFFLEX with respect to its materials. There are no other warranties, including the implied warranties of merchantability and fitness for a particular purpose. TUFFLEX specifically disclaims liability for any incidental, consequential, or other damages, including but not limited to, loss of profits or damages to a structure or its contents, arising under any theory of law whatsoever.

The dollar value of TUFFLEX'S liability and buyer's remedy under his limited warranty shall not exceed the purchase price of the TUFFLEX material in question.

TUFF-POXY PRIMER #2 (07)