



# TECHNICAL DATA

## TUFF-POXY 607-WB

### TWO-COMPONENT, WATERBORNE EPOXY PRIMER/SEALER

#### 1. PRODUCT

TUFF-POXY 607-WB is a two-component, liquid applied, water-borne epoxy primer/sealer for various substrates. It is one of the primer/sealers used with the moisture-curing deck coating systems supplied by TUFFLEX Polymers (TUFFLEX).

#### 2. PRODUCT DESCRIPTION

**Composition:** A two-component, low odor, liquid applied epoxy primer/sealer designed for easy mixing with a simple 1 to 1 volume ratio. The primer/sealer may be applied after thoroughly mixing the two components together and allowing a 30 minute induction period.

**Basic Uses:** TUFF-POXY 607-WB is one of the primer/sealers used in the various TUFFLEX moisture-curing polyurethane pedestrian and vehicular deck coating systems.

TUFF-POXY 607-WB is also used as a primer/sealer for various substrates including surface treated metal, wood, plywood, and concrete. It is insensitive to humid application conditions and will cure and adhere well on damp concrete and damp wood which has surface dried. Tests have shown that the use of TUFF-POXY 607-WB as a barrier coat significantly reduces the incidence of pinholing and surface imperfections in polyurethane waterproofing membrane installations as compared to similar applications on an untreated substrate. TUFF-POXY 607-WB enhances the long term adhesion of the waterproofing membrane to the substrate.

**Limitations:** Surfaces to be coated should be surface dry, clean, and free of foreign material. The TUFF-POXY 607-WB coating must be allowed to cure for a minimum of 3 to 4 hours at 75°F if substrate coated is in the shade or indoors and 1 to 2 hours if exposed to direct sunlight. The base coat must be applied over the TUFF-POXY 607-WB within 24 hours; 16 hours if substrate temperature is 85°F or above. TUFF-POXY 607-WB cures faster when applied under warm temperatures and low humidity conditions and slower when applied during cool weather and high humidity conditions.

**Shelf Life:** Twelve (12) months after manufacture when continuously stored indoors in the original unopened container at temperatures under 80°F and above 35°F.

#### 3. INSTALLATION

**Surface Preparation:** All surfaces to be coated with TUFF-POXY 607-WB must be free of all contamination including curing compounds, oil, grease, paint, and dirt. All joints should be caulked with a polyurethane elastomeric sealant. Concrete surfaces should be free of roughness which will show through and be noticeable in the completed application. Concrete should be cleaned by shotblasting, hydro-blasting or acid etching (followed by neutralizing and thorough rinsing with a pressure washer) and allowed to dry for at least 24 hours.

**Application:** TUFF-POXY 607-WB Part A and Part 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. TUFF-POXY 607-WB is white in color when first applied, but dries to a clear finish. TUFF-POXY 607-WB should be applied at a rate of 250 to 350 square feet per gallon. Cure time will vary with temperature and humidity and if exposed to direct sunlight; the higher the temperature and greater exposure to sunlight the faster the cure. A minimum cure of 3 to 4 hours at 75°F in shady areas is recommended or two hours if exposed to direct sunlight at temperatures below 75°F. Under normal conditions the top coat should be applied over the cured TUFF-POXY 607-WB primer within 16 hours for proper adhesion.

#### 4. TECHNICAL SERVICE

Technical assistance is available by contacting

**TUFFLEX POLYMERS**  
**10880 Poplar Avenue**  
**Fontana, California 92337**  
**Phone: (909) 349-2016**  
**Fax: (909) 823-6309**

#### 5. TECHNICAL DATA

PROPERTY	TYPICAL VALUE	ASTM TEST METHOD
Solids Content (Mixed)	26 ± 2%	D-1353
Weight Per Gallon (Mixed)	8.2 lbs.	D-1475
Viscosity @ 77°F (Mixed Material)	150 cps	D-2393
VOC Content	100 gm/l	Calculated
Flash Point (Mixed)	Above 200°F	D-1310-82
Mix Ratio By Volume	1 to 1	----
Pot Life (1 quart) @ 77°F	24 hours	D-2471
Cure time @ 77°F, 50% R.H.		
Firm to Touch	2 to 4 hours	----
Tack Free	1 - 2 hours	----
Coverage, Sq. Ft., Per Gal.	250 - 350	----
Cured Film Flexibility	Passes 1/8 inch	Mandrel Bend
Cured Film Impact	Passes 60 in. lbs	Reverse Impact

#### 6. PRECAUTIONS

Personnel should wear protective clothing and gloves, avoid contact of material with skin or eyes, and avoid breathing vapors. Mix and apply in well-ventilated areas and observe normal safety precautions. This product is for professional use only.

#### 7. 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 this limited warranty shall not exceed the purchase price of the TUFFLEX material in question.

TUFF-POXY 607-WB (06)

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