



TECHNICAL DATA

TUFF-POXY PRIMER #1

100% SOLIDS / SOLVENT-FREE

PRODUCT DESCRIPTION

COMPOSITION: TUFF-POXY PRIMER #1 is a two (2) component, 100% solids, solvent-free liquid applied, epoxy-polyamine primer. The special polyamine gives unique penetrating characteristics and a rapid cure. It has low viscosity and excellent adhesion to various surfaces and basecoats.

BASIC USES: TUFF-POXY PRIMER #1 is an epoxy-polyamine primer used in the TUFFLEX Decking Systems and other specialty systems. It is specifically formulated to improve polyurethane elastomeric membrane adhesion to concrete and plywood. Because it has low odor, TUFF-POXY PRIMER #1 is excellent for indoor applications.

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

PACKAGING: TUFF-POXY PRIMER #1 is packaged in kit form. The VOLUME MIXING ratio is 2 parts Side-A to 1 part Side-B (Side-A / Side-B = 2:1). TUFF-POXY PRIMER #1 is available in kits of 1 1/2 gallons, 3 gallons, and 15 gallons.

PRE-APPLICATION PRECAUTION

LIMITATIONS: Once the material is mixed together, it must be used within 15 to 20 minutes since TUFF-POXY PRIMER #1 has a short work life and cures and solidifies rapidly when the 2 parts interact. Opened containers must be sealed tightly and remaining unmixed material must be used within several days. Surfaces to be coated must be properly prepared, dry, clean, and free of all foreign matter.

PRECAUTION: TUFF-POXY PRIMER #1 is a component of the TUFFLEX Decking Systems. It should primarily be used as stipulated in these TUFFLEX SPECIFICATIONS. Results occurring from use other than what is stipulated in the TUFFLEX SPECIFICATIONS is not tested or guaranteed by TUFFLEX.

SURFACE REQUIREMENTS: Successful bonding required structurally sound, strong and clean substrates. The substrates must be cleaned to ensure that it is free of all oils, "laitances", greases and other contaminations, such as concrete curing compounds, that may cause poor adhesion of TUFF-POXY PRIMER #1. After cleaning, the surfaces should be rinsed thoroughly to remove loose particles and dust created during shot-blasting or grinding and traces of the cleaning chemicals. Primers, adhesives, detailing, membranes, etc. should not be applied until the surface is dry.

MIXING INSTRUCTIONS: This primer may be diluted with Xylene or Toluene, to the extent allowed by local Air Quality Management authority. Addition of solvent extends the work life of the mixture, provides better surface penetration and is economical. However, strict fire fighting precautions (equipment, procedures, etc.) and health precautions must be observed. TUFF-POXY PRIMER #1 Side-A and Side-B should be thoroughly agitated prior to mixing to ensure a homogeneous material. TUFF-POXY PRIMER #1 must always be mixed with a two parts Side-A and one part Side-B (Side-A: Side-B = 2:1). The combined components should be thoroughly mixed for at least 3 minutes, if mixed by hand.

OPTIONAL: If odor or the use of flammable solvents is not a concern. You may add small amounts of solvent as desired to meet local VOC laws. Blend with a mechanical mixer (explosion proof) for 3 minutes. Induction time is not required.

APPLICATION: TUFF-POXY PRIMER #1 should be applied at the rate of 1 gallon per 350 square feet. It can be applied using a brush or phenolic core roller.

CURING: Allow TUFF-POXY PRIMER #1 to become tacky to the touch, a minimum of 3 hours at 77°F., before filling cracks, joints, or applying the coating.

Note: Temperature will affect the curing time of TUFF-POXY PRIMER #1. Higher temperatures will significantly accelerate the cure time while colder temperatures will significantly retard the cure time. To improve cure/bond time in cooler temperatures, TUFF-POXY PRIMER #1 may be pre-mixed and allowed to sit in the container for 10 to 15 minutes (the cooler the temperature, the longer the residence times) before application. In hot temperatures, the pot life of TUFF-POXY PRIMER #1 is reduced therefore the residence time should be kept relatively short. Recommended application temperature is > 10°C (50°F).

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

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PHYSICAL PROPERTY	TYPICAL VALUE	TEST METHOD
Coverage Rate	1 gal/ 350 ft ²	
Dry Film Thickness per Coat	4 ± 1 mills	
Hardness	70 ± 5 Shore D	
Shelf Life	12 months	
Specific Gravity	Side A 1.09 Side B 1.02	
Total Solids by Weight	100%	ASTM D-2369
Total Solids by Volume	100%	ASTM D-2697
Viscosity at 24°C (75°F)	Side A 400 ± 50 cps Side B 300 ± 50 cps	
Volatile Organic Compounds	0 lbs./gallon	ASTM D-2369-81

PRECAUTIONS: This product contains Epoxy Resins and Polyamine hardeners. Personnel applying these coatings should wear protective clothing, safety goggles 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 required for Epoxy and Amine 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 #1 (07)