PRO INDUSTRIAL™

113.21 HIGH PERFORMANCE EPOXY

PART A B67-200
PART B B67V200
SERIES HARDENER

CHARACTERISTICS

Pro Industrial High Performance Epoxy is a VOC compliant, 80% volume solids, two-package, epoxy polyamine for use in industrial maintenance environments and high performance architectural applications.

- Chemical Resistant
- Abrasion Resistant
- Low VOC

Color: most colors

Recommended Spreading Rate per ct:

Wet mils:	5.0 - 10.0
Dry mils:	4.0 - 8.0
Coverage:	160 - 320 sq ft/gal approximate

Note: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule 5.0 mils wet @ 50% RH:

	@ 50°F	@ 77°F	@100°F
To touch:	10 hrs	8 hrs	2 hrs
Tack free:	10 hrs	8 hrs	5 hrs
To recoat:			
minimum:	36 hrs	8 hrs	5 hrs
maximum:	30 days	30 days	30 days
To cure:	14 days	14 days	3 days

If maximum recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.

Mix Ratio: 4:1
Pot Life: 2.5 hrs 2 hrs 1 hr
Sweat-in-time: None required
Finish: Gloss
Flash Point: 74°F, PMCC, mixed
Shelf Life: Part A 12 months
Part B 36 months
unopened, store indoors 40°F to 100°F.

Tinting with 844 or Blend-A-Color:

Base	oz/gal	Strength
Extra White	0-6	150%
Deep Base	6-18	150%
Ultradeep	6-18	150%

B67W201 (may vary by color)

VOC (EPA Method #24)(mixed): <250 g/L; 2.08 lb/gal
Volume Solids: 80% ± 2%
Weight Solids: 89.5% ± 2%
Weight per Gallon: 12.88 lb

SPECIFICATIONS

Steel, acrylic universal primer:
1ct Pro Industrial Pro-Cryl WB Universal Primer
1-2 cts Pro Industrial High Performance Epoxy

Steel, solvent-based universal primer:
1 ct Kem Bond HS
1-2 cts Pro Industrial High Performance Epoxy

Concrete Block:
1 ct. Heavy Duty Block Filler
1-2 cts Pro Industrial High Performance Epoxy

Poured/Tilt-up Concrete (including floors):
1-2 cts Pro Industrial High Performance Epoxy

Aluminum:
1 ct DTM Wash Primer
1-2 cts Pro Industrial High Performance Epoxy

Galvanized:
1-2 cts Pro Industrial High Performance Epoxy

Interior Plaster and Wallboard:
1 ct PrepRite 200 Latex Primer
1-2 cts Pro Industrial High Performance Epoxy

Wood:
1-2 cts Pro Industrial High Performance Epoxy

System Tested: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP6/NACE 3
Primer: 1 ct. Recoatable Epoxy @ 4.0 mils dft
Finish: 1 ct. Pro Industrial High Performance Epoxy @ 5.0 mils dft

Abrasion Resistance:
Method: ASTM D4060
CS17 wheel, 1000 cycles, 1 kg load
Result: 113 mg loss

Accelerated Weathering - QUV:
Method: ASTM D4587, QUV-A, 5,000 hours
Results: passes

Adhesion:
Method: ASTM D4541
Result: 840 psi

Corrosion Weathering:
Method: ASTM D5894, 13 cycles, 4,368 hours
Result: Rating 10 per ASTM D714 for blistering
Rating 10 per ASTM D610 for rusting

Direct Impact Resistance:
Method: ASTM G14
Result: 70 in. lb.

Dry Heat Resistance:
Method: ASTM D2485
Result: 200°F

Exterior Durability:
Method: 1 year 45° South
Result: Excellent (with chalk)

Flexibility:
Method: ASTM D522, 180° bend, 1½" mandrel
Result: Passes

Moisture Condensation Resistance:
Method: ASTM D4585, 100°F, 1000 hours
Result: No blisters, rust, delamination, or creepage

Pencil Hardness:
Method: ASTM D3363
Result: H

Salt Fog Resistance:
Method: ASTM B117, 6,000 hours
Result: Rating 8 per ASTM D714 for blistering
Rating 10 per ASTM D610 for rusting

Thermal Shock:
Method: ASTM D2246, 15 cycles
Result: Passes

Epoxy coatings may darken or yellow following application and curing.

continued on back

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SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Remove all weld spatter and round all sharp edges by grinding to a minimum of ¼" radius. Prime any bare steel within 8 hours or before flash rusting occurs. Primer required.

Aluminum - Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1. Primer required.

Drywall - Must be clean and dry. All nail heads must be set and spackled. Joints must be taped and covered with a joint compound. Spackled nail heads and tape joints must be sanded smooth and all dust removed prior to painting. Exterior surfaces must be spackled with exterior grade compounds.

Galvanized Steel - Allow to weather a minimum of six months prior to coating. Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1 (recommended solvent is VM&P Naphtha). When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

SURFACE PREPARATION

Masonry and Block - For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI 03732, CSP 1-3. Surfaces must be clean, dry, sound and offer sufficient profile to achieve adequate adhesion. Concrete and mortar must be cured at least 28 days @ 75°F. Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with ArmorSeal Crack Filler.

Plaster - Must be allowed to dry thoroughly for at least 30 days before painting. Room must be ventilated while drying; in cold, damp weather, rooms must be heated. Damaged areas must be repaired with an appropriate patching material. Bare plaster must be cured and hard. Textured, soft, porous, or powdery plaster should be treated with a solution of 1 pint household vinegar to 1 gallon of water. Repeat until the surface is hard, rinse with clear water and allow to dry.

Wood - Surface must be clean, dry, and sound. Paint as soon as possible. No painting should be done immediately after a rain or during foggy weather. Knots and pitch streaks must be scraped, sanded and spot primed. All nail holes or small openings must be properly caulked. Sand to remove any loose or deteriorated surface wood and to obtain a proper surface profile. Self priming.

Previously Painted Surface - If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

APPLICATION

Refer to the MSDS sheet before use

Temperature:	50°F minimum
	110°F maximum
	(Air, surface, and material)
	At least 5°F above dew point
Relative humidity:	85% maximum

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Reducer/Clean Up	Reducer R7K54
Airless Spray	
Pressure	2800 psi
Hose	3/8"-1/2" ID
Tip	.017"
Filter	60 mesh
Reduce	As needed up to 10% by volume
Conventional Spray	
Gun	Binks 95
Fluid Nozzle	66
Air Nozzle	69 PB
Atomization Pressure	60 psi
Fluid Pressure	25 psi
Reduce	As needed up to 10% by volume
Brush	Nylon/Polyester or Natural Bristle
Reduction	Not recommended
Roller	1/4"-3/8" woven
Reduction	Not recommended

If specific application equipment is listed above, equivalent equipment may be substituted.

CLEANUP INFORMATION

Clean spills and spatters immediately with Reducer #54, R7K54. Clean tools immediately after use with Reducer #54, R7K54. Follow manufacturer's safety recommendations when using any solvent.