

106031
106031-01

Better Primer

4.45



RECOATABLE EPOXY PRIMER

Industrial and Marine Coatings

PART G B67A5
PART G B67H5
PART G B67R5
PART H B67V5

GRAY
TAN
RED OXIDE
HARDENER

PRODUCT INFORMATION

Revised 1/87

Product Description

Recommended Uses

RECOATABLE EPOXY PRIMER is a rust inhibitive high build catalyzed polyamide/bisphenol A epoxy primer designed for fast dry and quick or extended recoatability.

- Meets Class A requirements for ASTM A490 Slip Coefficient and Creep Resistance, .50
- Long pot life
- High build coating for economical application
- One year recoatability
- Suitable for use in USDA inspected facilities
- Low temperature application - down to 35°F
- Corrosion resistant

For use as a shop or field applied epoxy primer where a variable recoat window is required due to construction schedules, distribution logistics and environmental considerations. Allows flexibility in projects when completion schedules cannot be specified.

- Primer for structural steel
- Marine applications
- Paper mills
- Storage tanks
- Power plants

PRODUCT CHARACTERISTICS

PERFORMANCE CHARACTERISTICS

Finish: Flat
Color: Red Oxide, Tan, Gray
Volume Solids: 65% ± 2%, mixed
Weight Solids: 81% ± 2%, mixed
VOC (EPA Method 24): Unreduced: 295 g/L; 2.46 lb/gal
mixed Reduced 5%: 323 g/L; 2.70 lb/gal
Mix Ratio: 1:1 by volume

Recommended Spreading Rate per gal:
Wet mils: 6.0 - 9.0
Dry mils: 4.0 - 6.0
Coverage: 175 - 260 sq ft/gal approximate
NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.
Apply at 1.0 - 1.5 mils dft maximum under laminate systems

Drying Schedule 6.0 mils wet @ 50% RH:

	@ 35°F	@ 77°F
To touch:	1 hour	15 minutes
Tack free:	2 hours	30 minutes
To recoat:		
minimum:	6 hours	2 hours
maximum:	1 year	1 year
To cure:	14 days	14 days

Pot Life: @ 35°F 8+ hours @ 77°F 8 hours @ 120°F 3 hours
Sweat-In-Time: 1 hour 30 minutes 10 minutes
If maximum recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.

Shelf Life: 36 months, unopened, at 77°F

Flash Point: 80°F, PMCC, mixed

Reducer/Clean Up: Reducer #54, R7K54

System Tested: (unless otherwise indicated)
Substrate: Steel
Surface Preparation: SSPC-SP6
Primer: 1 ct. Recoatable Epoxy Primer @ 5.0 mils dft

Abrasion Resistance:
Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load
Result: 200 mg loss

Adhesion:
Method: ASTM D4541
Result: 400 psi

Direct Impact Resistance:
Method: ASTM G14
Result: 160 in. lbs.

Dry Heat Resistance:
Method: ASTM D2485
Result: 250°F (discolors)

Flexibility:
Method: ASTM D522, 180° bend, 1" mandrel
Result: Passes

Moisture Condensation Resistance:
Method: ASTM D4585, 100°F, 1000 hours
Result: Good

Pencil Hardness:
Method: ASTM D3363
Result: 3H

Salt Fog Resistance:
Method: ASTM B117, hours
Result: Excellent; no blistering, cracking or delamination.
No more than 1/16" rust creepage at scribe.

Slip Coefficient:
Method: ASTM B117, ASTM A490
Result: Class A, 0.50

Epoxy coatings may darken or yellow following application and curing.

Provides performance comparable to products formulated to federal specifications: Mil-P-23377, Mil-P-53022

**SHERWIN
Williams****RECOATABLE EPOXY PRIMER**

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HARDENER**PRODUCT INFORMATION****RECOMMENDED SYSTEMS****Steel (Catalyzed Epoxy Topcoat):**

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 8.0 mils dft
2 cts. Sher-Tile HS Epoxy @ 4.0 - 8.0 mils dft/ct

Steel (Polyurethane Topcoat):

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 6.0 mils dft
1-2 cts. Corothane II @ 2.0 - 4.0 mils dft/ct

Steel (Acrylic Epoxy Topcoat):

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 6.0 mils dft
2 cts. Water Based Catalyzed Epoxy
@ 2.5 - 3.0 mils dft/ct

Steel (Acrylic Topcoat):

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 8.0 mils dft
2 cts. DTM Acrylic Coating @ 2.5 - 4.0 mils dft/ct

Galvanized:

- 1 ct. Recoatable Epoxy Primer @ 4.0 - 6.0 mils dft
2 cts. Sher-Tile HS Epoxy @ 4.0 - 8.0 mils dft/ct

Immersion**Steel (Laminate System):**

- 1 ct. Recoatable Epoxy Primer @ 1.0 - 1.5 mils dft
maximum (Additional reduction of 20 to 25% may
be required to achieve the recommended film
thickness.)
1 ct. Poly-Glass Putty, as need for fairing surfaces and
to radius chine areas.
1 ct. Poly-Glass Polyester Resin with 1½ oz. glass mat
@ 40 - 45 mils dft
1 ct. Poly-Glass Polyester Resin with Wax Solution
@ 15 - 20 mils dft (gel coat)
Total Laminate thickness: 55 - 65 mils dft

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.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel:	
Atmospheric:	SSPC-SP6, 2 mil profile
Laminate system:	SSPC-SP10, 2 mil profile
Galvanizing:	SSPC-SP1

COLOR AVAILABILITY/TINTING

Do not tint.

Color: Red Oxide, Tan, Gray

APPLICATION CONDITIONS

Temperature:	
air and surface:	35°F minimum, 120°F maximum
material:	50°F minimum
	At least 5°F above dew point

Relative humidity:	85% maximum
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Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:	5 gallons mixed
Part A:	4 gallons in a 5 gallon container
Part B:	1 gallon

Weight per gallon:	13.28 ± 0.2 lb, mixed
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SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

The systems listed above are representative of the product's use. Other systems may be appropriate.



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APPLICATION BULLETIN

APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with power agitation. Make certain no pigment remains on the bottom of the cans. Then combine one part by volume of Part G with one part by volume of Part H. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per gal:

Wet mils:	6.0 - 9.0
Dry mils:	4.0 - 6.0
Coverage:	175 - 260 sq ft/gal approximate

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance. Apply at 1.0 - 1.5 mils dft maximum under laminate systems.

Drying Schedule 6.0 mils wet @ 50% RH:

	① 35°F	② 77°F	
To touch:	1 hour	15 minutes	
Tack free:	2 hours	30 minutes	
To recoat:			
minimum:	6 hours	2 hours	
maximum:	1 year	1 year	
To cure:	14 days	14 days	
Pot Life:	③ 35°F 8+ hours	④ 77°F 8 hours	⑤ 120°F 3 hours

Sweat-In-Time: 1 hour 30 minutes 10 minutes

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

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Reducer #54, R7K54.

Material must be at least 50°F prior to catalyzing.

Refer to Product Information sheet for additional performance characteristics and properties.

CLEAN-UP INSTRUCTIONS

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.

SAFETY PRECAUTIONS

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APPLICATION BULLETIN

Revised 1/97

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 (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10. 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 1/4" radius. Prime any bare steel the same day as it is cleaned.

Iron & Steel (Immersion service, laminate system only)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10. 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 1/4" radius. Prime any bare steel the same day as it is cleaned. Maximum dft 1.0 mils for use under laminant systems.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Solvent Clean 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.

Previously Painted Surfaces

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 CONDITIONS

Temperature:
air and surface: 35°F minimum, 120°F maximum
material: 50°F minimum
At least 5°F above dew point

Relative humidity: 85% maximum

APPLICATION EQUIPMENT

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

Below 80°F Reducer #54, R7K54
Above 80°F Reducer #100, R7K100

Airless Spray

Pressure 2400 psi
Hose 1/4" ID
Tip017"
Filter 60 mesh
Reduction as needed up to 5% by volume

Conventional Spray not recommended

Brush

Brush Natural Bristle
Reduction not recommended

Roller

Cover 3/8" - 1/2" woven with phenolic core
Reduction not recommended

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