



TECHNICAL DATA

FLEXSTONE EPOXY PRIMER

TWO-COMPONENT, LOW VISCOSITY, EPOXY PRIMER/SEALER

PRODUCT DESCRIPTION

COMPOSITION: Flexstone PRIMER 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: FLEXSTONE PRIMER 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 FLEXSTONE PRIMER 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. FLEXSTONE PRIMER enhances the long-term adhesion of the polyurethane membrane to the substrate. It is also an excellent coating for dust proofing concrete. FLEXSTONE PRIMER also has good adhesion to properly cleaned ferrous metal.

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

PACKAGING: Flexstone 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**). FLEXSTONE PRIMER is available in kits of two (2) quarts, two (2) gallons, and two (2) each 5 gallon pails.

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 FLEXSTONE PRIMER cures and solidifies rapidly when the two parts interact. Unmixed containers which are left open must also be used within several days since FLEXSTONE PRIMER contains solvents which evaporate when exposed to air. The primer should not be diluted. Surfaces to be coated with FLEXSTONE PRIMER must be dry, clean, and free of all foreign matter.

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

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

SURFACE PREPARATION: All surfaces to be coated with FLEXSTONE PRIMER 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: FLEXSTONE PRIMER Side-A and Side-B should be thoroughly agitated prior to mixing to ensure a homogeneous material. FLEXSTONE PRIMER 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: FLEXSTONE PRIMER 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. FLEXSTONE PRIMER 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.

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PROPERTY	TYPICAL VALUE	TEST METHOD
Solids Content (Mixed)	80 ± 2%	ASTM D-1353
Weight per Gallon		
Part A (Resin)	8.5 lbs.	ASTM D-1475
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 MSDS sheets before using this product. **THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.**

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

This limited warranty is the only warranty extended by FLEXSTONE with respect to its materials. There are no other warranties, including the implied warranties of merchantability and fitness for a particular purpose. FLEXSTONE 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 FLEXSTONE'S liability and buyer's remedy under his limited warranty shall not exceed the purchase price of the FLEXSTONE material in question.