



FIVE STAR
Specified by the World's Best™

EPOXY PRIMER

Low Viscosity Epoxy Baseplate Primer

PRODUCT DESCRIPTION

Five Star® Epoxy Primer is a two component, 100% solids, low viscosity epoxy primer designed for steel and concrete corrosion protection. It is formulated to be brush, roller or spray applied in industrial applications to provide a protective coating and barrier against corrosion and provides excellent adhesion to steel and concrete while maintaining a strong bond with epoxy grouts.

ADVANTAGES

- Excellent moisture tolerance
- 100% solids provides greater coverage on first coat
- Low VOC
- Tough abrasion and impact resistance
- Excellent adhesion to steel, concrete and Five Star® Epoxy Grouts
- Fast cure response

USES

- Pump bases
- Rotating equipment
- Induced draft fans
- Compressors

PACKAGING AND YIELD

Five Star® Epoxy Primer is a two-component 3:1 ratio epoxy primer offered in A & B pails to form a single 1-gallon unit when combined. Approximate yield is 530 ft² (49.2 m²) @ 3 mils DFT.

SHELF LIFE

Two years in original unopened packaging when stored in dry conditions at 45°F - 90°F (5°C - 35°C). High relative humidity reduces shelf life.

TYPICAL PROPERTIES AT 70°F (21°C)				
Color	Clear			
Gel Time	50°F (10°C)	70°F (21°C)	90°F (32°C)	
	40 minutes	30 minutes	20 minutes	
Adhesion (7) Days ASTM D 4541				
DFT	A36 Steel/DP Grout	A36 Steel/HP Grout	A36 Steel/SP Grout	Concrete
3-5 mils	950 psi (6.5 MPa)	1,150 psi (7.9 MPa)	1,350 psi (9.3 MPa)	550 psi (3.8 MPa)
5-8 mils	1,250 psi (8.6 MPa)	1,300 psi (9.0 MPa)	1,450 psi (10.0 MPa)	650 psi (4.5 MPa)
Hardness (7) Days on A 36 Steel				
DFT	Shore D Harness , ASTM D 2240		Pencil Hardness, ASTM D 3363	
3-5 mils	70-75 durometer		2H-3H	
5-8 mils	78-86 durometer		4H-5H	
Dry Time @ 3-5 mils	Touch—5 Hrs	Handle—6 Hrs	Hard—10 Hrs	Grout—18Hrs

The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result. Test methods are modified where applicable.

PLACEMENT GUIDELINES

1. **SURFACE PREPARATION:** Surface must be clean, dry and free from any other substance or contaminates. For best results surfaces should be prepared to an SSPC-SP5 or better profile.
2. **MIXING:** **Five Star® Epoxy Primer** should be preconditioned to between 65°F and 85°F (18°C and 29°C) before using. Pour contents of Component B into Component A and stir. Mix complete unit in the proportions supplied. DO NOT THIN. Once it has been mixed, note the working pot life of the material.
3. **APPLICATION:** Use only a lint free roller with 1/2" or 1/4" nap. NOTE: Material may be applied using airless spray equipment. Consult Five Star Products' Engineering and Technical Service Center first.
4. **CLEAN UP:** Flush and clean all equipment immediately after use with xylene or MEK. Cured material can only be removed mechanically.

NOTE: PRIOR TO APPLICATION, READ ALL PRODUCT PACKAGING THOROUGHLY. For more detailed placement procedures, refer to the Five Star Products' Design-A-Spec™ installation guidelines or call the Five Star Products' Engineering and Technical Service Center at 1-800-243-2206.

CONSIDERATIONS

- Minimum application temperature of substrate is 40°F (4°C) and rising.
- Low temperatures adversely affect flowability and strength gain.
- Cold temperatures lengthen gel time; hot temperatures decrease gel time.
- Do not thin with solvents.
- If primer has aged longer than 90 days then some form of abrasive measures to the surface of the primer are recommended before grouting.

CAUTION

Irritant, toxic, strong sensitizer. Contains epoxy resin and amine. This product may cause skin irritation. Do not inhale vapors. Provide adequate ventilation. Protect against contact with skin and eyes. Wear rubber gloves, long sleeve shirt, goggles with side shields. In case of contact with eyes, flush repeatedly with water and contact a physician. Areas of skin contact should be promptly washed with soap and water. Do not take internally. Keep product out of reach of children. **PRIOR TO USE, REFER TO MATERIAL SAFETY DATA SHEET.**

For worldwide availability, additional product information and technical support, contact your local Five Star® distributor, local sales representative, or you may call Five Star Products' Engineering and Technical Service Center at 1-800-243-2206.

SKU / PRODUCT CODE	DESCRIPTION	UNIT SIZE
34600	Five Star® Epoxy Primer	1 Gallon

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