Tufcote™ LV PR Epoxy Primer
(Formerly Maximus 5187)

GENERAL

DESCRIPTION
Tufcote LV PR 5187 Epoxy Primer is a corrosion resistant two-part (4:1) epoxy primer that is extremely hard, tough and durable. When mixed with Tufcote 5199 Activator, the combined component VOC level is 0.8 lbs/gal (100 g/l), or less, to meet the requirements of SCAQMD Rule 1113 for the category of Industrial Maintenance Coatings. May be applied by spray application, brush or roller.

SUGGESTED USES
As an economy coating for use indoors, outdoors, above water, over properly prepared steel, wood, concrete, aluminum or fiberglass where the following attributes are desirable:
- Extremely hard, tough and durable
- Corrosion resistant
- Exceptionally strong adhesion
- Will withstand above water exposure
- Excellent for long-term protection

COMPATIBILITY WITH OTHER COATINGS
- Tufcote 5100 and 5500 Series Topcoats
- Priming and protecting unpainted steel
- As a primer under epoxy and polyurethane topcoats

COLOR
5187 Light Grey

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Tufcote LV PR 5187 Primer	1 gallon container 80% full (102 oz.)
Tufcote LV PR 5199 Activator	1 quart container 80% full (26 oz.)

MIX RATIO

Component	**Part by Vol.**
Tufcote LV PR 5187 Primer	4
Tufcote LV PR 5199 Activator	1

MIXING
Assure color is uniform and there are no solids on bottom of can.

Tufcote LV PR 5187 Epoxy Primer is a two-part product consisting of Part A Base and Part B Activator. The proper mixing ratio is 4:1.

Part A Base must be mixed with Tufcote 5199 Solventborne Epoxy Primer Activator – Part B before the product can be used.

MIX ONLY WHEN READY TO USE. Mix four parts Tufcote LV PR 5187 Epoxy Primer with one part 5199 Tufcote Epoxy Primer Activator. Stir intermittently and allow to set in an open container for 30 minutes before application and/or thinning.

Reduction

If thinning is necessary, reduce with Tufcote 82 Super Gloss & Flow Zero VOC Reducer or Tufcote 8020 Zero VOC Exempt Solvent, up to 10%. Thin to desired viscosity after the Tufcote 5199 Epoxy Primer Activator has been added.

POT LIFE

Pot life is approximately 3 hours @77ºF (25ºC). Pot Life can be extended by adding Tufcote 82 Super Gloss & Flow Zero VOC Reducer or Tufcote 8020 Zero VOC Exempt Solvent. Pot Life will be reduced as the ambient temperature rises about 77ºF (25ºC) and/or when volume of mixture exceeds 1 gallon.

APPLICATION

APPLICATION CONDITIONS

Application at air and surface temperatures lower than 125°F (52ºC) and above 50°F (10ºC) and more than 5°F (-15ºC) above the dew point is suggested.

SURFACE PREPARATION

All surfaces to be painted must be clean, dry and in fit condition to be painted. Be sure to remove all wax, silicone, oil, powdery or scaling rust, loose or peeling paint and all other foreign matter. Smooth, slick surfaces should be sanded to promote adhesion. Prime bare and uncoated surfaces with Tufcote Epoxy Primer.

BARE FERROUS METALS: Clean off all dirt, grease, oil, wax or other foreign matter. All loose, powdery or scaling rust must also be removed. A completely de-rusted surface is recommended. Prime bare and uncoated surfaces with Tufcote Epoxy Primer.

For best results on steel, abrasive blast surface to an SSPC-SP-6 Commercial Blast. Profile should be 2.0 to 2.5 mils. Average peak to valley surface profile shall be 1.5 to 2.5 mils. If blasting is not possible or practical, hand tool clean to an SSPC-SP 2 or power tool clean to an SSPC-SP 3 may be used with sacrifice in performance vs. blasted surfaces.

Aluminum surfaces should be properly treated. Surface preparations may include sanding, brush off blasting (SSPC-SP7), alodine treatment, treatment with an acid, or other preparation necessary to ensure adhesion. All aluminums are not alike, it is strongly suggested that adhesion testing be done to assure system robustness.

Galvanized steel surface preparation may include detergent washing, pre-treatment and abrasion for new surfaces; for weathered surfaces, detergent washing and sanding. For new galvanized surfaces, acid treatments, degreasing and abrasion might be required before application of appropriate primer.

PAINTED SURFACES: Tufcote LV PR 5187 Epoxy Primer may lift old paint. We recommend a test patch. If lifting occurs, remove old paint and follow directions for bare ferrous metals. Be sure all loose and peeling paint is completely removed, and the surface is clean. Remove excess chalkiness with a wire brush or by sanding. Feather edge and spot prime with Tufcote Epoxy Primer.

BARE WOOD: Clean wood thoroughly. Prime and seal with one coat of Tufcote Epoxy Primer or Tufcote Enamel (tinted close to finish color, if desired).

APPLICATION

Be sure all spray painting equipment is clean and ready to use prior to mixing and application of coating. Apply by spray, (or in small areas by brush or roller) in an even, wet coat. Give particular attention to all irregularities to ensure that they are completely covered. On a porous type primer or substrate, the use of a thin or "mist" coat may be needed.

Re-Coat

Recoat when material is relatively dry and firm [12 hours-4 days at 77°F (25°C) and 50% RH], but before coating reaches complete cure and hardness. Check for desired film thickness and continuity.

CLEAN UP THINNERS

Do not allow catalyzed material to stand in equipment after use. Clean equipment immediately after use in an enclosed spray equipment cleaner with Axalta Tufcote 8020 Zero VOC Exempt Solvent.

DRY TIMES

Cure Time at Recommended Thickness @ 50% RH

	77°F (25°C)
To Touch	2 hours
To Handle	12 hours
Recoat Time	12 hours - 4 days (under certain conditions, can be at @ 2hours)
Full Cure	7 days

Allow final dry time of at least 4 days at 77°F. All solvent vapors should be removed before placing in service. Curing time is significantly shorter at higher temperatures or lower film thicknesses, and longer at lower temperatures or higher film thicknesses.

PHYSICAL PROPERTIES

Viscosity	65-70 Kreb Units @ 77ºF
Volume Solids	41-42%
Weight Solids	57-58%
Theoretical Coverage Per Gallon	672 ft² per gallon @ 1 mil DFT
Solvents Used	Xylene/Methyl Acetate/Butyl Acetate/Butyl Alcohol/Tert-Butyl Acetate
Flash Point	8.6ºF/TCC (Base), 40ºF/TCC (Catalyst)
Gloss	Flat
Shelf Life	12 months
Recommended DFT	2-3 mils DFT (5-7 mils WFT)

Application by brush and roller may require additional coats to achieve recommended films thickness.

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between 35ºF (2ºC) and 90ºF (32ºC).

VOC REGULATIONS

VOC (Theoretical, varies with color).

0.8 lbs/gal (100 grams per liter) or less

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: August 2017

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