

351 Epoxy Primer

Updated: January 2015

Specification Data

Generic Type: Polyamide epoxy

Description: APCO 351 is a two component, high solids, corrosion inhibitive epoxy primer. When applied over properly prepared surfaces it exhibits excellent adhesion and corrosion resistance. Formulated to achieve outstanding intercoat adhesion with urethane enamels such as APCO 400HS and APCO 427. Excellent for fixed and mobile equipment where a long lasting durable yet economical coating is required.

Features:

- Excellent adhesion properties
- Outstanding intercoat adhesion
- VOC compliant
- Can be top coated quickly

Solids Content: 54% by Volume

Theoretical Coverage:

- 868 mil ft²
- 217 ft² @ 4 Mils

Allow for loss during mixing & application.

VOC Value:

- 3.27 lbs/gal per EPA Method 24

Color: 1062 White, 1028 Gray, 2015 Red Oxide

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: not recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 2.0-3.0 Mil.

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Concrete: Concrete must be cured 28 days at 75°F minimum. Prepare surface in accordance with ASTM D4258 surface cleaning of concrete. Maximum performance achieved when surface is abraded in accordance with ASTM D4259

Topcoats: APCO 400HS, APCO 427, APCO 300, APCO 220

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2100 or 95 Gun w/65 series nozzles and 56 needle.
- **Airless:** Graco 30:1 Min. 1/4" material line. Silver Gun Tip size: .01-.015 Output PSI- 3000

Brush & Roller:

- **Brush:** Synthetic bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: 2

Mix Ratio: 4 Part A to 1 Part B

Pot Life: 8 hours at 75°F

Mixing: Power mix each part separately, then combine and mix to uniform color & consistency.

Induction Time: None.

Pot life is significantly shorter at higher temperatures and larger mixed volumes. Consult APCO technical representative for more information.

Thinning:

- **Spray:** Up to 12 oz/gal with S118 if necessary

Application

Pre-application: Flush all equipment with thinner S108 or MEK

Temperature: Application range from 60°F-110°F surface temperature. Do not apply below 60°F.

Method: Apply one coat maintaining a wet edge to achieve a wet film thickness of 4-6 Mils. Apply second coat of 4-6 mils of a contrasting color after 1 hour. Maximum performance will be achieved with two coats totaling 4-6 mils dry film thickness. Dry film thickness over 10 mils is not recommended.

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Application Continued

Inspection: Test for voids in coating film using low voltage holiday detector. Dry film thickness can be measured with either a calibrated magnetic or electronic dry film thickness guage.

Clean up & disposal: After use immediately flush all equipment with thinner S108 or MEK. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 2.5 hours

Dry to recoat/topcoat: 2 hours

Dry to through: 6 hours

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: Pre measured 1 & 5 gallon kits

Shipping Weight: 13 lbs/gal

UN Classification: UN1263, PAINT, CLASS 3, PGIII