



**Pruett-Schaffer**  
*Coatings for a Green World*  
**412-771-2000**

[www.pruett-schaffer.com](http://www.pruett-schaffer.com)

**PRODUCT NUMBER**      **PRODUCT NAME**

**10-SERIES      HIGH BUILD EPOXY PRIMERS, 2-COMPONENT SYSTEM**

**GENERAL DESCRIPTION**

Pruett-Schaffer's 10-Series coatings are solvent based, two component, epoxy primers. Apply by brush, roller or regular spray equipment. Use on metal, concrete or previously painted surfaces. They are formulated with high performance phenalkamine (low temperature cure) hardeners and epoxy resins that are designed for extended pot life, good adhesion over a wide variety of substrates, good chemical resistance, and excellent corrosion resistance. Topcoating may be done with a wide variety of paints. Contact P-S for recommendations.

**RECOMMENDED USES**

10-Series coatings are recommended for use in areas where chemical splash, fume, mist, or vapor creates a corrosive environment in which it is difficult or expensive to repaint. They will resist chemicals, solvents, dilute acid or alkali, water, oils, and salt. These primers have excellent adhesion and can be used as repair paints where minimum surface preparation is necessary and as lead paint encapsulation coatings. They work well with 14-Series epoxy mastic topcoats for maximum corrosion resistance, and with 24- or 25-Series acrylic topcoats and 65 or 66 series urethanes for excellent exterior weathering, depending on the application.

**SURFACE PREPARATION**

For severe service, metal substrates should be blasted to SSPC-SP-10 White Metal blast. An SSPC-SP-6 commercial Blast may be sufficient for most applications with less severe

requirements. Degreasing, brush blasting or power washing may be used for repainting jobs where the paint is tightly adhering.

**MIXING INSTRUCTIONS**

Mix 4 parts by volume A component with 1 part 10-B Hardener. Mix at slow speed to avoid entraining air into the paint, box the mixing containers. Use at once, there is no induction time. Do not use previously used mixing containers; partially cured material will greatly accelerate the cure of the freshly mixed paint resulting in dramatically reduced pot life. Clean mixing blade after each use.

**THINNING**

Under normal conditions no thinning is necessary. If desired, thin with xylol. Add a little at a time with constant gentle agitation to a maximum of 5% by volume.

**APPLICATION EQUIPMENT**

Apply by regular spray equipment, brush or roller (1/4" nap or less); touch up by brush or tie in sprayed areas within 10 minutes for best results. Use .015-.017 inch spray tip size. The recommended dry film build per coat typically is between 2 and 4 mils when sprayed.

**CURING TIMES & TEMPERATURES**

Cures set-to-touch in 1-2 hours at 75 °F; 3-5 hours at 57 °F; 1/2 hour 87 °F. Recoating should be done after 8 hours and before 48 hours cure time or reduced adhesion may result. Allow 7-10 days cure (minimum at 75 °F) before placing into severe service.

Unlike normal epoxy coatings, products in this series will cure at temperatures below freezing.

**CLEANUP**

Clean equipment with xylol or toluol before the film cures.

**ENVIRONMENTAL**

These products meet current air pollution regulations regarding hydrocarbon and ozone reactive emissions. They are VOC compliant for most industries, are chromate free, and comply with current federal regulations regarding the use of lead in paint.

**PHYSICAL PARAMETERS**

**VOC, ASTM D-3960:**  
3.30 lb./gal mixed system typical

**WEIGHT PER GALLON, ASTM D-1475:**  
11.2 lbs. mixed system typical

**NONVOLATILE, mixed system:**  
By weight: 69-71% , by volume: 53-54%

**THEORETICAL COVERAGE:**  
860 -870 ft<sup>2</sup>/gallon/mil, dry film

**INITIAL GLOSS, 60°, ASTM D-523:** 1-15

**VISCOSITY, mixed system, ASTM D-562:**  
60-80 Krebs Units

**POT LIFE, mixed in 5 gal lots:**  
6-8 hrs @ 77 °F; 2 hrs @ 90 °F  
Pot life will shorten if accelerator is added.

**FLASH POINT, TAG CC:** 81 °F

THIS INFORMATION RESULTS FROM TESTS CONDUCTED IN A LABORATORY UNDER LABORATORY CONDITIONS. DIFFERENT RESULTS MAY BE OBTAINED IN COMMERCIAL USE OF THIS PRODUCT UNDER FACTORY OR FIELD CONDITIONS. PRUETT-SCHAFFER MAKES NO WARRANTY CONCERNING THE SUITABILITY OF THIS PRODUCT FOR THE END USE CONTEMPLATED BY THE BUYER, EXCEPT THAT THE PRODUCT SHALL BE IN COMPLIANCE WITH THE TECHNICAL SPECIFICATIONS PRESENTED HEREIN.

REVISED 03-24-2006