



Protective RECOATABLE EPOXY PRIMER & Marine Coatings LOW VOC

PART G
PART H

B67-45
B67V45

SERIES
HARDENER

Revised: August 19, 2022

PRODUCT INFORMATION

4.48

PRODUCT DESCRIPTION

Recoatable Epoxy Primer Low VOC is a rust-inhibitive high build catalyzed polyamide/bisphenol A epoxy primer designed for fast dry and quick or extended recoatability. It is a low VOC product that contains solvents that are exempt from VOC emissions.

- Long pot life
- High build coating for economical application
- One year recoatability
- Suitable for use in USDA inspected facilities
- Low temperature application - down to 35°F (1.6°C)
- Corrosion resistant (contains zinc phosphate)
- Outstanding application properties

PRODUCT CHARACTERISTICS

| | |
|----------------------|---|
| Finish: | Flat |
| Color: | Off-White, Red Oxide |
| Volume Solids: | 66% ± 2%, mixed |
| Weight Solids: | 76% ± 2%, mixed |
| VOC (EPA Method 24): | Unreduced: 100 g/L; 0.71 lb/gal mixed Reduced 5%: 100 g/L; 0.71 lb/gal |
| Mix Ratio: | 1:1 by volume |

Recommended Spreading Rate per coat:

| | Minimum | Maximum |
|---|-----------|----------|
| Wet mils (microns) | 6.0 150 | 9.0 225 |
| Dry mils (microns) | 4.0* 100 | 6.0* 150 |
| ~Coverage sq ft/gal (m ² /L) | 175 4.3 | 260 6.4 |
| Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft | 1056 25.9 | |

*See Performance Tips section

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

@ 77°F/25°C
50% RH

| | |
|---|------------|
| To touch: | 15 minutes |
| Tack free: | 30 minutes |
| To recoat: | |
| minimum: | 2 hours |
| maximum: | 1 year |
| To cure: | 7 days |
| If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent. | |
| Pot Life: | 5 hours |
| Sweat-in-time: | 30 minutes |

| | |
|--------------|--|
| Shelf Life: | Part G - 24 months, unopened Part H - 36 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C). |
| Flash Point: | 88°F (31°C), PMCC, mixed |
| Reducer: | R7K111 |
| Clean Up: | R7K111 or Reducer #54 (R7K54) |

RECOMMENDED USES

For use as a shop or field applied epoxy primer where a variable recoat window is required due to construction schedules, distribution logistics and environmental considerations. Affords flexibility in projects when completion schedules cannot be specified.

- Primer for structural steel
- Marine applications
- Paper mills
- Storage tanks
- Power plants

Approved primer coat for FIRETEX M90 and M93 series systems.

PERFORMANCE CHARACTERISTICS

Substrate*: Steel

Surface Preparation*: SSPC-SP6/NACE 3

System Tested*:

- 1 ct. Recoatable Epoxy Primer Low VOC@ 4.0 - 6.0 mils (100-150 microns) dft
- 1 ct. Acrolon 218 HS @ 4.0-6.0 mils (100-150 microns) dft

*unless otherwise noted below

| Test Name | Test Method | Results |
|--|--|---|
| Abrasion Resistance (primer only) | ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load | 200 mg loss |
| Adhesion (primer only) | ASTM D4541 | 1050 psi |
| Corrosion Weathering | ASTM D5894, 12 cycles, 4368 hours | Rating 7 per ASTM D610 for Rusting; Rating 10 per ASTM D714 for Blistering |
| Direct Impact Resistance (primer only) | ASTM D2794 | 60 in. lbs. |
| Dry Heat Resistance (primer only) | ASTM D2485, Method A, Quench Test | 250°F (121°C) |
| Flexibility (primer only) | ASTM D522, 180° bend, 1" mandrel | Passes |
| Moisture Condensation Resistance | ASTM D4585, 100°F (38°C), 2000 hours | Rating 10 per ASTM D610 for Rusting; Rating 10 per ASTM D714 for Blistering |
| Pencil Hardness (primer only) | ASTM D3363 | 3H |
| Salt Fog Resistance | ASTM B117, 5600 hours | Rating 7 per ASTM D610 for Rusting; Rating 10 per ASTM D714 for Blistering |



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RECOMMENDED SYSTEMS

| | | Dry Film Thickness / ct. | |
|--|------------------------------------|--------------------------|-----------|
| | | Mils | (Microns) |
| Steel, catalyzed epoxy topcoat: | | | |
| 1 ct. | Recoatable Epoxy Primer Low VOC | 4.0-6.0 | (100-150) |
| 2 cts. | Tile-Clad HS Epoxy | 2.5-4.0 | (63-100) |
| Steel, polyurethane topcoat: | | | |
| 1 ct. | Recoatable Epoxy Primer Low VOC | 4.0-6.0 | (100-150) |
| 1-2 cts. | Hi-Solids Polyurethane | 3.0-4.0 | (75-100) |
| Steel, acrylic epoxy topcoat: | | | |
| 1 ct. | Recoatable Epoxy Primer Low VOC | 4.0-6.0 | (100-150) |
| 2 cts. | Water Based Catalyzed Epoxy | 2.5-3.0 | (63-75) |
| Steel, acrylic topcoat: | | | |
| 1 ct. | Recoatable Epoxy Primer Low VOC | 4.0-6.0 | (100-150) |
| 2 cts. | Pro Industrial DTM Acrylic Coating | 2.5-4.0 | (63-100) |
| Galvanized: | | | |
| 1 ct. | Recoatable Epoxy Primer Low VOC | 2.0-4.0 | (50-100) |
| 2 cts. | Tile-Clad HS Epoxy | 2.5-4.0 | (63-100) |

The systems listed above are representative of the product's use, other systems may be appropriate.

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel: SSPC-SP6/NACE 3, 2 mil (50 micron) profile
Galvanized: SSPC-SP1

| Surface Preparation Standards | | | | | |
|-------------------------------|----------------------|-------------------------|---------------------------|-------|------|
| | Condition of Surface | ISO 8501-1 BS7079:A1 | Swedish Std. SIS055900 | SSPC | NACE |
| White Metal | | Sa 3 | Sa 3 | SP 5 | 1 |
| Near White Metal | | Sa 2.5 | Sa 2.5 | SP 10 | 2 |
| Commercial Blast | | Sa 2 | Sa 2 | SP 6 | 3 |
| Brush-Off Blast | | Sa 1 | Sa 1 | SP 7 | 4 |
| Hand Tool Cleaning | Rusted | C St 2 | C St 2 | SP 2 | - |
| | Pitted & Rusty | D St 2 | D St 2 | SP 2 | - |
| | Rusty | C St 3 | C St 3 | SP 3 | - |
| Power Tool Cleaning | Pitted & Rusty | D St 3 | D St 3 | SP 3 | - |

TINTING

Do not tint.

APPLICATION CONDITIONS

Temperature:

air and surface: 35°F (1.6°C) minimum, 140°F (60°C) maximum
material: 50°F (10°C) minimum
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging: 5 gallon (18.9L) containers

Weight: 14.55 ± 0.2 lb/gal ; 1.75 Kg/L, mixed

SAFETY PRECAUTIONS

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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Protective & Marine Coatings

RECOATABLE EPOXY PRIMER

LOW VOC

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PART H

B67-45
B67V45

SERIES
HARDENER

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APPLICATION BULLETIN

4.48

SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned.

Galvanized Steel

Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SP1. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7/NACE 4 is necessary to remove these treatments. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2, prime the area the same day as cleaned.

Previously Painted Surfaces

If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

APPLICATION CONDITIONS

Temperature:

air and surface: 35°F (1.6°C) minimum, 140°F (60°C) maximum
material: 50°F (10°C) minimum
At least 5°F (2.8°C) above dew point

Relative humidity:

85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

ReducerR7K111

Clean UpR7K111 or Reducer #54 (R7K54)

Airless Spray

Pressure.....2400 psi
Hose.....1/4" ID
Tip017" - .021"
Filter60 mesh
Reduction.....As needed up to 5% by volume

Conventional Spray

GunBinks
Fluid Nozzle66
Air Nozzle.....63PB
Atomization Pressure.....50 psi
Fluid Pressure.....12-20 psi
Reduction.....As needed up to 5% by volume

Brush

Brush.....Natural Bristle
Reduction.....Not recommended

Roller

Cover3/8" - 1/2" woven with solvent resistant core
Reduction.....Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

Surface Preparation Standards

| Condition of Surface | ISO 8501-1 BS7079:A1 | Swedish Std. SIS055900 | SSPC | NACE |
|----------------------|--------------------------|---------------------------|-------|------|
| White Metal | Sa 3 | Sa 3 | SP 5 | 1 |
| Near White Metal | Sa 2.5 | Sa 2.5 | SP 10 | 2 |
| Commercial Blast | Sa 2 | Sa 2 | SP 6 | 3 |
| Brush-Off Blast | Sa 1 | Sa 1 | SP 7 | 4 |
| Hand Tool Cleaning | Rusted D St 2 | C St 2 | SP 2 | - |
| Pitted & Rusty | D St 2 | D St 2 | SP 2 | - |
| Rusted | C St 3 | C St 3 | SP 3 | - |
| Power Tool Cleaning | Pitted & Rusty D St 3 | D St 3 | SP 3 | - |



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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the cans. Then combine one part by volume of Part G with one part by volume of Part H. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate per coat:

| | Minimum | Maximum |
|--|------------------|-----------------|
| Wet mils (microns) | 6.0 150 | 9.0 225 |
| Dry mils (microns) | 4.0* 100 | 6.0* 150 |
| ~Coverage sq ft/gal (m ² /L) | 175 4.3 | 260 6.4 |
| Theoretical coverage sq ft/gal (m ² /L) @ 1 mil / 25 microns dft | 1056 25.9 | |

*See Performance Tips section

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Drying Schedule @ 6.0 mils wet (150 microns):

@ 77°F/25°C
50% RH

| | |
|-------------------|------------|
| To touch: | 15 minutes |
| Tack free: | 30 minutes |
| To recoat: | |
| minimum: | 2 hours |
| maximum: | 1 year |
| To cure: | 7 days |

*If maximum recoat time is exceeded, abrade surface before recoating.
Drying time is temperature, humidity, and film thickness dependent.*

| | |
|-----------------------|------------|
| Pot Life: | 5 hours |
| Sweat-in-time: | 30 minutes |

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with R7K111 or Reducer #54 (R7K54). Clean tools immediately after use with R7K111 or Reducer #54 (R7K54). Follow manufacturer's safety recommendations when using any solvent.

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PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Do not apply the material beyond recommended pot life.

Do not mix previously catalyzed material with new.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with R7K111 or Reducer #54 (R7K54).

Material must be at least 50°F (10°C) prior to catalyzing.

When coating over aluminum and galvanizing, recommended dft is 2-4 mils (50-100 microns).

Refer to Product Information sheet for additional performance characteristics and properties.

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