



TECHNICAL DATA SHEET

Tremco® Epoxy Primer
Two-Part Epoxy Primer

PRODUCT DESCRIPTION

Tremco® Epoxy Primer is a two-component (1:1) primer recommended for use as a porous primer and is also used as a compatible tie-in to create connectivity between TREMproof® below-grade waterproofing membranes, Vulkem® urethane coatings and ExoAir® air barrier membranes.

Tremco Epoxy Primer may also be used as shallow concrete repair when mixed with Silica Sand.

BASIC USES

Tremco Epoxy Primer may be applied to concrete and wood substrates and to the surface of fully cured TREMproof 201/60, 250GC, 6100 HRA, 6145 HRA, ExoAir 120, ExoAir 220, ExoAir 230, Vulkem 360NF, and 350NF. It can also be used as a construction coat when a temporary solution is needed to protect the substrate from moisture during construction.

COVERAGE RATE

Approximately 200-300 ft²/gal.

PACKAGING

4-Gallon Kit:

Tremco Epoxy Primer Part A: Two 1-gal cans

Tremco Epoxy Primer Part B: Two 1-gal cans

10-Gallon Kit:

Tremco Epoxy Primer Part A: One 5-gal pail

Tremco Epoxy Primer Part B: One 5-gal pail

AVAILABILITY

Immediately available from your local Tremco Sales Representative, Tremco distributor, or warehouse.

STORAGE

Store indoors, protected from moisture, at temperatures between 50 °F and 90 °F (10 °C and 32 °C) and out of direct sunlight.

PRECAUTIONS/LIMITATIONS

- Do not subject Tremco Epoxy Primer to freezing temperatures before it has fully cured.
- Substrate surface and ambient temperature during applications should be between 50 °F and 90 °F (10 °C and 32 °C).
- Material temperatures should be at least 50 °F (10 °C) and rising.
- Working time and cure time will decrease as temperature increases and will increase as temperature decreases.
- Do not thin Tremco Epoxy Primer.
- Tremco Epoxy Primer will discolor upon prolonged exposure to ultraviolet light and high-intensity artificial lighting.
- Tremco Epoxy Primer is not to be used as a finished/aesthetic coating.
- Do not use Tremco Epoxy Primer for anchoring.
- Do not apply Tremco Epoxy Primer to slabs on grade unless an uninterrupted vapor barrier has been installed under the slab.
- Do not apply Tremco Epoxy Primer if the substrate is subject to excessive moisture vapor drive or hydrostatic pressure.
- In all cases, consult the product Safety Data Sheet before use.

- If coating over old/existing epoxy or urethane coatings, or if more than 24 hours will elapse between coats: then follow the two-coat application method with silica sand and then proceed with the coating operation. If an old/existing coating is loose, flaking, etc., then remove all unsound and loose material prior to the new application of the epoxy primer.
- Substrate must be at least 5 °F (3 °C) above measured dew point temperatures to avoid dew point conditions.

CONDITIONS FOR CONCRETE SURFACES

Concrete shall be water-cured and attain a 2500 psi minimum compressive strength. Moisture content in the concrete must be lower than 4.5% as measured using a Tramex CME 4 Moisture Meter. Depending on concrete construction and job site location, additional concrete testing may be required. Please contact your local Tremco Sales or Technical Representative.

Concrete shall be free of any laitance which can usually be achieved by shotblasting (preferred method) or sandblasting the surface. For proper methods, refer to ICRI's Technical Guide No. 310.2R-2013.

Concrete surface shall be properly cleaned so that the surface to receive the coating, sealant or liquid-applied flashing is free of mold, paint, sealers, coatings, curing agents, loose particles, and other contamination or foreign matter that may interfere with the adhesion.

Shrinkage cracks in the concrete surface that are 1/16" (1.6 mm) wide or greater shall be ground out to a minimum 1/4" wide x 1/2" deep (6 mm x 12 mm) and treated. Refer to Tremco's coating applications instructions.

Structural cracks regardless of width shall be ground out to a minimum 1/4" wide x 1/2" deep (6 mm x 12 mm). Refer to Tremco's coating application instructions.

Spalled areas shall be cleaned free of loose contaminants prior to repair. Because jobsite conditions vary, it is recommended that you contact Tremco Technical Services at 866-209-2404 for the best method of repair.

In the event of exposed reinforcing steel, it is recommended that the structural engineer of record be contacted for investigation and for best repair method.

Surfaces shall be made free of defects that may telegraph and show through the finished coating. Surfaces that are rough (fins, ridges, exposed aggregate, honeycombs, deep broom finish, etc.) shall be leveled and made smooth by applying a coat of sand-filled epoxy. All drains shall be cleaned and operative. Drains shall be recessed lower than the deck surface. The surface shall be sloped to drain to provide positive drainage.

If the project is a restoration deck, old sealant and backing material shall be removed. The joint interface will require a thorough wire brushing, grinding, sandblasting, solvent washing and/or primer.

CONDITIONS FOR WOOD SURFACES

Wood must be exterior grade and must be solid and firm and fastened with ring shank nails/screws to ensure a solid substrate and with no movement in the joints.

MIXING

Condition A & B components at 60 °F (16 °C) to 80 °F (27 °C) for 24 hr prior to mixing. Mix Tremco Epoxy Primer using a low-speed drill and mixing paddle. Pre-mix Part A and Part B separately for approximately 1 minute each. Combine Part A and Part B in a 1 to 1 ratio by volume, then mix thoroughly for 3 to 5 minutes. Scrape the bottom and sides of the containers at least once during mixing. Do not scrape bottom or sides of the container once mixing operations have ceased; doing so may result in unmixed resin or hardener being applied to the substrate. Unmixed resin or hardener will not cure properly. Do not aerate the material during mixing.

To make Tremco Epoxy Primer mortar, gradually add clean, dry 20-40 mesh silica sand to previously mixed Tremco Epoxy Primer and mix thoroughly for 3 to 5 minutes. The mix ratio of aggregate to mixed epoxy is approximately 3 to 1 by volume **but can be modified depending on the desired consistency of the epoxy mortar.**

STANDARD APPLICATION METHOD

Tremco Epoxy Primer is applied by brush or short nap roller. Thickness of the Tremco Epoxy Primer must not exceed 30 mils on vertical surfaces; minimum thickness is generally 10 mils. Full coverage is required. Subsequent epoxy or urethane coatings may be applied as soon as the primer has become tack free, typically within 8 to 16 hr at 75 °F (24 °C), but no later than 24 hr after primer application.

If the 24 hour cure time has been exceeded, please contact Tremco Technical Services.

TWO-COAT APPLICATION METHOD WITH SILICA SAND

Condition Tremco Epoxy Primer per Standard Application Methods above. The first application of Tremco Epoxy Primer must be applied at 8 to 12 mils. Apply the second application no later than 24 hours after the first application. The second application of Tremco Epoxy Primer must be applied at 10 to 12 mils followed immediately by Silica Sand broadcasted to refusal. Allow primer to fully cure. Remove loose Silica Sand with a broom or blower before applying a membrane over the Silica-Sanded Primer.

Note: This product can be used as a Construction Coat to temporarily provide skid resistance and moisture protection to the substrate and during construction. Pressure wash and make sure system is completely dry before application of additional layers. If the Construction Coat is damaged during construction, it will need to be repaired by applying an additional 10-12 mil coat that is broadcasted to refusal with silica sand and allowed to fully cure before application of membrane.

SHALLOW CONCRETE REPAIR METHOD WITH SILICA SAND

Condition Tremco Epoxy Primer per Standard Application Methods above. Apply Tremco Epoxy Primer neat as a primer coat to the prepared concrete surface. Add up to 3 parts Silica Sand per 1 part Tremco Epoxy Primer and continue to mix until thoroughly dispersed. Pour the mixture into the repair area before the neat primer coat becomes tack free and level with a trowel. Base coat material can be applied once the primer has become tack free, typically within 8 to 16 hours at 75 °F (24 °C).

WARRANTY

A repair or replacement warranty is available on all Tremco products. Visit <https://www.tremcosealants.com/warranties/> for details.

TYPICAL PHYSICAL PROPERTIES

PROPERTY @ 75 °F, 50%, RH	TYPICAL VALUE
Mix Ratio (A:B by Volume)	1:1
Mixed Solids	100% by weight
Mixed Viscosity	300 to 400 cps
Gel Time (100 grams)	30-40 min.
Pot Life (2 gal. (7.6 L))	10-20 min.
Storage Temperature Range	50 °F (10 °C) minimum to 90 °F (32 °C) maximum

Please refer to our website at www.tremcosealants.com for the most up-to-date Product Data Sheets.

NOTE: All Tremco Safety Data Sheets (SDS) are in alignment with the Globally Harmonized System of Classification and Labelling of Chemicals (GHS) requirements.

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Tremco Construction Products Group (CPG) brings together the Commercial Sealants & Waterproofing and Roofing & Building Maintenance divisions of Tremco CPG Inc.; Dryvit and Willseal brands; Nudura Inc.; Prebuck LLC; Tremco Barrier Solutions, Inc.; Weatherproofing Technologies, Inc.; Weatherproofing Technologies Canada, Inc.; and Pure Air Control Services, Inc.



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