



Tufcote™ 2.5 PR™ High Solids Alkyd Primer



GENERAL

DESCRIPTION

A phenolic modified medium oil, lead and chromate free, single-package, 2.5 lbs./gal. VOC conforming primer based on Axalta alkyd technology. The resulting primer is designed to be very quick drying and to deliver good corrosion resistance.

SUGGESTED USES

As a primer, direct-to-metal (DTM) or “shopcoat” on carbon steel and wood where:

- Universal primer for use under lacquer or enamel topcoats is needed
- Corrosion protection during transport and construction is required
- Fast dry and handling times will improve productivity
- Indefinite pot life, single component and no thinning reduce cost
- Application by brush, roll, or spray may be required
- Rusted, hand or power-tool cleaned surfaces must be protected

COMPATIBILITY WITH OTHER COATINGS

As a universal primer, most topcoats can be applied over Tufcote 2.5 PR, including alkyds, epoxies, polyurethanes, and acrylics. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your Axalta representative for specific recommendations.

NOT RECOMMENDED FOR

- Immersion service
- Application over galvanized steel
- Application over inorganic zinc

PERFORMANCE PROPERTIES

Chemical	Very Good with appropriate topcoat
Humidity	Excellent
Weather	Excellent

COLOR

681-20704™ Red Oxide
681-21072™ Med. Gray

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



MIXING

COMPONENTS

Tufcote 2.5 PR – 681-XXXXX Base	1 gallon container 100% fill (128 oz.) 5 gallon container 100% fill (640 oz.)
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ACTIVATION

No activation required.



Reduction

No further reduction necessary. Can be thinned up to 5% with Axalta TY-3810™ or TY-3819™. However, thinning greater than 5% will eliminate compliance with VOC limitation of 2.8 lbs/gal. See VOC chart.

APPLICATION THINNERS

Spray TY-3810
 Brush, Roll TY-3819

Normally no reduction should be required. See VOC information for amounts that can be added and still remain compliant at 2.8 lbs/gal VOC.

POT LIFE

Not applicable.



APPLICATION

SURFACE PREPARATION

Commercial Blast SSPC-SP 6 is recommended. If not possible, clean to an SSPC-SP 2 Hand Tool Clean or SSPCSP 3 Power Tool Clean with some sacrifice in performance. Steel surface should be clean, dry and free of any oil or dirt.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 40°F (4°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

ROLL APPLICATION

Manufacturer: Wooster® Pro/Doo-Z ¼" - ½" nap
 • Keep roll wet. Roll in one direction, rewet, then cross roll.

BRUSH APPLICATION

Manufacturer: Wooster China Bristle - 3"-4" brush

SPRAY APPLICATION

Manufacturers listed below are a guide. Others may be used. Changes in tip size or pressure may be required to achieve proper application.

Conventional Spray

	<u>Binks</u>	<u>DeVilbiss</u>	<u>SATA</u>
Spray Gun:	2001	JGA	K3RP
Fluid Nozzle:	63BSS	FF (1.4)	1.1
Pot Pressure:			12
Atomizing Pressure			36
Air Cap:	63PB	765	

HVLP Spray

	<u>Binks</u>	<u>DeVilbiss</u>
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	94 (1.4)	1.4
Air Cap:	94P	2000

Airless Spray

Pump: Graco Extreme 33:1
 Airless Gun: Graco 207945
 Fluid Hose: 3/8" x 50' max.
 Tips: 415-521
 Minimum pressure to avoid fingering: 2700 psi min.

CLEAN UP THINNERS

TY-3819 or mineral spirits



DRY TIMES

Cure Time in Hours at Recommended Thickness @ 50% RH

	77°F (25°C)
To Touch	0.5
To Handle	2
Recoat	1
Hard Dry	12

Dry to recoat is by spray. If by brush or roll, will require 24-72 hours @ 70°F depending on solvency of topcoat.



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (93°C) in continuous service
Volume Solids	51% ± 2%
Weight Solids	71% ± 2%
Theoretical Coverage Per Gallon	818 ft ² (20.0 m ² /L) @ 1 mil DFT 409 ft ² (10.0 m ² /L) @ 2 mils DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Weight Per Gallon	11.4 lbs./gal ± 0.5%
Shipping Weight (approximate)	1 gallon container: 13 base 5 gallon container: 63 base
Suggested Film Thickness:	4 mils (100 µm) wet 2 mils (50 µm) dry

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

Flash Point: (Tag Closed Cup)	20 – 73°F (-7 to 23°C)
Gloss:	Flat
Package Size:	1 & 5 gallon containers Contact Axalta for current package sizes.
Shelf Life:	1 year minimum

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between -30°F (-34°C) and 120°F (48°C).

Tufcote 2.5 PR may settle. Agitate before each use.

VOC REGULATIONS

VOC (Theoretical, varies with color).	
Tufcote 2.5 PR unreduced (all/Ave)	2.5 lbs/gal (300 g/l)
Tufcote 2.5 PR reduced 5% with TY-3819 or TY-3810	2.8 lbs/gal (336 g/l)

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.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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