



Tufcote™ 3.5 PR™ High Solids Alkyd Primer



GENERAL

DESCRIPTION

An acrylic modified medium oil, lead and chromate free, single-package, 3.5 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 may improve productivity
- Indefinite pot life, single component and no thinning is desired
- Rusted, hand or power-tool cleaned surfaces must be protected
- Using a coating manufactured from recycled products to support a commitment to reduce environmental impact

COMPATIBILITY WITH OTHER COATINGS

As a universal primer, most topcoats can be applied over Tufcote 3.5 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
- Application by roller

PERFORMANCE PROPERTIES

Chemical	Good, with appropriate topcoat
Humidity	Good
Weather	Very Good

COLOR

67-934™ Red Oxide

67-939™ Gray

67-940™ Black

Color may vary from batch to batch. If using more than one batch, blend materials to ensure color consistency.

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



MIXING

COMPONENTS

Tufcote 3.5 PR – 67-9XX

5 gallon container 100% fill (640 oz.)

ACTIVATION

No activation required.



Reduction

No further reduction necessary. Any thinning will increase VOC above 3.5 lbs./gal. VOC.

APPLICATION THINNERS

None required.

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.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 40°F (4°C) or above 110°F (43°C). For best results, the temperature should be between 65°F (13°C) and 85°F (29°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 - 2"-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 208663
 Fluid Hose: 3/8" x 50' max.
 Tips: 413-419
 Minimum pressure to avoid fingering: 2400 psi min.

CLEAN UP THINNERS

TY-3810 or xylene



DRY TIMES

Cure Time in Hours at Recommended Thickness @ 50% RH

	77°F (25°C)
To Touch	0.5
To Handle	1
Recoat	0.5
Hard Dry	48



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (93°C) in continuous service
Volume Solids	50.5%
Weight Solids	70%
Theoretical Coverage Per Gallon	810 ft ² (20.5 m ² /L) @ 1 mil DFT 405 ft ² (10.2 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	12.3 lbs./gal (5.6 Kg.)
Shipping Weight (approximate)	5 gallon container: 63 lbs
Suggested Film Thickness:	4 mils (100 µm) wet 2 mils (50 µm) dry

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

Flash Point: (Tag Closed Cup)	83°F (28°C)
Gloss:	Flat
Package Size:	5 gallon container
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 3.5 PR may settle. Agitate before each use.

VOC REGULATIONS

VOC (Theoretical, varies with color).	
67-934 Red Oxide	3.5 lb/gal
67-939 Gray	3.5 lb/gal
67-940 Black	3.5 lb/gal
VOC listing is less exempts without thinning.	

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.



ASTM INFORMATION

Physical properties are for a system of Tufcote 3.5 PR and Imron 3.5 HG. For other system results, contact Axalta Coating Systems.

Paint System	Tufcote 3.5 PR Imron 3.5 HG
Type/Color	urethane red urethane white
DFT	2.8 2.1 mils

Salt Fog (ASTM B117)	1000 hours	no rusting, dense #2 blisters at the scribe
Relative Humidity (ASTM D2247)	1000 hours	no rusting, medium #2 & #4 blisters on the face of the panel – end test
Dry Heat (ASTM D2485)	250°F for 24 hrs	no cracking, no blisters, no loss of adhesion, no discoloration

Electrical Resistance (ASTM D2457):

Adhesion (ASTM D4521 A2):	1467 psi	cohesive failure within the primer
Cleveland Cond (ASTM D4585):	1000 hours	no rusting, medium dense #4 blisters on the face of the panel
UV Con (ASTM D4587)*	3000 hours	Gloss before exposure 87 Gloss after exposure 78.3 Evaluation no rusting, no blisters, no delamination

Impact (ASTM D2794):	20 inch pounds
Mandel Bend (ASTM D522):	% Elongation - 28%
Taber Abrasion (ASTM D4060):	weight loss in grams - 0.08

*8 hr UV @ 50°C, 4 hr condensation @ 40°C, gloss readings @ 60°

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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In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

