



# Tufcote™ CE 184 Epoxy Primer

(Formerly CenturyExtreme™ 184)



## GENERAL

### DESCRIPTION

The Tufcote™ CE 184 is a high solid, HAPs Free (Hazardous Air Pollutant), VOC Compliant, two-component, epoxy primer designed to provide excellent corrosion protection and acid/alkali chemical resistance to properly prepared steel structures. This product is easily applied with standard airless spray application equipment and requires no additional thinner or induction time ("sweat-in").

### SUGGESTED USES

The Tufcote™ CE 184 is intended for use over properly prepared steel substrates in the following areas:

- Railcar Manufacturing and Refurbishment
- Steel Storage tanks
- Heavy Equipment
- Trailer Chassis and Frame
- Marine/OEM/Industrial Maintenance

### RECOMMENDED SYSTEM

1 CT, Tufcote™ CE 184 applied at 5-10 mil DFT  
1 CT, Tufcote™ CE 609 applied at 2-4 mil DFT

### PERFORMANCE PROPERTIES

Chemical	Excellent
Humidity	Excellent
Weather	Excellent
Impact	Excellent

### COLORS AVAILABLE

Salmon/Buff  
Custom Colors Available



## MIXING

### MIXING RATIO

1:1 BY VOLUME  
1 PART BASE / 1 PART ACTIVATOR

### COMPONENTS

Base:  
Salmon/Buff, 184-R300-131

Activator:  
184-V-111

### REDUCTION

No thinning/reduction required for airless application. If thinning is desired, consult your Axalta Industrial Coatings representative for thinning amounts for specific VOC requirements.



#### POT LIFE

Temperature	
104° (40°C)	1 Hr.
77°F (25°C)	2 Hr.
60°F (15°C)	4 Hr.



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### APPLICATION

#### SURFACE PREPARATION

This product should be applied to a steel surface prepared to SSPC-SP 5, 6, 7 or 10 with a 1.5– 3.0 mil (38-76 micron) abrasive blast profile. Poor surface preparation will reduce the overall performance and service life of the coating. For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants.

#### APPLICATION CONDITIONS

Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising. Water condensation on the new film may cause surface imperfections and poor cure. Do not apply when Relative Humidity exceeds 85%. Avoid placing freshly painted components outdoors under wet, rainy conditions. Lower temperatures (< 60°F) will increase dry times. Do not use this product when temperatures fall below 50°F. Substrate temperatures above 120°F may cause the product to sag, curtain, or run.

#### APPLICATION DATA

Coating Thickness:	5-10 Mil DFT
Coverage:	218 Sq. Ft/Gal @ 5 Mil DFT
Full Cure:	10 Days @ 77°F
Re-coat (Min):	6 Hr. @ 77°F
Re-coat (Max):	72Hr. @ 77°F

#### SPRAY APPLICATION

##### Airless Spray

Pressure:	2,000 – 2,800 psi
Tips:	0.017” – 0.021”

##### Conventional Spray

Spray Gun:	Binks 95
Fluid Nozzle:	68
Air Cap:	68P
Atomizing Pressure	50 psi
Fluid Pressure	10-12 psi

#### BRUSH & ROLL APPLICATION

These products may be applied by brush or roller for touch-up. Use nylon or other brushes designed for solvent based paints. Use ¼” rosin core roller covers designed for solvent-based paints. See application Guidelines for detailed instructions.

#### CLEAN UP THINNERS

Flush all paint supply lines immediately after application. Clean equipment Axalta thinners 10-T-101 or 10-T-120. Use soap and water to remove any material from hands or skin.



## DRY SCHEDULE

Cure time at 5 mil DFT

Temperature	Dry Touch	Dry-Handle	Dry-Topcoat
104° (40°C)	1 Hr.	2 Hr.	3 Hr.
77°F (25°C)	3 Hr.	5 Hr.	6 Hr.
60°F (15°C)	7 Hr.	10 Hr.	12 Hr.
50°F (10°C)	11 Hr.	15 Hr.	17 Hr.



## PHYSICAL PROPERTIES

Finish	Satin
Mixed VOC	2.3 lbs./gal
Volume Solids	68% +/- 1%
Weight Solids	81% +/- 1%
Theoretical Coverage Per Gallon	1090 ft <sup>2</sup> @ 1 mil DFT 218 ft <sup>2</sup> @ 5 mils DFT

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

Package Size: 5-gallon pail, 50-gallon drum containers

## RECOMMENDED STORAGE CONDITIONS

Store components between 55°F and 100°F. Store in dry shaded/covered conditions away from sources of heat and ignition.

Shelf-Life, Part A, 24 Months-Unopened, 77°F  
Part B, 24 Months-Unopened, 77°F

## SAFETY AND HANDLING

Please contact your Axalta representative for acceptable alternatives to the thinners listed above. Use soap and water to remove any material from hands or skin. Cleanup solvents or thinners are recommended to be used in accordance with each facilities Environmental, Health and Safety standards, regulations and procedures. Please read and understand the Safety Data Sheet before using this product.