LIFELAST®
Innovation Through Formulation

PRIMALL-160

MIXING INSTRUCTIONS

EFFECTIVE: 9/01/19

PARTS LIST

Primall-160 Resin Container
Primall-160 Curative Container

ADDITIONAL RECOMMENDED MATERIALS

Goggles/Safety glasses
Chemical resistant gloves
Solvent: MEK, Acetone or IPA
Clean white painters rags
Paint mixing stick
Drill
Mechanical paint mixing blade
Brush, roller or spray machine

MIXING INSTRUCTIONS

1. Before applying the primer, ensure that the surface has been prepared according to the *Application Specification Sheet* for the LifeLast polyurethane being used and is free of any rust, dirt, grease or any other types of contaminants. If the surface is not completely clean, solvent wipe as necessary using clean white painters rag. Approved solvents are MEK, Acetone or IPA.

2. Primall-160 is typically supplied in pre-measured kits. Pour the Primall-160 Curative into the Primall-160 Resin bucket. Be sure to scrape all of the Curative out of the bucket. Thoroughly mix the two parts together (drill mixer is recommended) making sure to scrape the sides and bottom of the bucket. ***Note: Primall-160 is a 100% solids product and therefore should not be thinned with solvent.***

   Mix Ratios for Primall-160
   1.61 : 1 by volume (Resin : Curative), i.e. 16.1 ounces of Resin with 10 ounces of Curative
   1.84 : 1 by weight (Resin : Curative), i.e. 184 grams of Resin with 100 grams of Curative

3. Pot life (70°F): 100g mass ≈ 50 min.; 2 mixed gallons ≈ 40 minutes; 4 mixed gallons ≈ 30 minutes. *Note: pot life reduces considerably as ambient and material temperature increases.*

4. Primer application
   a. Hand Application: Do not scrape the sides or bottom of the container or leave the container upside-down in an attempt to remove all of the primer as there will be unmixed material on the sides and bottom. Using a shed resistant roller or a brush, apply the primer to the prepared surface. Apply the primer at a minimum wet film thickness of 4 mils on metallic and fiberglass substrates and 8 mils on concrete and masonry. Be sure to work the primer into all cracks and bugholes. To ensure complete coverage, the primer should be applied using a crosshatch meth-

od. This method is simply applying the material onto the surface in alternating perpendicular patterns. Do not apply primer to any surfaces after the primer has reached string-back (i.e. primer sticks to an object and forms a string as the object is pulled away).

b. Spray Application: Using desired spray equipment, spray apply primer to prepared surface at a film thickness of 4 mils on metallic and fiberglass substrates and 8 mils on concrete and masonry. For concrete and masonry applications, it is required that the primer be back-rolled after spray applying to even the thickness, fill bugholes and mitigate outgassing. Recommended spray equipment includes an airless machine with a 30:1 head, ¼" spray line, and Graco RAC V spray tips of 0.015"-0.025". Spray pressure should be greater than 2000 psi.

5. Allow the primer to cure prior to applying the urethane topcoat. The primer has cured when the surface is slightly tacky to tack free. Clean the surface of the primer prior to the application of the urethane if the primer has been exposed to contaminants. Primall-160 may blush if exposed to cold temperatures and/or high humidity while curing. Blush must be removed prior to application of the LifeLast polyurethane. Primall-160 has a 5-day open time at 70°F.

EXAMPLES OF CURE RATES:

Ambient Temperature	Cure Time
40°F	45 hours
50°F	24 hours
60°F	15 hours
70°F	9 hours
80°F	8 hours