

SHIPBUILDERS AND MARINE

PAINTS AND COATINGS **BC-100/ BC-80**

PRODUCT / PROCEDURE DATA SHEET NO. _____

Date: 04-23-01	Rev. 2
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I.	GENERIC TYPE AND DESCRIPTION: Epoxy Primer Specification Number (If Applicable): MIL-D-24613 Bond Coat		
II.	MANUFACTURERS DATA:		
(a)	MANUFACTURER: ITW American Safety Technologies	(b)	PRODUCT DESIGNATION: BC-100/ BC-80 Bond Coat
(c)	COLOR(S): Clear	(d)	USES: Epoxy Primer
(e)	TECHNICAL SERVICE REPRESENTATIVE: (Include Telephone No.): (800) 631-7841 - Technical Dept.	(f)	NOT RECOMMENDED FOR: Landing Areas
III.	PROPERTIES:		
(a)	% VOL. SOLIDS (ASTM D2697): 86 " 1%	(b)	FLASH POINT (ASTM D93): 108F (42C) OR (ASTM D56): 108F (42C)
(c)	WT. PER GAL. (FTMS 141 _a 4184.1): 8.7 " .2 lbs.	(d)	SHELF LIFE: 1 Year
(e)	VISCOSITY (FTMS 141 _a 4281): less than 1000 cps @ 75F	(f)	PACKAGING: 62 gal. pails
(g)	NUMBER OF COMPONENTS: 2	(h)	GLOSS (ASTM D523): N/A
(i)	STORAGE REQUIREMENTS: 24 hrs. prior to mixing (Colder temperatures will extend cure time)	TEMP.	MIN. <u>40F</u> MAX. <u>100F</u> (Long Term) TEMP. 60F 80F
SPECIAL SAFETY PRECAUTIONS:			
PRECAUTIONS TO BE TAKEN IN HANDLING AND STORING: WARNING! IRRITANT. Do not get in eyes. Avoid contact with skin and clothing. Avoid inhalation vapor or mist. Use with adequate ventilation. Wash thoroughly after handling, and before eating, drinking or smoking. Remove contaminated clothing and wash before use.			
OTHER PRECAUTIONS: Avoid extreme heat - keep away from flame.			
IV.	SURFACE PREPARATION MINIMUM REQUIREMENTS (USE SPECIFIC STANDARD NUMBER(S)):		
(a)	INITIAL - Remove grease, oil, and dirt (SSPC-SP1), followed by sanding or grit blasting.		
(b)	For Use on Decking requiring a primer prior to application of Epoxy Underlayment or Membrane Decking.		

FIG 1A Data Sheet (Front)

V.

MIXING PROCEDURE:

- (a) MIXING RATIO BY WEIGHT - 1.4 : 1 (Base to hardener)
 BY VOLUME - 1.6 : 1 (Base to Hardener)
- (b) INDUCTION TIME - None
- (c) RECOMMENDED SOLVENT - THINNING - Not Authorized
 CONFINED AREAS - N/A
 NON CONFINED AREAS - N/A
- CLEAN UP - 1) Propylene Glycol Ether
 2) Aromatic Naphtha
 3) N-Methyl Amyl Ketone (MAK)
- (d) THINNING REQUIREMENTS (RATIO) - Not Applicable
- (e) POT LIFE -
- | | |
|-----------------|----------------------------|
| <u>20</u> Mins@ | <u>90</u> F (<u>32</u> C) |
| <u>40</u> Mins@ | <u>70</u> F (<u>21</u> C) |
| <u>60</u> Mins@ | <u>50</u> F (<u>10</u> C) |
- (f) SPECIAL INSTRUCTIONS - Pre-mix Part A, base component, to ensure all materials which may have settled during storage are lifted from the bottom. Mix Part A and Part B components with a mechanical/power mixer for a minimum of 3 to 5 minutes or until the mixed material assumes a uniform color and appearance. Scrape the bottom and sides of the pail and mix again for 3 to 5 minutes.

VI. APPLICATION:

- (a) ENVIRONMENTAL LIMITATIONS:
- | | | | |
|---------------------|-----------------|------|--------------------------|
| TEMP. MIN. | <u>40</u> F | MAX. | <u>100</u> F (Long Term) |
| % RELATIVE HUMIDITY | MIN. <u>0</u> % | MAX. | <u>85</u> %F |
- (b) FILM THICKNESS (SSPC PA2-73T)
- | | | | |
|----------|---------------|----------|----------------|
| WET MIN. | <u>6</u> mils | WET MAX. | <u>12</u> mils |
| DRY MIN. | <u>5</u> mils | DRY MAX. | <u>10</u> mils |
- (c) DRY TIMES (ASTM D1650) - RECOAT
- | | |
|------|----------------------------------------------------------------|
| MIN. | <u>0.3</u> Hrs @ <u>90</u> F (<u>32</u> C) @ <u>50</u> % R.H. |
| MIN. | <u>0.5</u> Hrs @ <u>70</u> F (<u>21</u> C) @ <u>50</u> % R.H. |
| MIN. | <u>1.0</u> Hrs @ <u>50</u> F (<u>10</u> C) @ <u>50</u> % R.H. |
| MAX. | ___ Hrs @ ___°F (___°C) |
- TO HANDLE
- | | |
|------|---------------------------------------------------------------|
| MIN. | <u>3</u> Hrs @ <u>90</u> F (<u>32</u> C) @ <u>50</u> % R.H. |
| MIN. | <u>6</u> Hrs @ <u>70</u> F (<u>21</u> C) @ <u>50</u> % R.H. |
| MIN. | <u>12</u> Hrs @ <u>50</u> F (<u>10</u> C) @ <u>50</u> % R.H. |
- FOR IMMERSION
- | | |
|------|--------------------------------------------|
| MIN. | <u>6</u> Hrs @ <u>90</u> F (<u>32</u> C) |
| MIN. | <u>12</u> Hrs @ <u>70</u> F (<u>21</u> C) |
| MIN. | <u>24</u> Hrs @ <u>50</u> F (<u>10</u> C) |
| MAX. | ___ Hrs @ ___°F (___°C) |
- (d) EQUIPMENT REQUIREMENTS (INCLUDE PREFERRED, SUITABLE AND NOT SUITABLE REQUIREMENTS).
 Roller with extended handle. Adequate power or mechanical mixer.
- (e) SPECIAL INSTRUCTIONS - DO NOT APPLY material when deck temperature is UNDER 50F or over 120F.
 At time of application MATERIAL TEMPERATURE must be GREATER than 60F and LESS than 80F.

CAUTION SHOULD BE TAKEN THAT SURFACE TEMPERATURE IS AT LEAST 5 degrees F ABOVE DEW POINT.
 DO NOT APPLY Intermediate Membrane or Non-Skid Coating until surface is dry to the touch.