

**DESCRIPTION:**

Nukote Metal Prime I is a two component, high solids, liquid applied, epoxy-polyamine adhesion promoting primer suitable for concrete and steel.

**FEATURES:**

- Low Odor
- High Solids, Low Solvent
- Excellent Adhesion
- Low Viscosity
- For SCAQMD Areas
- Seals concrete

**TYPICAL USES:**

- Metal
- Concrete
- Polyurethane inter-coat primer
- Plywood

**COLORS:**

Part-A: Black, Part-B: White

**PACKAGING:**

2-gallon (7.6-liter) kit: One 1-gallon (3.8-liter) can of Side-A and one 1-gallon (3.8-liter) can of Side-B.

10-gallon (38-liter) kit: One 5-gallon (19-liter) pail of Side-A and one 5-gallon (19-liter) pail of Side-B.

**COVERAGE:**

Nukote Metal Prime I may be applied at  $4.5 \pm 1$  mils ( $102 \pm 25$ ).

Calculation for theoretical coverage: 300 ft<sup>2</sup>/gal @ 4.5 mil (7.14 m<sup>2</sup>/liter @ 102 microns).

**STORAGE:**

Twelve months in factory delivered, unopened drums. Store on pallets and keep away from extreme heat, freezing, and moisture. The use of drum heaters is encouraged to reduce material viscosity at low temperatures.

<b>TECHNICAL DATA (All values @ 77 °F / 25 °C)</b>	<b>US</b>	<b>Metric</b>
Solids by volume (ASTM D2697)	84 ± 2 %	84 ± 2 %
Volatile organic compounds (ASTM D2369)	0.83 lb./gal	100 gm/ lit
Theoretical coverage	300 ft <sup>2</sup> /gal @ 4.5 mil	7.4m <sup>2</sup> /lit @102 microns

Specific Gravity of materials (ASTM D792)	A: 10.85, B: 15.8 lbs./gal	A: 1.3, B: 1.89 kg/ liter
Viscosity at 77° F/25° C in cps ±10% (ASTM D4878)	1200 ± 200	1200 ± 200
<b>PROCESSING PROPERTIES (Under standard lab conditions)</b>		
Mix Ratio V/V	1:1	
Pot life @ 75° F / 24° C & 50% RH	60 to 90 minutes	
Tack free time ( DFT & Temperature dependent)	4 to 6 hours	
Recoat time	12 to 24 hours	
<i>Properties and values are highly dependent on equipment, spray gun, mix chamber temperature, pressure and related parameters. Variations are possible and expected.</i>		

**MIXING:**

The volume mixing ratio is 1 part Side-A Black Liquid to 1 part Side-B White Liquid. Nukote Metal Prime I Side-A and Side-B should be thoroughly mixed individually prior to combining to ensure a homogeneous material. The combined components should be thoroughly mixed using mechanical mixer at slow speed or for at least 5 minutes if mixed by hand.

**SURFACE PREPARATION:**

**Metal:**

All surfaces should be clean and free from contamination. The surface should be assessed and treated in accordance with ISO 8504, Abrasive blast the surface to minimum NACE-2/SSPC SP-10/Sa 2.5, as per ISO 8501-1, for a visual assessment of surface cleanliness with an anchor profile of 3 to 4 mils (75 -100 microns). Soluble salts must be removed to an acceptable levels. *Refer to NCSI surface preparation manual for detailed procedures for different types of substrates.*

**Concrete:**

The surface of a concrete subfloor should be dry, smooth, structurally sound and free of depression, scale, or foreign deposits of any kind. Remove all curing compounds. Abrasive blast, sweep blast or water blast to remove all latent material and expose voids. Use a good quality epoxy filler or mortar for void and spall filling, skim coat or repairs. Prime, fill imperfections in the substrate surface to limit out-gassing. All concrete substrates, on or below grade level should be tested for moisture content. On-grade or below-grade concrete floors or slabs should have a moisture barrier installed to protect from ground moisture. The surface preparation of concrete should meet and conform to Joint NACE 6/SSPC-SP 13 standards and achieve a concrete surface profile of CSP 3 to CSP 6 as per ICRI Guideline No.03732 for optimum performance.

**APPLICATION:**

Nukote Metal Prime I should be applied at the rate of 1 gallon (mixture of Part-A & Part-B) /300 sq. ft. (0.14 liters/m<sup>2</sup>). Coverage rate will depend on surface roughness and porosity. It can be applied using an airless sprayer, brush, or Phenolic resin core roller. Allow Nukote Metal Prime I to become tack free before applying the coating.

Recommended surface temperature should be greater than 50° F (10° C) and at least 5° F (3° C) above the dew point. Nukote Metal Prime I is very sensitive to heat and moisture. Higher temperatures and/or high humidity will significantly accelerate the cure time and pot life. Use caution in batch sizes and thickness of application. Low temperature and/or low humidity extend the cure time.

---

**EQUIPMENT CLEAN UP:**

---

Equipment should be cleaned with an environmentally safe solvent, as permitted under local regulations, immediately after use.

---

**LIMITATIONS:**

---

Not UV stable. Mix no more material than can be used within 45 minutes.  
Nukote Metal Prime I should be coated within 8-12 hours after it has become tack free.  
Containers that have been opened must be used as soon as possible.  
Nukote Metal Prime I is difficult to clean up after it has cured.  
Surfaces must be dry, clean and free of foreign matter.

---

**WARNING:**

---

This product contains Epoxy and curatives.

---

**WARRANTIES AND DISCLAIMERS:**

---

*Nukote Coating Systems International, a Nevada, USA Corporation warrants that the two components of this product shall conform to the technical specifications published in the product literature. The quality and fitness of the product is dependent upon the proper mixture and application of the components by the applicator. Nukote Coating Systems has no role in the application of the finished polymer other than to manufacture and supply its two components. It is vital that the person applying this product understands the product and is fully trained and certified in the use of plural component equipment and application of plural component materials. There are no warranties that extend beyond the description on the face of this instrument, except when provided in writing, directly by Nukote Coating Systems International and executed under seal by a company officer.*