



PRODUCT DATA SHEET

54RF230 Epoxy Polyamide Primer

PRODUCT DESCRIPTION:

Drew 54 Series Epoxy is a high performance epoxy primer that is designed to be applied to blasted steel substrates. Drew 54 Series has good chemical resistance for splash/spill exposure.

INTENDED USES:

Recommended as a protective coating for new construction industrial and marine facilities, or as a field maintenance primer over bare metal surfaces. Drew 54 Series may be overcoated with epoxy or urethane top coats.

PHYSICAL PROPERTIES:

Vehicle Type:	Epoxy Resin
Color:	Red Oxide
Finish:	Flat
Solids	
By Volume:	57% Avg. (+/-2%)
By Weight:	76.7% Avg.
Viscosity:	75-90 Krebs Unit
V.O.C.	3.34 lbs. per gal / 401 grams per litre Catalyzed
Pot Life	6 hours @ 70°F
Recommended Dry Film Thickness:	2-3 mils
Theoretical Coverage:	305-457 sq.ft. per gal.

DRY TIME:

Substrate Temp.	Tack Free	Dry to Recoat Minimum	Dry to Recoat Maximum
50°F	2 Hours	16 Hours	(*) 7 days
77°F	35 minutes	6 Hours	(*) 7 days
95°	20 minutes	4 Hours	(*) 7 days

(*) See dry times on back of data sheet for more information.

NOTE: Drew 54 Series like most epoxies will yellow, fade and chalk when exposed to sunlight and certain types of interior lighting. This is a natural occurrence and does not affect the performance of the coating.

DRY TIMES:

Normally there is no overcoating limit provided that the surface is free from chalking and other contaminants prior to application. To insure the best intercoat adhesion it is recommended that you apply the subsequent coat before the preceding coat has fully cured.

SURFACE PREPARATION:

Surfaces that are to be coated must be clean, dry and free of surface contaminants. For best performance steel should be blast cleaned to an SSPC-SP6 Commercial Blast Cleaning.

MIXING:

Drew 54 Series is supplied in a 2 component product, 4:1 mix ratio, stir separate components thoroughly before mixing together. Combine base and catalyst, using a powered drill mixer mix activated material for 2-3 minutes. Do not activate more material than you can use within the stated pot life.

THINNING: Do not exceed regulatory limits

Brush/Roll – Not normally required, recommended no more than 10% reduction with 8017 Epoxy Reducer.
Airless Spray – If required 5-10% of 8017 Epoxy Reducer (½ pint per gallon)
Conventional – Reduce up to 20% or as needed with 8017 Epoxy Reducer.

APPLICATION:

Airless – recommended tip sizes (.017-.021)
Air Assisted Airless – Kremlin Model 17:35 or larger, MX Gun
Conventional – Binks Model 2001 or equivalent
HVLV – Binks Model Mach 1
Brush/Roll – Thinning may be necessary

Top Coat:

Drew 54 Series may be top coated with epoxy, or urethane.

CLEANING UP:

Xylene, MEK

ORDERING:

These products are available in 1 and 5 gallons kits.

COMPLIANCE: Federal Regulations

RULE	CATEGORY	MAXIMUM LEVELS	COMPLIANT
NESHAP	General	340 g/l	Yes
Automobile Refinishing	Primers	580 g/l	Yes
AIM	Industrial Maintenance or Metallic Pigmented	450 g/l 500g/l	Yes

SAFETY:

Products are intended for industrial use only; improper handling and misuse may be hazardous. Please refer to the Material Safety Data Sheets for more detail safety information.

COMPLIANCE:

This product meets the VOC requirements for NESHAP and AIM regulations. Solvent reduction should not exceed those allowed per VOC regulations.

NOTE:

This information is based on technical data that we believe to be accurate and reliable and is intended to be used by persons having the knowledge and skill to apply these coating properly. We assume no responsibility for results or damages incurred from their use by the Buyer in whole or in part.

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