



TUFCOTE[®] 3.5 PR[®]

FAST DRY ALKYD PRIMER

(formerly DuPont 67 FD™)

Tufcote[®] 3.5 PR™ is an acrylic modified medium oil, lead and chromate free, single-package, VOC conforming primer (3.5 lbs./gal.) based on DuPont alkyd technology. The resulting very quick drying primer delivers good corrosion resistance.

SUGGESTED USES:

As a primer, direct-to-metal (DTM) or “shopcoat” on carbon steel and wood where:

- Universal primer for use under lacquer or enamel topcoats is needed.
- Corrosion protection during transport and construction is required.
- Fast dry and handling times will improve productivity.
- Indefinite pot life, single component and no thinning reduce cost.
- Rusted, hand or power-tool cleaned surfaces must be protected.
- Using a coating manufactured from recycled products to reduce environmental impact is desirable.

NOT RECOMMENDED FOR:

- Immersion service
- Application over galvanized steel
- Application over inorganic zinc
- Application by roller

COMPATIBILITY WITH OTHER COATINGS:

As a universal primer, most topcoats can be applied over Tufcote[®] 3.5 PR™, including alkyds, epoxies, polyurethanes, and acrylics. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact your DuPont Performance Coatings Representative for specific recommendations.

MAXIMUM SERVICE TEMPERATURE:

200°F (93°C) in continuous service

PERFORMANCE PROPERTIES:

Chemical	Good, with appropriate topcoat
Humidity	Good
Weather	Very Good

VOLATILE ORGANIC CONTENT (VOC) THEORETICAL:

DuPont 67-934™ Red Oxide	3.5 lb/gal
DuPont 67-939™ Gray	3.5 lb/gal
DuPont 67-940™ Black	3.5 lb/gal

VOC listing is less exempts without thinning.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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COLOR:

DuPont 67-934™ Red Oxide
DuPont 67-939™ Gray
DuPont 67-940™ Black

GLOSS:

Flat

CURE TIME – HOURS @ 50% R.H. @ SUGGESTED DFT

77°F (25°C)

To Touch	½
To Handle	1
To Recoat	½
Full Cure	48

THEORETICAL COVERAGE PER GALLON:

810 ft.² (20.5 m²/L) @ 1 mil DFT

405 ft.² (10.2 m²/L) @ 2 mils suggested DFT

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

SUGGESTED FILM BUILD:

4 mils (100 µm) wet
2 mils (50 µm) dry

VOLUME SOLIDS (MIXED) AVERAGE:

50.5%

WEIGHT SOLIDS (MIXED) AVERAGE:

70.0%

WEIGHT PER GALLON (MIXED) AVERAGE:

12.3 Lb. 5.6 Kg.

FLASH POINT (TAG CLOSED CUP):

83°F (28°C)

PACKAGING:

5 gallon containers

SHIPPING WEIGHT (LBS.) APPROXIMATE:

5 gallon container: 63

SHELF LIFE & STORAGE CONDITIONS:

Store in a dry, well-ventilated area. Storage conditions should be between –30°F (-34°C) and 120°F (-48°C).

- Shelf Life: 1 year minimum.
- Tufcote[®] 3.5 PR™ may settle. Agitate before each use.

SAFETY:

Consult the Material Safety Data Sheet for this product prior to use.



Tufcote⁰ 3.5 PR⁰
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APPLICATION INSTRUCTIONS

SURFACE PREPARATION:

Commercial Blast SSPC-SP 6 is recommended. If not possible, clean to an SSPC-SP 2 Hand Tool Clean or SSPC-SP 3 Power Tool Clean with some sacrifice in performance.

ACTIVATION:

Not applicable

POT LIFE:

Indefinite

REDUCTION:

No further reduction necessary. Any thinning will eliminate compliance with 3.5 lbs./gal. VOC.

APPLICATION THINNERS:

None required.

CLEAN UP THINNERS:

DuPont TY-3810™ or xylene

APPLICATION CONDITIONS:

Do not apply if material, substrate or ambient temperature is below 40°F (3°C) or above 110°F (43°C). For best results, the temperature should be between 65°F (13°C) and 85°F (29°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT

- Apply by brush, roll, or spray.
- Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

BRUSH:

- ¼" - ½" nap Wooster Pro/Doo-Z roller cover. Keep roll wet. Roll in one direction, rewet, then cross roll.
- 2"-4" Wooster China Bristle Brush

CONVENTIONAL SPRAY:

	<u>Binks</u>	<u>DeVilbiss</u>	<u>Sata</u>
Spray Gun:	2001	JGA	K3RP
Fluid Nozzle:	63BSS	FF (1.4)	1.1
Pot Pressure:			12
Atomizing Pressure			36
Air Cap:	63PB	765	

HVLP SPRAY:

	<u>Binks</u>	<u>DeVilbiss</u>
Spray Gun:	Mach 1	GTi
Fluid Nozzle:	94 (1.4)	1.4
Air Cap:	94P	2000

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AIRLESS SPRAY:

Pump:	Graco Extreme 33:1
Airless Gun:	Graco 208663
Fluid Hose:	3/8" x 100' max.
Tips:	413-419
Minimum pressure to avoid fingering:	2400 psi min.

ADDITIONAL COMMENTS:

1. VOC 3.5 average across colors.
2. Color may vary from batch to batch. If using more than one batch, blend materials to ensure color consistency.



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ASTM INFORMATION

Physical properties are for a system of Tufcote[®] 3.5 PR[™] and Imron[®] 3.5 HG[™]. For other system results, contact DuPont Technical Service.

◆ Paint System	Tufcote [®] 3.5 PR [™] /Imron [®] 3.5 HG [™] (67-934 [™] /333M [™])	
◆ Type/Color	alkyd red/urethane white	
◆ DFT	2.8/2.1	
◆ Salt Fog (ASTM B117)	1000 hours	no rusting, dense #2 blisters at the scribe
◆ Relative Humidity (ASTM D2247)	1000 hours	no rusting, medium #2 & #4 blisters on the face of the panel – end test
◆ Dry Heat (ASTM D2485)	250°F for 24 hours	no cracking, no blisters, no loss of adhesion, no discoloration
◆ Electrical Resistance (ASTM D2457):	2.4X10 ¹⁶	
◆ Adhesion (ASTM D4521 A2):	1467 psi	cohesive failure within the primer
◆ Cleveland Cond (ASTM D4585):	1000 hours	no rusting, medium dense #4 blisters on the face of the panel
◆ UV Con (ASTM D4587)*	3000 hours	Gloss before exposure 87
		Gloss after exposure 78.3
	Evaluation	no rusting, no blisters, no delamination
◆ Impact (ASTM D2794):	20 inch pounds	
◆ Mandrel Bend (ASTM D522):	% Elongation - 28%	
◆ Taber Abrasion (ASTM D4060):	weight loss in grams - 0.08	

*8 hr UV @ 50°C, 4 hr condensation @ 40°C, gloss readings @ 60°

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