

PRODUCT DESCRIPTION

Blome Primer 71 is a two-component urethane-based primer system developed to enhance secondary bonding performance. Blome Primer 71 significantly improves inter-laminar bond strength. Primer 71 utilizes a moisture activated curing system and contains no methylene chloride. Blome Primer 71 has versatile bonding characteristics and excellent tack retention.

BENEFITS

Virtually unaffected by temperature fluctuations, high humidity or moisture containing substrates

Effective with vinyl ester, polyester, FRP, steel, concrete and other substrates

Improves bonding up to 24 hours after application

TYPICAL LIQUID PROPERTIES
@ 77°F

PRIMER 71 PART A

Flash Point, °F: 425

Specific Gravity: 1.23

Viscosity, cps: 180

Vapor Pressure, mm Hg: $<1 \times 10^{-4}$

Isocyanate Equivalent Weight: 133

NCO Content, %: 31.5

Acidity, % as HCl: 0.02

PRIMER 71 PART B

Flash Point, °F: 81

Shelf Life (minimum), months: 6

Specific Gravity: 1.02

Viscosity, cps: 350

Color: Pale Yellow

Mixed, Ready to Apply VOC < 20 g/L

APPLICATION GUIDELINES

1. Prepare thermoplastic surface to be bonded by lightly sanding, then cleaning with styrene monomer. Chemically degraded sections should be ground down to structurally sound laminate.
2. Steel should be sandblasted to white metal and primed promptly to avoid formation of flash rust. Non-copper blast media must be used to avoid inhibition of Primer 71 curing. Smooth, troweled concrete surfaces should also be sandblasted.
3. Primer 71 components must be mixed before using. Blend 1 part (by weight) Part A with 4 parts (by weight) Part B. The pot life of blended Primer 71 is approximately 60 – 90 minutes at 80°F and 50% relative humidity.
4. Blome Primer 71 may be thixed for use on vertical surfaces or to improve adhesion to very porous substrates. Blend 3% hydrophilic fumed silica (Cabosil TS-720) into Primer 71 Part B (up to 1 part by volume), followed by 0.2% Tween 20 or Tween 80 (Croda).
5. One gallon of blended material covers approximately 250 square feet on steel substrates, and approximately 150 square feet on concrete or brick substrates.
6. Apply the Primer 71 mixture using brush, roller or spray for larger surfaces. Allow primer to cure for a minimum of 2 hours at ambient temperatures. Complete curing is evident when the primer surface cannot be indented by a fingernail. The cure is moisture-initiated, so cure time will vary with temperature and humidity conditions. If primer is left more than 24 hours, reapplication will be necessary to obtain full interlaminar bond strength.
7. Apply appropriate resin over the cured, primed surface, and then complete application according to accepted industry practice.
8. To ensure maximum performance of the Primer 71 Bonding System, conduct small scale tests to determine the most suitable conditions. Specific substrates should also be evaluated before large scale operations are conducted.
9. Protect components from exposure to moisture; reseal opened containers and keep tightly sealed after use.

CAUTION

Mix and use with extreme caution. Blome Primer 71 may cause skin irritation with prolonged or repeated contact. Avoid skin contact and follow the material safety data sheet, which is available for each product.

WARRANTY

We warrant that our goods will conform to the description contained in the order and that we have good title to all goods sold. Our material data sheets and other literature are to be considered accurate and reliable but are used as guides only. WE GIVE NO WARRANTY OR GUARANTEE, WHETHER OF MERCHANT ABILITY OR FITNESS OF PURPOSE OR OTHERWISE, AND WE ASSUME NO LIABILITY IN CONNECTION THEREWITH. We are happy to give suggestions for applications; however, the user assumes all risks and liabilities in connection therewith regardless of any suggestion, we may give. We assume no liability for consequential or incidental damages. Our liability, in law and equity, shall be expressly limited to the replacement of non-conforming goods at our factory, or at our sole option, to repayment of the purchase price of the non-conforming goods.

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