

Part A-Primer 251 Iso-Part# 50504
Part B-Primer 251 Resin-Part# 50514

DESCRIPTION

Primer 251 is a two-component, 100% solids (no solvents), zero VOC's, flexible, elastomeric polyurethane primer and sealant. It has high resistance to acids, hydrolysis and salt spray and withstands mechanical stresses where the liner is subject to impact. Primer 251 is used on a variety of properly prepared surfaces.

FEATURES & BENEFITS

- Excellent adhesion to a variety of substrates* with proper surface preparation
- Good flexibility-withstands mechanical stresses where the lining is subject to impact
- 100% solids, zero VOC's, no solvents
- Extended recoat window

251 PRIMER ADHESION RESULTS* (PSI) AST D-4541-17

	STEEL	STAINLESS STEEL	ALUMINUM
24 Hours	1,174	909	1,119
48 Hours	898	835	986
72 Hours	877	888	884

Primer applied 24 / 48 / 72 hours before coating. Plates sandblasted, solvent wiped and primed. Solvent wiped again before coating

CHEMICAL PROPERTIES	ISOCYANATE	RESIN
Solids by Volume/Weight	100%	100%
Volatile Organic Compounds (VOC)	0 lbs./gal.	0 lbs./gal.
Mix Ratio, Parts per Weight (grams)	10	25=35 grams mix total
	30	75=105 grams mix total
	100	250=350 grams mix total
Cure Time, Minutes	120-240 Minutes @ 60°F (16°C)	
	45-90 Minutes @ 90°F (32°C)	
Viscosity	120 cps	12,000 cps
Flash Point	424°F	302°F
Cure times can vary depending on ambient conditions, (humidity, temperature etc.)		
Shelf Life-Unopened Containers	12 Months	6 Months
Base Color	Brown	Gray

NOT RECOMMENDED FOR

Highly porous substrates. Substrates/surfaces containing moisture

SUBSTRATES

Metals, concrete, fiberglass, polyurethane, most plastics and dry wood.

(continued)

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Primer 251 *(continued)*

SURFACE PREPARATION

All surfaces must be free of all dirt, grease, rust, or unsound material that would interfere with maximum adhesion. If unsure of the proper surface preparation, you can contact Rhino Linings Technical Department for assistance.

MIXING PROCEDURES

Primer 251 is a 2.5 to 1 mix. The resin side container needs to be shaken or stirred thoroughly before mixing the ISO and Resin together and then mix the two components thoroughly.

APPLICATION

Primer 251 can be rolled, brushed, or sprayed with a HVLP gun with a large tip 2.0 or larger. The recommended thickness is 3-5 mils. Primer 251 must be completely dry before applying product over it.

Primer 251 can go up to 72 hours before the primer would have to be lightly abraded and another coat of Primer 251 applied. Then completely dried before applying product over it. Ideal surface temperature is no lower than 50°F.

POT LIFE

45 minutes after mixed

SAFETY

Always use proper safety gear, safety glasses, gloves, mask, spray suit. Apply Primer 251 in a well ventilated area.

COVERAGE

Primer 251 will cover approximately 200-250 square feet at 3-5 mils.

STORAGE

Make sure to close containers after using and store in a cool place

SAFETY PRECAUTIONS

Health Considerations: Consult the Rhino Linings® Safety Data Sheets (SDS)

This chemical system requires the use of proper safety equipment and procedures. Please follow the Rhino Linings® product SDS and Safety Manual for detailed information and handling guidelines.

For Your Protection: The information and recommendations in this publication are, to the best of our knowledge, reliable. Suggestions made concerning the products and their uses, applications, storage and handling are only the opinion of Rhino Linings Corporation. Users should conduct their own tests to determine the suitability of these products for their own particular purposes and of the storage and handling methods herein suggested. The toxicity and risk characteristics of products made by Rhino Linings Corporation will necessarily differ from the toxicity and risk characteristics developed when such products are used with other materials during a manufacturing process. The resulting risk characteristics should be and made known to ultimate end-users and processors.

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