

I. GENERIC TYPE AND DESCRIPTION: **BIO-DEK™ Bond Coat**

Date: 08/24/2020

Specification Number: MIL-PRF-32584

NOTE: For Type/Grade/Class/Application information see QPD-Type V, Class 1&2, Grade A, Composition E

II. MANUFACTURERS DATA:

(a) MANUFACTURER: BIO-DEK LLC, 2827 Andrew Ave., Pascagoula, MS 39567

(b) PRODUCT DESIGNATION: **BIO-DEK™ Bond Coat**

(c) COLOR(S): translucent red

(d) USES: **bond coat for Bio-Dek "BUTTERR"™: Ultra Lightweight Underlayment and Tenacious One Step Epoxy Flooring**

(e) TECHNICAL SERVICE REPRESENTATIVE: Murray DuBourdieu 714 975-0898

III. PROPERTIES:

(a) PERCENT VOLUME SOLIDS (ASTM D2697): 100 %

(b) PERCENT WEIGHT SOLIDS (ASTM D2369): 100 %

(c) FLASH POINT ([Click here to enter text](#)):

Part A (Resin): >302 °F (>150 °C)

Part B (Hardener): >302 °F (150 °C)

(d) WEIGHT PER VOLUME (ASTM D1475):

Part A (Resin) 9.48 lb/gal (1006 g/L)

Part B (Hardener) 8.52 lb/gal (1098 g/L)

(e) PERCENT EDGE RETENTION, IF REQUIRED BY APPLICABLE SPECIFICATION (N/A): [Click here to enter text](#) %

(f) SHELF LIFE: 24 Months

(g) VISCOSITY ([Click here to enter text](#)):

Part A (Resin) : 2000 cp @ 70 °C (21 °F)

Part B (Hardener) : 2000 cp @ 70 °C (21 °F)

(h) PACKAGING: resin in gallon can, hardener in quart can, 2 full kits provided in a box

(i) NUMBER OF COMPONENTS: 2

(j) GLOSS (ASTM D523): 60-80 @ 60degrees GU

(k) STORAGE REQUIREMENTS: TEMPERATURE: 50 °F (10 °C) MIN. 90 °F (32 °C) MAX.

ADDITIONAL PAINT STORAGE REQUIREMENTS: do not open prior to use

(l) VOLATILE ORGANIC COMPOUNDS (VOCS- EPA TEST METHOD 24): <.04 lb/gal (<5 g/L)

(m) WEIGHT PER AREA OF DRY FILM AT 1 MIL THICKNESS: .0057 lb/sq. ft. (27.84 g/m²)

<p>(n) SPECIAL PROPERTIES: Click here to enter text</p>
<p>IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:</p> <p>(a) INITIAL CLEANLINESS: clean, dry and free of loose particulate.</p> <p>(b) TOUCH-UP CLEANLINESS: same as initial</p> <p>(c) PROFILE (1): 1 mils MIN. 3 mils MAX.</p> <p>(d) SPECIAL INSTRUCTIONS: temperature will effect the working time and dry to full cure</p> <p>(e) PRIMER REQUIREMENTS: not required, but can be used over tightly adhearing primer with 1-3 mil profile</p> <p>(f) MAXIMUM ALLOWABLE CONDUCTIVITY (Click here to enter text):</p> <p style="padding-left: 40px;">Refer to NAVSEA Standard item 009-32</p> <p>(g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: Surface shall be cleaned to a matte finish with at least 95% of the surface area free of all previously existing visible residues and the remaining 5% containing only randomly dispersed stains of rust, coatings, and foreign matter</p>
<p style="text-align: center;">SPECIAL SAFETY PRECAUTIONS: refer to MSDS</p>
<p>V. MIXING PROCEDURES</p> <p>(a) MIXING RATIOS BY WEIGHT: 1.8:1 resin:hardner BY VOLUME: 1.6:1 resin:hardner</p> <p>(b) INDUCTION TIME: N/A Minutes</p> <p>(c) RECOMMENDED CLEANING SOLVENT (NO THINNING ALLOWED): alcohol, acetone, xylene</p> <p>(d) POT LIFE: Click here to enter text</p> <p>3.5 Hours @ 70 °F (21 °C)</p> <p style="padding-left: 40px;">Graphs included on page: 4</p> <p>(e) SPECIAL INSTRUCTIONS: Click here to enter text</p>
<p>VI. APPLICATION:</p> <p>(a) ENVIRONMENTAL LIMITATIONS:</p> <p style="padding-left: 40px;">SUBSTRATE TEMPERATURE: 50°F (10°C) MIN. 90°F (32°C) MAX. AMBIENT TEMPERATURE: 50°F (10°C) MIN. 90°F (32°C) MAX. DIFFERENCE ABOVE THE DEW POINT: 5 °F (3 °C) MAXIMUM PERCENT RELATIVE HUMIDITY: 90 %</p> <p>(b) FILM THICKNESS (SSPC PA2-73T): PER COAT:</p> <p style="padding-left: 40px;">4 mils WET MIN. 50 mils WET MAX.</p>

4 mils DRY MIN. 50 mils DRY MAX.
 TOTAL SYSTEM:
 4 mils DRY MIN. N/A mils DRY MAX.

(c) DRY TIMES (ASTM D1640):

Minimum Overcoat Window:

n/a [Click to select time Interval @ 85 °F \(29°C\)](#)
 n/a [Click to select time Interval @ 75 °F \(24°C\)](#)
 n/a [Click to select time Interval @ 65 °F \(18°C\)](#)

Maximum Overcoat Window:

24 Hours @ 85 °F (29°C)
 36 Hours @ 75 °F (24°C)
 48 Hours @ 65 °F (18°C)

Dry to Handle:

6 Hours @ 85 °F (29°C)
 10 Hours @ 75 °F (24°C)
 14 Hours @ 65 °F (18°C)

Dry to Service:

n/a [Click to select time Interval @ 85 °F \(29°C\)](#)
 n/a [Click to select time Interval @ 70 °F \(24°C\)](#)
 n/a [Click to select time Interval @ 60 °F \(18°C\)](#)

Graphs included on page [Click here to enter text](#) or additional information included on page [Click here to enter text](#)

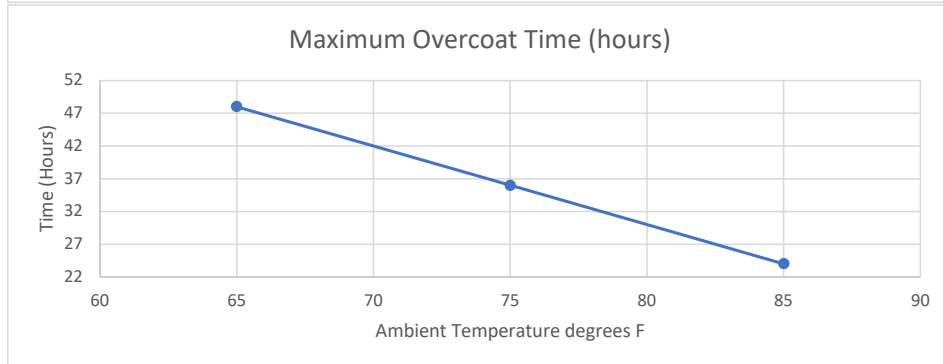
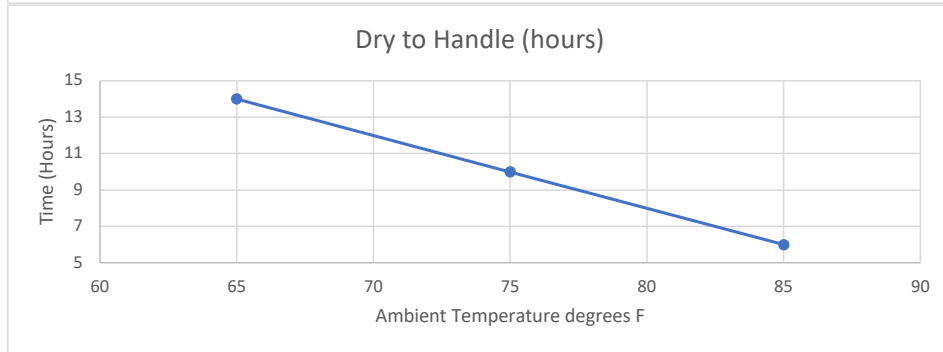
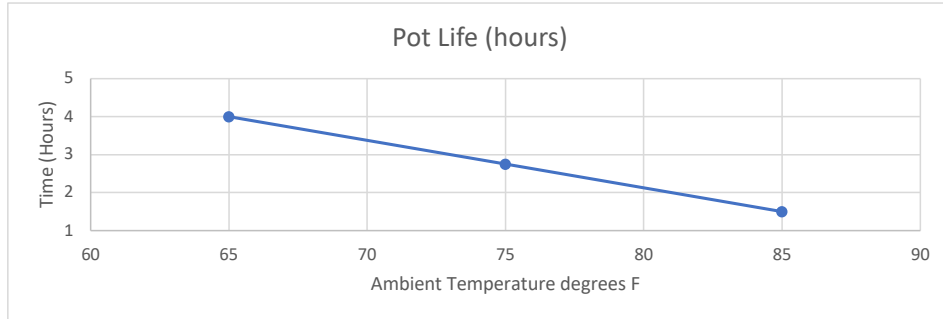
(d) EQUIPMENT REQUIREMENTS: small jiffy blade for mixing and low speed drill, ¼" nap roller or brush for application

(e) SPECIAL INSTRUCTIONS: [Click here to enter text](#)

IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: If critical window has been exceeded, surface should be sanded to a 1-3 mil profile before applying next step

IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR NON-CRITICAL APPLICATIONS: If critical window has been exceeded, surface should be sanded to a 1-3 mil profile before applying next step

GRAPHS FOR POT LIFE AND CURE TIMES:



ADDITIONAL DATA/INSTRUCTIONS:

I. GENERIC TYPE AND DESCRIPTION: 100% solids, low odor epoxy material designed to assist underlayment & terrazzo adhesion and performance of BIO-DEK materials

II. MANUFACTURERS DATA: [Click here to enter text](#)

III. PROPERTIES: [Click here to enter text](#)

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS: 1-3 mil. Surface profile. Surface must be clean, dry and free from flaking particulate

V. MIXING PROCEDURES: mix part A resin with Jiffy blade on low speed for 20-30 seconds then blend in part B and mix until homogeneous (1-2 minutes)

VI. APPLICATION: apply by brush or roller or squeegee – min. of 4 mils is recommended for best results