

## DESCRIPTION

Thiokol 415 Primer is a low viscosity primer for polysulfide sealants.

## TYPICAL APPLICATION

• Primer	Thiokol 415 Primer @ 3–5 mils (concrete) / 2–3 mils (steel)
• Sealant	Thiokol Sealant System

## PERFORMANCE DATA

VOC ..... 6.5 lb/gal; 781.5 gm/L  
Volume Solids ..... 15%

## STORAGE & INSTALLATION

Storage Environment ..... Dry area, 65–80°F  
Application Temperature, ambient ..... 40–95°F  
Application Temperature, substrate ..... Minimum 5°F above dew point  
Shelf Life ..... 1 year  
Set Time, @ 77°F ..... 60 minutes

*Material cures more slowly at cooler temperatures, and working time will be substantially reduced at higher temperatures. In hot weather, material should be cooled to 65°F to 80°F prior to mixing and application to improve workability and avoid shortened pot life. The data shown above reflects typical results based on laboratory testing under controlled conditions. Reasonable variations from the data shown above may result.*

## CONSIDERATIONS & LIMITATIONS

1. Do not thin with solvents unless advised to do so by PolySpec.
2. Confirm product performance in specific chemical environment prior to use.
3. Prepare substrate according to “Surface Preparation” portion of this document.
4. Always use protective clothing, gloves and goggles consistent with OSHA regulations during use. Avoid eye and skin contact. Do not ingest or inhale. Refer to Material Safety Data Sheet for detailed safety precautions.
5. For industrial/commercial use. Installation by trained personnel only.

# THIOKOL®

# 415

TECHNICAL DATA SHEET

## Primer for Polysulfide Sealants

### BENEFITS

- One component
- Easy to apply
- Fast recoat time

### RECOMMENDED USES

- Used in conjunction with Thiokol sealants

### GENERIC DESCRIPTION

Primer

### STANDARD COLORS

Amber

### PACKAGING

1-Gallon Unit

55- Gallon Unit (53 Gallon –fill weight)

### COVERAGE

Concrete: 300 ft<sup>2</sup> / gallon @ 3–5 mils

Steel: 400 ft<sup>2</sup> / gallon @ 2–3 mils

## SURFACE PREPARATION

**Concrete:** Apply only to clean, dry and sound concrete substrates that are free of all coatings, sealers, curing compounds, oils, greases or any other contaminants.

- *New concrete should be cured a minimum of 28 days.*
- *Concrete that has been contaminated with chemicals or other foreign matter must be neutralized or removed.*
- *Remove any laitance or weak surface layers.*
- *Concrete should have a minimum surface tensile strength of at least 300 PSI per ASTM D-4541.*
- *Surface profile shall be CSP-3 to CSP-5 meeting ICRI (International Concrete Repair Institute) standard guideline #03732 for coating concrete, producing a profile equal to 60-grit sandpaper or coarser. Prepare surface by mechanical means to achieve this desired profile.*
- *Moisture vapor transmission should be 3 pounds or less per 1,000 square feet over a 24 hour time period, as confirmed through a calcium chloride test, as per ASTM E-1907. Quantitative relative humidity (RH) testing, ASTM F-2170, should confirm concrete RH results <75%.*
- *All surface irregularities, cracks, expansion joints and control joints should be properly addressed prior to application.*
- *Outgassing may occur due to the porosity of some concrete surfaces. To reduce the effect of outgassing, the primer and coating should be applied when the temperature of the concrete substrate is dropping. This usually occurs in the evening; however, the concrete substrate temperature should be measured with a surface thermometer for verification. Double priming will greatly reduce the effects of outgassing by additionally filling the pores in the concrete.*

**Steel:** For immersion service, "White Metal" abrasive blast with an anchor profile of 2–4 mils in accordance with Steel Structures Painting Council Specification SP-5-63 or NACE No. 1 is required. For splash and spillage exposure, "Near White" SP-10-63 or NACE No. 2 is required.

**Refer to PolySpec Surface Preparation Guidelines for more details.**

## INSTALLATION STEPS

1. Thiokol 415 Primer can be applied by spray, brush or roller.

*NOTE: Use of a brush will allow for joints to be primed before the application of Thiokol sealants.*

**Spray Application:** Apply Thiokol 415 primer in a spray mist-coat at a rate not to exceed the following:

- Concrete:..... 300 ft<sup>2</sup>/gallon maximum
- Steel: ..... 400 ft<sup>2</sup>/gallon maximum

**Brush or Roller Application:** Thiokol 415 may be applied by brush or roller; however, coverage will be significantly reduced.

- Concrete:..... 3–5 mils
- Steel: ..... 2–3 mils

2. Allow primer to cure until it is dry to the touch (typically 1 hour @ 77°F) before proceeding to application of Thiokol sealant.
3. For best results, clean tools and equipment with PolySpec® All Purpose Cleaner, a nonflammable and non-evaporating cleaner. Always wear gloves when using this product.

Premixed / DOC 415-TDS

Rev 01/10

Thiokol is a © Registered Trademark of Toray Fine Chemicals Co., Ltd.

© Copyright 2005 PolySpec L.P. All rights reserved. Published technical data and instructions are subject to change without notice. Please visit the online catalog at [www.polyspec.com](http://www.polyspec.com) for the most current technical data and instructions. Or, you may contact your PolySpec representative for current technical data and instructions.

PolySpec, L.P. warrants its products to be free from defects in material and workmanship. PolySpec's sole obligation and Buyer's exclusive remedy in connection with the products shall be limited, at PolySpec's option, to either replacement of products not conforming to this warranty or credit to Buyer's account in the invoiced amount of the nonconforming products. Any claim under this Warranty must be made by Buyer to PolySpec in writing within five days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify PolySpec of such nonconformance as required herein shall bar Buyer from recovery under this warranty.

**PolySpec makes no other warranties concerning this product. No other warranties, either expressed or implied, or statutory, such as warranties of merchantability or fitness for a particular purpose, shall apply. In no event shall PolySpec be liable for consequential or incidental damages.**

Any recommendation or suggestion relating to the use of the products made by PolySpec, whether in its technical literature, or in response to specific inquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyers having requisite skill and know-how in the industry, and therefore it is for the Buyer to satisfy itself of the suitability of the products for its own particular use, and it shall be deemed that Buyer has done so, at its sole discretion and risk. Variation in environment changes in procedures of use, or extrapolation of data may cause unsatisfactory results. PolySpec cannot guarantee that color will conform to sample, if provided.