



GACOFLEX™ E5320 2-PART EPOXY PRIMER/FILLER

A. DESCRIPTION:

GacoFlex E5320 is a two-component water-based epoxy primer/filler.

B. RECOMMENDED USE:

This multi-purpose primer offers excellent adhesion to most surfaces, including metal roofs, metal flashings, existing elastomeric coatings, wood, masonry and single-ply membranes. GacoFlex E5320 improves adhesion of GacoFlex roof coatings, and spray polyurethane foam, including GacoFlex F2733 GacoRoofFoam™, to approved substrates. It can also be used as a masonry block filler when combined with ordinary sand.

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C. PACKAGED PRODUCT DATA:

| PROPERTY | DESCRIPTION |
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| COLOR | Part A: White Part B: Brown Part A & B Combined: Light Pink |
| CONSISTENCY | Part A is slurry with soft settling characteristics. Part B is a viscous liquid. When combined, the resulting product becomes a creamy, easy spreading mixture. When properly mixed and applied, E5320 Primer should remain a translucent pink color in its cured state. |
| THEORETICAL COVERAGE | When used unreduced as a block filler, the coverage is 70 – 100 ft ² / gal (6.5 – 9.3 m ² / 3.8 L). When thinned with 0.13-gal clean water / 1 gal of GacoFlex E5320 (Part A & B Combined) (0.5 L per 3.78 L) and applied to smooth concrete, the coverage is 200 – 250 ft ² / gal (18.6 to 23.2 m ² / 3.8 L). NOTE: Actual coverage may be less due to surface profile, losses due to overspray and wind, and residual coating left in the container. |
| SOLIDS | Weight: 60.5 % ASTM D1644 Volume: 44 % ASTM D2697 |
| STORAGE STABILITY | <u>Part A:</u> Two (2) years from date of manufacture when stored in sealed containers between 50 °F – 80 °F (10 °C – 26 °C). Protect from freezing in shipment and storage. <u>Part B:</u> Two (2) years from date of manufacture when stored in sealed containers between 50 °F – 80 °F (10 °C – 26 °C). Protect from freezing in shipment and storage. |

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| V.O.C. | < 100 g / L | EPA Method 24 |
| FLASH POINT | TOC > 200 °F (93 °C) | ASTM D1310 |

D. APPLIED PHYSICAL PROPERTIES:

| PROPERTY | RESULT |
|----------------------------|---|
| ADHESION | Excellent adhesion to most surfaces. Most coatings and spray polyurethane foams have excellent adhesion to cured GacoFlex E5320. |
| CHEMICAL RESISTANCE | Good solvent resistance and excellent alkali resistance. |
| WEATHERABILITY | Must be top-coated when used in exterior applications |
| HARDNESS | Cures to form a hard coating material. |
| TOXICITY | <p>Part B contains a polyamide resin that is normally non-sensitizing; however, care should be taken to thoroughly clean with soap and water any skin areas that are contacted by GacoFlex E5320. If you experience any difficulty breathing, leave the area to obtain fresh air. If difficulty continues, seek medical assistance immediately. In case of eye contact, flush immediately with plenty of water for at least 15 minutes and seek medical attention; for skin, wash thoroughly with soap and water.</p> <p>During application, the use of chemical protective clothing and gloves is recommended. A properly fitted respirator (NIOSH/MSHA approved) is recommended during spray application.</p> |

E. APPLICATION:

| STEP | INSTRUCTIONS |
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| THINNING | <p>Thinning is not normally required for roller application. When thinning is necessary to extend pot life for spraying, for application at cool temperatures, or to achieve recommended application rates, thin combined material 10% – 20% with clean water and mix thoroughly.</p> <p>NOTE: Do not thin more than 20%.</p> |
| MIXING | <p>GacoFlex E5320 is a two-component material. Equal parts by volume of Part A and Part B must be properly combined per the following directions prior to application:</p> <ol style="list-style-type: none"> Mix Part A well for 3 – 5 minutes. Mix Part B for 3 – 5 minutes. Pour Part B into a clean, empty pail. Pour Part A into the same pail. It will sink. Mix both together for 3 – 5 minutes. Mixture will appear thin and light pink in color. Power mixing is recommended when combining more than 1 gal (3.8 L) each of Part A and Part B. |
| POT LIFE | Pot life after mixing is 1.5 hours at 75 °F (24 °C). The pot life will double at 55 °F (13 °C) and at 100 °F (38 °C), pot life is reduced to approx. 45 minutes. |
| APPLICATION | Product may be applied by brush, roller or spray. On smooth surfaces, use a 1/4 – 3/8 in (6 – 10 mm) nap roller or nylon brush. When applying E5320 as block filler for porous concrete, use a 1 – 1-1/4 in (25 mm – 32 mm) nap roller. If blow holes form as the primer dries, make a second pass with a relatively dry roller; allow 5 – 10 minutes between passes. Contact Technical Services for application utilizing equipment. Do not apply to surfaces that are below 50 °F (10 °C). |

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| | <p>1. <u>SINGLE PLY MEMBRANE ROOFS, SMOOTH-SURFACED MODIFIED BITUMEN, EXISTING ELASTOMERIC COATINGS (INCLUDING GACOFLEX A4271 BLEEDTRAP™) AND SMOOTH CONCRETE:</u> Apply one coat at the rate of 1 gal / 500 ft² (3.78 L / 46.5 m²) a total Dry Film Thickness (DFT) of 1 – 2 mils. NOTE: Combined material will need to be thinned 10 – 20 % with clean water to achieve this spread rate.</p> <p>On asphalt-based surfaces including smooth cap sheets, apply two separate coats at the rate of 1 gal / 250 ft² (3.78 L / 23.2 m²) to achieve an overall DFT of 2 – 3 mils.</p> <p>2. <u>METAL ROOF DECKS:</u> Apply one coat at a rate of 1 gal / 300 ft² (3.78 L / 27.8 m²) for a DFT of 2-3 mils.</p> <p>3. <u>FOR DIRECT APPLICATION TO GRANULAR SURFACES:</u> Apply two separate coats at a rate of 1 gal / 200 ft² (3.78 L / 18.6 m²) for a DFT of 3-4 mils.</p> <p>NOTE: For all applicable substrate types, application rate is job-specific. Additional material may be required to meet minimum DFT requirement.</p> |
| DRY TIME | <p>Allow E5320 Primer to dry for a minimum of 6 hours before applying a GacoFlex coating. Dry time is dependent upon temperature and humidity. Apply GacoFlex top coat within 72 hours. If E5320 is exposed for greater than 72 hours, please contact Technical Services for assistance.</p> <p>NOTE: Where maximum solvent resistance is needed, apply two coats of E5320 a minimum of two hours apart and allow to cure for 48 hours (at a daily maximum temperature of 70 °F (21 °C) or higher). For 60 °F (16 °C) days, allow up to one week. Full dry time may be longer when there is poor air ventilation such as in tanks or enclosed reservoirs</p> |
| CLEAN UP | <p>Clean brushes and rollers with soap and water; a small amount of vinegar may be added to make clean up easier. Late in the pot life or in hot weather, clean-up is impractical and brushes and rollers should be disposed of. Clean spray equipment with water supplemented with a small amount of vinegar and recirculate through lines and gun until residual coating is removed</p> |

* For specific Health and Safety information please refer to applicable Safety Data Sheet (SDS)