AMERON INTERNATIONAL
Performance Coatings & Finishes

Nu-Klad® 127

100% solids epoxy primer/sealer

Product Data/ Application Instruction

- 100% solids
- Easy to apply
- Low viscosity
- Seals porous concrete, reduces bubbling of self-leveling topcoats
- Suitable for new concrete or refurbishment
- Smooths rough surface profile

Nu-Klad 127 is a low viscosity, 100% solids, two component, high build, fast cure epoxy primer/sealer. Nu-Klad 127 enhances adhesion by penetrating into the concrete substrate and helps reduce bubbling and pinholes that may occur when coating porous surfaces.

Typical Uses

- Food and beverage processing facilities
- Electronic equipment plants
- Industrial and commercial warehouses
- Laboratory floors
- Pharmaceutical plants
- Power plants
- Waste water and sewage treatment plants

Nu-Klad 127 is for use over prepared concrete. It is ideal for use on porous concrete or over a rough surface profile.

Nu-Klad 127 is normally topcoated with Nu-Klad 126. Consult your Ameron representative for other recommendations.

Recommended Systems

Service	Primer	2nd Coat	3rd Coat
Decorative	Nu-Klad 127	Nu-Klad 126 (10 mils)	Nu-Klad 126 Clear or Amershield (Optional)
Mild	Nu-Klad 127	Nu-Klad 126 (20 mils)	Nu-Klad 126 Clear or Amershield (Optional)
Moderate	Nu-Klad 127	Nu-Klad 126 (30 mils)	Nu-Klad 126 Clear or Amershield (Optional)
Severe	Nu-Klad 127	Nu-Klad 110C	Nu-Klad 126 Clear (30 mils)
Chemical Exposure	Nu-Klad 127	PSX 758	None

Physical Data

Finish	Low gloss	
Color*	Clear, gray,	
Components	2	
Curing mechanism	Chemical reaction between components	
Volume Solids (calculated)	100%	
DFT per coat	mils 6 to 10	microns 150-250
Coats	1	
Theoretical coverage		
	ft^2/gal	m^2/L
6 mils (150 microns)	267	6.5
8 mils (200 microns)	200	4.9
10 mils (250 microns)	160	3.9
Temperature resistance, dry	200˚F (93˚C)	
VOC (calculated)	0.0 lb/gal	0.0 g/L
Flash point (SETA)	°F	°C
cure	255	124
resin	300	182
Amercoat 12	2	-17

**Nu-Klad 127 is subject to color change upon aging especially if exposed to direct sunlight. There may be minor variations in color from batch to batch. Change batches at natural breaks or transitions, or intermix batches for consistency.*

Nu-Klad 127 Chemical Resistance Guide

Environment	Slash and Spillage	Fumes and Weather
Acidic	F	G
Alkaline	E	E
Solvents	E	E
Salt solutions		
Acidic	G	VG
Neutral	E	E
Alkaline	E	E
Water	E	E

F-Fair G-Good E-Excellent VG-Very Good

This chart shows typical resistance of Nu-Klad 127. Contact your Ameron representative for your specific requirements.

Surface Preparation

Coating performance is proportional to the degree of surface preparation. Concrete surfaces must be clean and dry and free of contaminants such as dust, dirt, grease, or oil.

New/Bare Concrete – Refer to SSPC-SP 13/NACE No.6 surface preparation of concrete for detailed information regarding surface preparation of concrete. In general, concrete must have sufficient profile to achieve satisfactory adhesion of primer and topcoat. Concrete must be in sound condition and free of all coatings, curing compounds, oil and other contaminants. New concrete must cure a minimum of 28 days prior to application of any coatings.

Concrete can be abrasive blasted (ASTM D4259) or mechanically abraded to achieve a profile equal to 60 grit sandpaper or coarser. Moisture vapor transmission should be 3lbs. or less over a 1000 sq.ft. area during a 24 hour period, measured and confirmed through a calcium chloride test. Concrete should have a minimum surface tensile strength of 300 PSI verified by a pull-off adhesion test. Should concrete not meet moisture vapor transmission or tensile strength requirements, contact your local Ameron representative for guidance. Consult the following ASTM methods: ASTM 4263 - plastic sheet method for checking moisture in concrete; ASTM 4258 standard practice for cleaning concrete; ASTM 4259 standard practice for abrading concrete; ASTM 4260 standard practice for etching concrete.

Previously Painted Concrete – Old coatings and concrete must be in sound condition. Surfaces must be clean and dry and free of all contaminants such as dust, dirt, grease, or oil. Old coatings must be uniformly abraded to achieve satisfactory adhesion. Apply a test patch to the abraded surface and allow to cure a minimum of one week before testing adhesion. If adhesion is poor, or if the old coatings are peeling, chipping, or are otherwise in poor condition, remove the coatings down to bare concrete and prepare the bare concrete as shown above.

Application Data

Applied over	Prepared concrete
Surface preparation	ASTM D4260 or 4259
Method	Pour and spread - squeegee and backroll.
Mixing ratio (by volume)	1.6 parts resin to 1 part cure

Environmental conditions		
Temperature	°F	°C
air	55 to 95	13 to 35
surface	55 to 95	13 to 35
material	55 to 95	13 to 35

Surface temperatures must be at least 5˚F (3˚C) above dew point to prevent condensation. Relative humidity must not exceed 85%.

Pot life (mins.)	˚F/˚C		
	90/32	70/21	55/13
	15	30	45

Drying time (hours, @ 8 mils DFT, 50% RH)

	˚F/˚C		
	90/32	70/21	55/13
touch	4	5	7
through	18	24	48
full cure	7 days	7 days	10 days

Recoat time (hours, @ 8 mils DFT, 50% RH)

	˚F/˚C		
	90/32	70/21	55/13
recoat, min	5	6	8
recoat, max*	24	24	24

* Roughen surface if maximum recoat/topcoat time has been exceeded.

Cleaner Amercoat 12

Application Equipment

The following is a guide. Adjustments in application equipment or technique may be necessary to accommodate varying field conditions.

Squeegee – Flat or notched rubber squeegee (depending upon DFT required) with EPDM rubber blade, available from manufacturers such as Midwest Rake Co.

Rollers – ⅜ inch lint-free roller with phenolic core for backrolling, and 7/16 inch sharp-tipped spiked roller for air release and leveling, available from manufacturers such as Midwest Rake Co.

Mixing

Nu-Klad 127 is a two- component coating. Stir resin thoroughly to disperse pigment before mixing with cure. Add cure to resin and mix slowly until uniformly blended. **Do not mix at high speed, air entrainment will occur.** Nu-Klad 127 is ready for use immediately after mixing resin and cure; no induction time is required. Do not mix more material than can be used within the working time: See potlife data. Material which has begun to set cannot be satisfactorily used and must be discarded.

Surface temperatures must be at least 5˚F (3˚C) above dew point to prevent condensation.

Application Procedure

Nu-Klad 127 is packaged in the proper proportions which must be mixed together before use. **Mix full units only.**

1. Pour a substantial portion of mixed material onto floor in a long ribbon approximately 12 to 18 inches wide.
2. Using a flat rubber squeegee, spread the mixed material to a uniform thickness. Apply sufficient pressure to work the material into the porous surface.
3. Wet film thickness can be adjusted by varying the angle of the squeegee to the floor and by varying the amount of pressure applied.
4. As material is being spread with the squeegee, an applicator wearing spiked shoes should immediately backroll and crossroll the material with a clean, lint-free ⅜" roller. Finish by uniformly tipping off the surface with the roller in one direction, leaving 6-10 mils on the surface.
5. After 15 minutes set up time, the material should be rolled with a spiked roller to aid air release and improve appearance. Do not spike roll after 30 minutes.
6. If primer is to be topcoated with Nu-Klad 110C surfacer, sand or other suitable aggregate may be lightly broadcast over wet primer to aid the application of the surfacer by providing a grip for the surfacer and preventing the surfacer from sliding on the primed surface as it is troweled on.
7. If porosity or pinholes are evident after initial cure, an additional coat of Nu-Klad 127 may be necessary, especially on very porous concrete.
8. Clean equipment with Amercoat 12 cleaner.

Shipping Data

Packaging	1 gal unit	5 gal unit
cure	.38 gal in ½ gal can	1.9 gal in 2½ gal can
resin	.62 gal in 1 gal can	3.1 gal in 5 gal can
Shipping weight	lb	kg
1 gal unit		
resin	6.4	2.9
cure	3.5	1.6
5 gal unit		
resin	31.0	14.1
cure	17.0	7.7

Shelf life when stored indoors at 40 to 100°F (4 to 38°C) resin and cure 1 year from shipment date

Numerical values are subject to normal manufacturing tolerances, color and testing variances. Allow for application losses and surface irregularities. See application instructions for complete information and safety precautions.

The mixed product is photochemically reactive as defined by the South Coast Air Quality Management District's Rule 102 or equivalent regulations.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

This product is for industrial use only. Not for residential use .

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligation and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming to this Warranty or credit to Buyer's account in the invoices amount of the nonconforming products. Any claim under this Warranty must be made by Buyer to Ameron in writing within five (5) 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 Ameron of such nonconformance as required herein shall bar buyer from recovery under this Warranty.

Ameron makes no other warranties concerning the product. No other warranties, whether express, implied, or statutory, such as warranties of merchantability or fitness for a particular purpose, shall apply. In no event shall Ameron be liable for consequential or incidental damages.

Any recommendation or suggestion relating to the use of the products made by Ameron, 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 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.

Limitation of Liability

Ameron's liability on any claim of any kind, including claims based upon Ameron's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim. **In no event shall Ameron be liable for consequential or incidental damages.**

AMERON INTERNATIONAL

Ameron U.S.A. • 13010 Morris Rd, Suite 400, Alpharetta, GA 30004 • (678) 393-0653
Ameron B.V. • J. F. Kennedylaan 7, 4191 MZ Geldermalsen, The Netherlands • (31) 345-587-587