

INDUSTRIAL PRIMER

K00020001, Red
K00020002, Gray

Product Data Sheet

KRYLON

INDUSTRIAL
COATINGS™

DESCRIPTION

Industrial Primer is a heavy duty primer which offers good protection for steel in normal industrial environments. This product is a high solids, low VOC (less than 340 g/L), rust resistant primer which is free of heavy metals. It is easy to apply by spray, fast drying and can be topcoated with alkyd and latex coatings.

ADVANTAGES

- High build to protect abrasive blasted steel
- Good corrosion and rust undercutting protection
- Abrasion resistant
- Interior and exterior use
- Fast drying
- Lead, chromate and barium-free pigmentation
- May be used under a variety of latex and alkyd topcoats

RECOMMENDED USES

For industrial and commercial applications to steel and iron to protect against atmospheric corrosion.

LIMITATIONS:

Not recommended for immersion service or exposure to acids, alkalies or strong solvents.

SPECIFICATIONS

Steel, Alkyd Topcoat:

1 ct. Industrial Primer @ 2 - 3 mils dft/ct
1-2 cts. Industrial Alkyd Enamel (K0053 Series), @ 2-3 mils dft/ct.
or High Gloss Alkyd Enamel (K0083 Series) @ 2-3 mils dft/ct

Steel, Aluminum Finish:

1 ct. Industrial Primer @ 2 - 3 mils dft/ct
1 ct. Industrial Aluminum (K053-2500) @ 1 mil dft/ct

Steel, Water-Based, Acrylic Topcoat:

1 ct. Industrial Primer @ 2 - 3 mils dft/ct
2 cts. Iron Guard™ Acrylic Enamel (K110 Series)
@ 2.5 - 4.0 mils dft/ct

Steel, Acrylic Alkyd Topcoat:

1 ct. Industrial Primer @ 2 - 3 mils dft/ct
2 cts. Rust Tough Alkyd @ 2 mils dft/ct

SURFACE PREPARATION

Surfaces must be dry and in sound condition. Remove oil, dust, dirt, loose rust, loose mill scale or other contamination to ensure good adhesion.

For maximum performance, the surface must be abrasive blasted for proper adhesion. All blasted steel must be primed the same day.

Iron and Steel: Remove all grease and oil from the surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Hand Tool Clean per SSPC-SP2. For optimum performance, the surface should be cleaned to Commercial Blast Clean per SSPC-SP6.

APPLICATION

APPLICATION CONDITIONS

Temperature: 40°F minimum, 120°F maximum (air, surface, and material). At least 5°F above dew point.
Relative humidity: 85% maximum.

IMPORTANT: Primer coats used for exterior applications should not be left untopcoated in excess of six months.

APPLICATION EQUIPMENT

Methods: Airless Spray, Conventional Spray, and Brush

Airless Spray: Pressure: 1800 - 1300 psi; Hose: 1/4";
Tip: .015" - .019"; Filter: 60 mesh; Reduction: None

Conventional Spray: Gun: Binks Model 18; Fluid Nozzle: 63C;
Air Nozzle: 63PB; Atomization Pressure: 50 psi;
Fluid Pressure: 15 - 20 psi; Reduction: Reduce up to 5% by volume with Mineral Spirits or VM&P Naphtha as necessary to be compatible with the existing application and environmental conditions.

Brush: China Bristle; confined to small areas or touch-up. Roller not recommended.

Note: If specific application equipment is listed above, equivalent equipment may be substituted.

MIXING INSTRUCTIONS

Mix paint thoroughly by boxing and stirring or mechanically agitate for uniformity and consistency.

PERFORMANCE TESTS

Not recommended for immersion service or exposure to acids, alkalies or strong solvents.

CHARACTERISTICS

FINISH: Flat (<10 units @ 60°)

COLORS: Red and Gray

CURING MECHANISM: Solvent Evaporation Oxidation

SHELF LIFE: 36 months, unopened, at 77°F

DRYING SCHEDULE @ 77°F @ 50% RH:

To touch: 15 minutes

To handle: 1 1/2 hours

To recoat: 7 hours

Note: Drying time is temperature, humidity, and film thickness dependent.

FLASH POINT:

Red: 95°F (Pensky-Martens/Seta Flash)

Gray: 93°F (Pensky-Martens/Seta Flash)

VISCOSITY: 70 - 76 KU

VOLUME SOLIDS (Red/Gray): 55% ± 2%

WEIGHT SOLIDS (Red/Gray): 77% ± 2%

WEIGHT GALLONS:

Red: 12.60 ± 2%

Gray: 12.38 ± 2%

RECOMMENDED SPREADING RATE: 3.6 - 5.5 mils wet,
2.0 - 3.0 mils dry

COVERAGE: 441 - 294 sq. ft/gal approximate

VOC: Less than 340 g/L; 2.84 lb/gal

REDUCER/CLEAN-UP: VM&P Naphtha (K01661714) or Mineral Spirits (K01661600).

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-777-2966.