



# ALKYD SHOPCOAT PRIMER

*K-S3102 Gray*  
*K-S4501 Red Oxide*

Alkyd Shopcoat Primer is a fast drying, heavy-duty primer that offers outstanding protection up to 6 months for steel in normal industrial environments. Its high volume solids makes it an economical primer with good coverage and excellent hiding power.

- ✓ Corrosion and rust-inhibitive protection
- ✓ Weld-through formula
- ✓ Abrasion resistant
- ✓ Good coverage and excellent hiding power
- ✓ Fast drying — dries to touch in 15 minutes
- ✓ Interior/exterior use
- ✓ Topcoat with latex and alkyd enamels

**INDUSTRIAL USE ONLY!**  
AS OF 01/01/16 COMPLIES WITH:

NATIONAL/EPA

**krylonindustrial.com**  
1-800-247-3266

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## RECOMMENDED USES

Use this product on properly prepared surfaces of steel such as structural steel, machinery and equipment, racking, piping, bar joists, joists, handrails and tank exteriors.

## RECOMMENDED SYSTEM

### Steel (Alkyd Topcoat):

1 coat Krylon® Industrial Alkyd Shopcoat Primer  
1–2 coats Krylon® Industrial Tough Coat® Alkyd Enamel

### Steel (Acrylic Topcoat):

1 coat Krylon® Industrial Alkyd Shopcoat Primer  
1–2 coats Krylon® Industrial Waterborne Acrylic Enamel

## SURFACE PREPARATION

**WARNING!** Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust and other foreign materials to ensure adequate adhesion. **Do not use hydrocarbon solvents for cleaning.**

### Iron And Steel:

Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPCSP6/ NACE 3. Primer recommended for best performance.

**According to AISC, shop coat primers are intended for protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating. Primer coats used for exterior applications should not be left untopcoated in excess of six months.**

## CLEAN UP

Clean spills, spatters and tools immediately with mineral spirits. After cleaning, flush spray equipment with mineral spirits to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using mineral spirits.

## TECHNICAL DATA

<b>Vehicle</b>	Alkyd
<b>Finish</b>	Flat (0–10 units @ 60°F)
<b>Flash Point</b>	45°F, PMCC
<b>Volume Solids</b>	
Gray	49 ± 2%
Red Oxide	45 ± 2%
<b>Weight Solids</b>	
Gray	73 ± 2%
Red Oxide	69 ± 2%
<b>Weight Gallon</b>	
Gray	11.7 lb/gal
Red Oxide	11.0 lb/gal
<b>VOC</b> (less exempt solvents)	
Gray	378 g/L (3.15 lb/gal) as per 40 CFR 59.406
Red Oxide	411 g/L (3.43 lb/gal) as per 40 CFR 59.406
<b>Rec. film thickness</b>	
	Wet mils: 4-5
	Dry mils: 2-2.5

**TECHNICAL DATA CONTINUED**

<b>Spread Rate</b>	400 f2/gal
<b>Application</b>	Apply by airless or conventional spray, brush
<b>Drying Time</b>	(@ 77°F, 50% RH)  Note: Drying times are temperature, humidity and film thickness dependant.
To Touch:	10 minutes
Tack Free	30 minutes
To Topcoat:	12 hours min, 48 hours max After maximum topcoat time, primed surface must be abraded prior to recoating or topcoating. Primer coats used for exterior application should not be left untopcoated in excess of six months.
<b>Reduction</b>	Not Required
<b>Clean-Up</b>	Mineral spirits
<b>Tinting</b>	Do not tint
<b>Sizes</b>	5 gallon
<b>Shelf Life</b>	12 months

**APPLICATION**

<b>Temperature</b>	(air, surface and material) 40°F min, 120°F max, at least 5°F above dew point
<b>Relative humidity</b>	85% maximum
<b>Reducer/Cleanup</b>	Mineral spirits
<b>Airless Spray</b>	
Pressure	1800–2300 psi
Hose	1/4" ID
Tip	.015"–.017"
Filter	60 mesh
Reduction	Not recommended
<b>Conventional Spray</b>	
Gun	Binks 18 (or similar)
Fluid Nozzle	63C
Air Nozzle	63PB
Atomization Pressure	50 psi
Fluid Pressure	15–20 psi
Reduction	As needed up to 5% by volume
<b>Brush</b>	(small areas and touch-up) Nylon/polyester
<b>Roller</b>	Not recommended

**PHYSICAL TEST DATA**

<b>System Tested</b>	
Substrate	Steel
Surface Preparation	SSPC-SP1
Primer	1 coat Krylon® Industrial Alkyd Shopcoat Primer
<b>Abrasion Resistance</b>	K-S4501 — 340 mg loss @ 1000 cycles
ASTM D4060, CS17 wheel, 1 kg load	K-S3102 — 350 mg loss @ 875 cycles
<b>Adhesion</b>	
ASTM D3359	Passes at 3B, 5%–15% loss
<b>Elongation</b>	
ASTM D522 Method B	K-S4501 — passes 1/4" mandrel K-S3102 — passes 1" mandrel
<b>Salt Fog Resistance</b>	
ASTM B117	K-S4501 — passes 250 hours K-S3102 — passes 100 hours
<b>Moisture Cond. Resistance</b>	
ASTM D4585, 100°F, 500 hours	Passes



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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.