

## PRODUCT DESCRIPTION

**Type** Heavy Duty rust inhibitive, weldable, structural steel shopcoat primer.

**99 Series Heavy Duty Inhibitive Shopcoat Primers** are high solids, rust inhibitive primers designed to protect steel and iron substrates from corroding prior to erection. Heavy Duty Inhibitive Primers are national rule VOC and HAPS compliant and contain no heavy metals. These primers contain a high level of inhibitive pigment to increase corrosion resistance, thereby extending exposure time before top-coating becomes necessary – the primers of choice for long-term protection.

- Uses**
- When extra protection is required in yards such as coastal environments and extended durability is needed over three months.
  - For use in light commercial and/or architectural construction materials where steel will be exposed to an environment of C2 or less (per ISO 12944).
  - Formulated for use in a controlled fabrication shop environment.

- Features**
- Provides performance exceeding SSPC Paint 15 and comparable to SSPC Paint 25. Listed on MPI Specification 79.
  - National VOC and HAPs compliant.
  - Tested with several cementitious / intumescent fireproofing materials. Contact Sumter Coatings for testing with specific products.

## SUBSTRATE & SURFACE PREPARATION

**All** Substrate must be clean, dry and free of contaminants. Remove all oil, dust, loose rust, loose mill scale and other contaminants to achieve best adhesion.

**Steel & Iron** The minimum surface preparation for steel and iron is Hand Tool Cleaning per SSPC-SP2 or SSPC-SP3 Power Tool Clean. For better performance, prepare substrate to SSPCSP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

**Primer** n/a

## MIXING & THINNING

**Ratio** 1 - component

**Mixing** Mix thoroughly before use by boxing or stirring with mechanical agitation.

**Thinning** Thinning is not normally needed. If needed add 560X3502 VM&P Naptha in cool conditions, or 560X Mineral Spirits in hot conditions. The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

**Cleanup** Use Universal Flush Solvent (560X1301), or Mineral Spirits (560X0194).

## APPLICATION GUIDANCE

**Application Methods** This product may be applied by conventional spray, airless, air-assisted airless and HVLP equipment. A natural bristle brush may be used for application in small areas. Recommended airless tip sizes are .015 - .019.

**Temperature** 40°F, 110°F maximum for either air or surface. Paint temperature should be 50°F – 90°F. Surface must be dry and at least 5°F above the dew point.

**Relative Humidity** Dry times may be adversely affected as the relative humidity increases. Caution should be taken when painting in very humid conditions of 85% relative humidity or higher.

## CURE TIME & RECOAT WINDOW

Substrate Temperature	To Touch	Tack Free	To Topcoat	Full Cure
75°F (24°C)	30 minutes	2 hours	Overnight or 8 hours	7 days

Drying times are dependent upon film thickness, temperature and humidity.



# Product Data Sheet

## Heavy Duty Inhibitive Shopcoat Primer

### 99 series

### PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
99 series Heavy Duty Inhibitive Primer	100x99xx series	5-gallon pails. 55-gallon drums

**Theoretical Coverage** 904.7 ft<sup>2</sup> / gallon @ 1.0 mil dry film thickness.

**Storage & Shelf Life** Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.

**Safety** Mixes and applications of this product present several hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

**Ventilation** Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

**FIREPROOFING** 99-Series Inhibitive Shopcoat Primers have been tested for compatibility and adhesion with certain cementitious fireproofing materials and were found to exhibit excellent performance. They have also been tested and approved under a limited number of intumescent fireproofing with satisfactory adhesion and compatibility. Contact Sumter Coatings or your Sumter Coatings representative for specific information.

**WELDING** Independent lab tests have found no evidence 99-series Inhibitive Shopcoat Primers adversely affected the welding process. These primers may be welded through to yield sound welds.

### TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
<i>Specific properties below are of 100W9927 White</i>	
Colors	Light Gray, 100D9914 Dark Gray, 100D9944 Red Oxide, 100R9913 White, 100W9927 Black, 100N9949
Gloss	Flat
Volume Solids	56.4%
Viscosity	45-50" Zahn 4
Recommended Film Thickness	4.4 - 8.8 Mils Wet 2.5 - 4.9 Mils Dry
Flash Point	105F° (40°C)
VOC	2.8 lbs. / gal. (336 g/L)
Weight / gallon	13.85 lbs. / gal.
Temperature Resistance	225°F
Shelf Life	2 years

### HINTS FOR BETTER PERFORMANCE

A clean substrate is necessary for optimal performance of the primer, as direct contact of primer and steel surface is required for rust inhibition and good adhesion. All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

Rev 04 / 2024

#### TERMS AND CONDITIONS OF SALE

While statements, technical information and recommendations contained herein are based on information our company believes to be reliable, nothing contained herein shall constitute any warranty, express or implied, with respect to the products and/or services described herein and any such warranties are expressly disclaimed. We recommend that the prospective purchaser or user independently determine the suitability of our product(s) for their intended use. No statement, information or recommendation with respect to our products, whether contained herein or otherwise communicated, shall be legally binding upon us unless expressly set forth in a written agreement between us and the purchaser/user. For all Terms and Conditions of Sale see [ergonarmor.com](http://ergonarmor.com).