

PRODUCT DESCRIPTION

Type	Rust inhibitive, weldable, modified alkyd universal primer.
Description	100-00 Series High Solids Universal Primer is a rust inhibitive primer designed to protect steel and iron substrates from corroding. It is low VOC, and HAPS compliant and contains no heavy metals. It is formulated to accept high performance topcoats such as epoxies, polyurethanes, solution acrylics, lacquers and other finish containing strong solvents.
Uses	<ul style="list-style-type: none"> • May be used to prime storage tanks, industrial plants, machinery and other steel that may be exposed to mild or moderate industrial environments. • May be used as a barrier coating over other primers or topcoats that may be subject to attack from strong solvents within subsequent topcoats.
Features	<ul style="list-style-type: none"> • Lead and chrome free • National VOC and HAPs compliant. • Meets or exceeds the performance requirements of SSPC Paint No. 15 & 25, TT-P-645, TT-P-664D, TT-P-636D, MPI #23 and MPI #79. • Fast drying • High film build

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. Prior to this procedure, the surface should be solvent cleaned per SSPC-SP1. For better performance, begin with SSPC-SP1 followed by 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 with mechanical agitation.
Thinning	Thinning is not normally needed. If needed add 560X3504 Xylene or 560X3611 n-Butyl Acetate to maintain reported HAPS.
Pot Life	n/a
Cleanup	Use Universal Flush Solvent (560X1301), or 560X3504 Xylene.

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.
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.

CURE TIME & RECOAT WINDOW

Substrate Temperature	To Touch	Tack Free	To Recoat	Full Cure
75°F (24°C)	15 minutes	½ hour	30' for alkyd topcoats; 2 hours for epoxy or polyurethane	7 days

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

PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
Inhibitive Shopcoat Primer	100x00xx series	5-gallon pails. 55-gallon drums
Theoretical Coverage	808 ft ² / 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 a few 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

High Solids Universal 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 High Solids Universal 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 100W0038 White</i>	
Colors	Black, 100N0020 Gray, 100D0031 Dark Gray, 100D0044 Red Oxide, 100R0027 White, 100W0038 Brite White, 100W0066
Gloss	Flat
Volume Solids	50.4%
Viscosity	33-40" Zahn 4
Recommended Film Thickness	4.0 – 9.0 Mills Wet 2.0 – 4.5 Mills Dry
Flash Point	45°F SETAFLASH
VOC	3.06 lbs. / gal. (367 g/L)
Weight / gallon	11.6 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.

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TERMS AND CONDITIONS OF SALE

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