



Structural Shopcoat Primers

100R0984 Red, 100D0985 Dark Gray

PRODUCT DESCRIPTION

Type Low gloss, rust inhibitive, weldable, structural steel shopcoat primer.

Structural Shopcoat Primers are fast drying, high solids, low gloss primers designed to protect steel and iron substrates from corroding prior to erection. These primers are VOC and HAPS compliant and contain no heavy metals. Their ease of application and environmental friendliness make them very desirable primers.

- Uses**
- Industrial shop applied applications such as structural steel and other commercial or architectural steel.
 - Inhibitive Shopcoat Primers are designed to protect steel and iron against atmospheric corrosion in mild industrial environments such as schools, metal buildings, shopping centers, etc.
 - Formulated to meet color and gloss requirements of metal building manufacturers.

- Features**
- Lead and chrome free
 - National VOC and HAPs compliant.
 - Meets or exceeds the performance requirements of SSPC Paint No. 15, TT-P-636, and listed with MPI #76.
 - Fast drying
 - National Rule VOC compliant

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.

Primer n/a

MIXING & THINNING

Ratio 1 - component

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

Thinning Thinning is not normally needed. If needed add 560X 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.

Pot Life n/a

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. For airless applications, a .015 - .019 airless tip is recommended.

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. Use caution when applying over 85% relative humidity.

CURE TIME & RECOAT WINDOW

Substrate Temperature	To Touch	Tack Free	To Recoat	Full Cure
75°F (24°C)	30 minutes	1 hour	2 hours for enamels, and 8 hours for 2-component epoxies and urethanes	7 days

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



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PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
Structural Shopcoat Primers	100x09xx series	5-gallon pails. 55-gallon drums

Theoretical Coverage 775 ft² / 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.

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
<i>Specific properties below are of 100D0985 Dark Gray</i>	
Colors	Dark Gray, 1000985 Red Oxide, 100R0984
Gloss	Low Gloss, 7-15 units
Volume Solids	48.3%
Viscosity	18 - 24" Zahn 4
Recommended Film Thickness	4.2 - 9 Mils Wet 2.0 - 4.3 Mils Dry
Flash Point	60F°
VOC	3.47 lbs. / gal. (417 g/L)
Weight / gallon	10.3 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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