



INDUSTRIAL CHOICE LOW VOC ALKYD ENAMEL PRIMER

DESCRIPTION AND USES

A general purpose, low VOC modified alkyd primer designed for interior and exterior surfaces.

Use on clean, abrasive-blasted, or lightly rusted steel in mild to moderate industrial environments. Use two coats of primer over abrasive-blasted or rusted steel. Not for use on galvanized steel.

PRODUCT

1-Gallon	Description
206308	Gray Primer

COMPANION PRODUCTS

RECOMMENDED TOPCOAT

Industrial Choice™ Low VOC Alkyd Enamels

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing surface with Pure Strength® Cleaner/Degreaser, item # 3599402, commercial detergent or other suitable cleaner. Mold and mildew areas must be cleaned with a chlorinated cleaner or bleach solution. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE 3) with a 1-2 mil (25-50 μ) surface profile is recommended for optimal performance. Abrasive blast clean steel requires two coats of primer.

NOTE: 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 adverse 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 additional information, contact the U.S. EPA/Lead Information Hotline at 1-800-424-LEAD.

APPLICATION

Apply only when the air and surface temperatures are between 32°-100° F (0°-38° C) and the surface temperature is at least 5° F (3° C) above the dew point. Abrasive blast clean steel requires two coats of primer.

PRODUCT APPLICATION (CONTINUED)

EQUIPMENT RECOMMENDATIONS

BRUSH: Use a good quality natural or synthetic bristle brush.

ROLLER: Use a good quality natural or synthetic cover. Use a short nap roller for smooth surfaces, and a medium nap roller for rough surfaces.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomizing Pressure
Pressure	0.055 –.070	16 oz/min	25–60 psi
Siphon	0.055 –.070	–	25–60 psi
HVLP (various)	0.043 –.070	8–14 oz/min	60–90 psi*

*(10 psi maximum at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600–2400 psi	0.013–.017	100

THINNING

BRUSH/ROLLER: Normally not required.

AIR-ATOMIZED SPRAY: 333402 Thinner – Use up to 15% by volume.

AIRLESS SPRAY: 333402 Thinner normally not required. If needed use up to 5% by volume.

CLEAN UP

633402 Thinner or Mineral spirits.

PERFORMANCE CHARACTERISTICS

PENCIL HARDNESS

METHOD: ASTM D3363
RESULT: 3B

CONICAL FLEXIBILITY

METHOD: ASTM D522
RESULT: >33%

CYCLIC PROHESION

METHOD: ASTM D5894, 3 Cycles, 1008 hours
RESULT: 10 ASTM D714 for blistering
8 ASTM D610 for rusting

IMPACT RESISTANCE-Direct/Reverse

METHOD: ASTM D2794
RESULT: 100/<8

TABER ABRASION

METHOD: ASTM D4060, CS17 Wheels
500g load, 1000 cycles
RESULT: 75.5 Mg. loss

For chemical and corrosion resistance see page 4 of the Rust-Oleum Industrial Brands Catalog Form #206275.

PHYSICAL PROPERTIES

		GRAY PRIMER
Resin Type		Oil Modified Alkyd
Pigment Type		Phosphosilicate
Solvents		Aliphatic Hydrocarbons
Volatile Organic Compounds		< 340 g/L (2.8 lbs./gal.)
Weight Per Gallon	Per Gallon	12.1 lbs.
	Per Liter	1.45 Kg
Solids	By Weight	77.4%
	By Volume	58.0%
Recommended Dry Film Thickness (DFT) Per Coat		1.0–2.0 mils (25.0–50.0 µ)
Wet Film to Achieve DFT (unthinned material)		2.0–3.5 mils (50.0–87.5 µ)
Theoretical Coverage at 1 mil DFT (25 µ)		930 sq. ft./gal. (22.9 m²/L)
Practical Coverage at Recommended DFT (assumes 15% material loss)		400–800 sq. ft./gal. (9.8–19.6 m²/L)
Dry Times at 70°–80° F (21°– 27° C) and 50% Relative Humidity	Tack-free	2–4 hours
	Handle	6–8 hours
	Recoat	16–24 hours
Dry Heat Resistance		212° F (100° C)
Shelf Life		5 years
Specification and Performance Alternatives		USDA acceptable
Safety Information	Flash Point	104° F (40° C)
	Contains	Lead-free
	Warning!	COMBUSTIBLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT, EYE AND SKIN IRRITATION. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT MATERIAL SAFETY DATA SHEET (MSDS) AND LABEL WARNINGS FOR ADDITIONAL SAFETY INFORMATION.

Calculated values are shown and may vary slightly from the actual manufactured material.

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