



# INDUSTRIAL PRIMER

*K0002 Series*

Industrial Primer is a heavy-duty primer that offers good protection for steel in normal industrial environments. This product is a high-solids primer.

- ✓ Can be topcoated with alkyd and latex coatings
- ✓ Interior and exterior use
- ✓ Fast drying

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

- |   |   |
|---|---|
| <input checked="" type="checkbox"/> OTC | <input type="checkbox"/> UTAH             |
| <input checked="" type="checkbox"/> EC  | <input checked="" type="checkbox"/> LADCO |
| <input type="checkbox"/> SCAQMD         | <input type="checkbox"/> CARB             |

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

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## RECOMMENDED USES

For industrial and commercial applications to steel & iron to protect against atmospheric corrosion.

## SPECIFICATIONS

### Steel, Alkyd Topcoat:

1 coat Industrial Primer @ 2 - 3 mils dft/ct  
1-2 coats Tough Coat® Alkyd Enamel, @ 2-3 mils dft/ct.

### Steel, Aluminum Finish:

1 coat Industrial Primer @ 2 - 3 mils dft/ct  
1 coat Tough Coat® Alkyd Enamel, Aluminum @ 1 mil dft/ct

### Steel, Water-Based, Acrylic Topcoat:

1 coat Industrial Primer @ 2 - 3 mils dft/ct  
2 coats Iron Guard™ Water-Based Acrylic Enamel (K110 Series)@ 2.5 - 4.0 mils dft/ct

### Steel, Acrylic Alkyd Topcoat:

1 coat Industrial Primer @ 2 - 3 mils dft/ct  
2 coats Rust Tough Alkyd @ 2 mils dft/ct

## SURFACE PREPARATION

Surfaces must be dry and in sound condition. Remove oil, dust, dirt, loose rust, loose mill scale or other contamination to ensure good adhesion.

For maximum performance, the surface must be abrasive blasted for proper adhesion. All blasted steel must be primed the same day.

Iron and Steel: Remove all grease and oil from the surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Hand Tool Clean per SSPC-SP2. For optimum performance, the surface should be cleaned to Commercial Blast Clean per SSPC-SP6.

## CLEAN UP

Clean spills, spatters and tools immediately with VM&P Naptha or Mineral Spirits. Follow manufacturer's safety recommendations when using any solvents.

## TECHNICAL DATA

<b>Finish</b>	Flat (<10 units @ 60°)
<b>Colors</b>	Red and Gray
<b>Curing Mechanism</b>	Solvent Evaporation Oxidation
<b>Shelf Life</b>	36 months, unopened, at 77°F
<b>Drying Schedule</b>	@ 77°F @ 50% RH:
<b>To touch</b>	15 minutes
<b>To handle</b>	1 1/2 hours
<b>To recoat</b>	7 hours
	<b>Note:</b> Drying time is temperature, humidity, and film thickness dependent.
<b>Flash Point</b>	
Red	95°F (Pensky-Martens/Seta Flash)
Gray	93°F (Pensky-Martens/Seta Flash)
<b>Viscosity</b>	70 - 76 KU
<b>Volume Solid</b>	(Red/Gray): 55% ± 2%
<b>Weight Solid</b>	(Red/Gray): 77% ± 2%
<b>Weight Gallon</b>	Red: 12.60 ± 2% Gray: 12.38 ± 2%
<b>Rec. Spread Rate</b>	3.6 - 5.5 mils wet, 2.0 - 3.0 mils dry
<b>Coverage</b>	441 - 294 sq. ft/gal approximate
<b>VOC</b>	Less than 340 g/L; 2.84 lb/gal

## APPLICATION

**Temperature** (air, surface and material)  
40°F min. 120°F max.  
at least 5°F above dew point

**Important** Primer coats used for exterior applications should not be left untopcoated in excess of six months.

**Methods** Airless Spray, Conventional Spray, and Brush

### Airless Spray

Pressure 1800 - 1300 psi

Hose 1/4"

Tip: .015" - .019"

Filter: 60 mesh

Reduction: None

### Conventional Spray

Gun Binks

Model 18;

Fluid Nozzle 63C;

Air Nozzle 63PB;

Atomization Pressure 50 psi;

Fluid Pressure 15 - 20 psi;

Reduction Reduce up to 5% by volume with Mineral Spirits or VM&P Naphtha as necessary to be compatible with the existing application and environmental conditions.

**Brush** China Bristle; confined to small areas or touch-up

**Roller** Not recommended

**Note:** If specific application equipment is listed above, equivalent equipment may be substituted.

**Mixing Instructions** Mix paint thoroughly by boxing and stirring or mechanically agitate for uniformity and consistency.

## CAUTIONS

Thoroughly review product label and SDS for safety and cautions prior to using this product. Please direct any questions or comments to your local Krylon Industrial Representative.



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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.