



# Protective & Marine Coatings

## STEEL SPEC™ SHOPCOAT PRIMER

B50A53  
B50R57

GRAY  
RED

Revised: May 1, 2019

### PRODUCT INFORMATION

2.55

#### PRODUCT DESCRIPTION

**STEEL SPEC SHOPCOAT PRIMER** is an all purpose rust inhibitive interior/exterior alkyd shop coat primer for topcoating with conventional alkyd or acrylic coatings. It offers outstanding protection during shipping and handling. Conforms to CISC/CPMA Standards 1-73a and 2-75.

- Contains no HAPS

#### PRODUCT CHARACTERISTICS

Finish:	Flat
Color:	Gray and Red
Volume Solids:	39% ± 2%, may vary by color
Weight Solids:	63% ± 2%, may vary by color
VOC:	<440 g/L; 3.7 lb/gal

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils:	4.0	6.5
Dry mils:	1.5	2.5
~Coverage sq ft/gal:	250	416
Theoretical coverage sq ft/gal @ 1 mil dft	624	

Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

#### Drying Schedule @ 4.0 mils wet @ 50% RH:

	@ 40°F	@ 77°F	@ 120°F
To touch:	15 minutes	10 minutes	5 minutes
Tack-Free:	15 minutes	15 minutes	15 minutes
Dry-Hard:	45 minutes	25 minutes	20 minutes
To handle:	3 hours	2 hours	1 hour
To recoat:	6 hours	2 hours	1 hour
To cure:	4 days	2 days	2 days

If maximum recoat time is exceeded, abrade surface before recoating.  
Drying time is temperature, humidity, and film thickness dependent.

Shelf Life:	36 months, unopened Store indoors at 40°F to 100°F.
Flash Point:	103°F, PMCC
Clean Up:	Mineral Spirits or VM&P Naphtha

#### RECOMMENDED USES

For architectural / light commercial construction application on steel to protect against atmospheric exposure.

According to AISC, shop coat primers are intended for protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating.

Not recommended for immersion service or exposure to acids or alkalis.

#### PERFORMANCE CHARACTERISTICS

**Substrate\*:** Steel

**Surface Preparation\*:** SSPC-SP6

**System Tested\*:**

1 ct. STEEL SPEC Shopcoat Primer @ 1.5 mils dft

\*unless otherwise noted below

Test Name	Test Method	Results
Flame Spread Rating	ASTM E84	Flame Spread Index - 5; Smoke Density Index - 0
Humidity Resistance	ASTM D4548, 96 hours	Rating 10 per ASTM D714 for blistering; Rating 10 per ASTM D610 for rusting
Immersion	96 hours fresh water	Passes, no rusting, blistering, or loss of adhesion
Salt Fog Resistance	ASTM B117, 75 hours	Rating 10 per ASTM D714 for blistering; Rating 10 per ASTM D610 for rusting

Complies with USDA requirements for use in federally inspected meat and poultry plants on structural, non-food contact or incidental food contact.

Meets the requirements of SSPC Paint 15



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#### RECOMMENDED SYSTEMS

Dry Film Thickness / ct.  
Mils

##### Steel:

1 ct.\* STEEL SPEC Shopcoat Primer 1.5 - 2.5

\*Refer to manufacturer's specified surface preparation for any subsequent coats.

#### SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

##### Do not use hydrocarbon solvents for cleaning.

Minimum recommended surface preparation:

Iron & Steel: SSPC-SP1 or SSPC-SP2/3  
Aluminum: SSPC-SP2  
Concrete & Masonry: SSPC-SP13/NACE 6  
Wood, interior: Clean, smooth, dust free

##### Surface Preparation Standards

Condition of Surface		ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Pitted & Rusty	C St 2	C St 2	SP 2	-
	Rusty	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Pitted & Rusty	C St 3	C St 3	SP 3	-
		D St 3	D St 3	SP 3	-

#### TINTING

Do not tint.

#### APPLICATION CONDITIONS

Temperature: 40°F minimum, 120°F maximum  
(air, surface, and material)  
At least 5°F above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

#### ORDERING INFORMATION

Packaging: 5 gallon pails and 53 gallon drums

Weight per gallon: 10.70 ± 0.2 lb, may vary by color

#### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

#### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

#### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.



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## APPLICATION BULLETIN

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### SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

#### Iron & Steel

Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3, blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

#### Previously Painted Surfaces

If in sound condition, clean the surface of all foreign material. Smooth, hard, or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, or if this product attacks the previous finish, removal of the previous coating may be necessary. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface as above.

### APPLICATION CONDITIONS

Temperature: 40°F minimum, 120°F maximum  
(air, surface, and material)  
At least 5°F above dew point

Relative humidity: 85% maximum

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

**Clean Up** ..... Mineral Spirits or VM&P Naphtha

#### Airless Spray

Unit ..... 1 Pump  
Pressure ..... 2800 psi  
Hose ..... 3/8" ID  
Tip ..... .013" - .017"  
Filter ..... 60 mesh  
Reduction ..... Not recommended

#### Conventional Spray

Gun ..... Binks  
Fluid Tip ..... 63C  
Air Nozzle ..... 63PB  
Atomization Pressure ..... 50 psi  
Fluid Pressure ..... 15-20 psi  
Reduction ..... Not recommended

#### HVLP

Air Pressure ..... 10-12 psi  
Fluid Pressure ..... 6-8 psi  
Reduction ..... Not recommended

#### Brush

Brush ..... Nylon/Polyester Natural Bristle  
Reduction ..... Not recommended

#### Roller

Cover ..... 1/4-3/8" woven with solvent resistant core  
Reduction ..... Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

#### Surface Preparation Standards

Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
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Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	CS 2	CS 2	SP 2	-
Pitted & Rusty	CS 2	CS 2	SP 2	-
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### APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

**Mixing Instructions:** Mix paint thoroughly by boxing and stirring before use.

Apply paint at the recommended film thickness and spreading rate as indicated below:

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
<b>Wet mils:</b>	<b>4.0</b>	<b>6.5</b>
<b>Dry mils:</b>	<b>1.5</b>	<b>2.5</b>
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Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

#### Drying Schedule @ 4.0 mils wet @ 50% RH:

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<b>To recoat:</b>	6 hours	2 hours	1 hour
<b>To cure:</b>	4 days	2 days	2 days

*If maximum recoat time is exceeded, abrade surface before recoating.  
Drying time is temperature, humidity, and film thickness dependent.*

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

### CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Mineral Spirits or VM&P Naphtha. Clean tools immediately after use with Mineral Spirits or VM&P Naphtha. Follow manufacturer's safety recommendations when using any solvent.

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### PERFORMANCE TIPS

Stripe coat crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. If possible, plan painting schedules to avoid these influences during the first 16-24 hours of curing.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Excessive reduction of material can affect film build, appearance, and adhesion.

Always test adhesion by applying a test patch of 2-3 square feet. Allow one week to dry before checking adhesion.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Mineral Spirits or VM&P Naphtha.

**Do not use hydrocarbon solvents for cleaning.**

Refer to Product Information sheet for additional performance characteristics and properties.

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