



General Industrial Coatings

CC-A101

Shopcoat Primer

Gray..... E61AC82 Red Oxide E61RC21 Custom Blend Series E61XX

DESCRIPTION

Shopcoat Primers are economical, fast drying alkyd primers offering field corrosion protection on iron and steel.

Advantages:

- Fast drying
- Fast recoat with aliphatic solvent alkyd enamels
- Apply by spray or dip

CHARACTERISTICS

(may vary by color)

Gloss: Flat

Volume Solids: 39 ± 2%

Viscosity:
40-55 secs., #4 Zahn Cup
45-75 secs., #2 Zahn Cup

Recommended Film Thickness:
Mils Wet 2.7-4.5
Mils Dry 1.0-1.75

Spreading Rate (no application loss):
362-635 ft.²/gal. at 1.0-1.75 mils DFT
as supplied

Cure: Air Dry

Substrate Disclaimer: Curing of coating at temperatures higher than the heat distortion parameters of the substrate may cause substrate issues.

Drying: 1.25 mils DFT at 77° F, 50% RH
To Touch 5-10 minutes
Tack Free 15-30 minutes
To Handle 10-15 minutes
To Recoat 30 minutes

Flash Point (Pensky Martens Closed Cup): 50° F

Air Quality Data:

- Non-photochemically reactive
- Volatile Organic Compounds (VOC)*
Theoretical as packaged, maximum, less exempt solvents: 3.9 lb/gal, 467 g/L

Package Life:

E61AC82 2 years, unopened
E61RC21 18 months, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

Aluminum: If untreated, prime with Industrial Wash Primer P60G2, RoHS Compliant Wash Primer P60G10 or Kem Aqua® Wash Primer E61G522.

Galvanized Steel: If untreated, prime with Industrial Wash Primer P60G2, RoHS Compliant Wash Primer P60G10 or Kem Aqua Wash Primer E61G522.

Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.

*VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

APPLICATION

Typical Setups

Reducers: R1K3 (VM&P Naphtha)
R1K4 (Mineral Spirits)
Reduction: As needed up to 25% (vol.)

May be applied by: Airless Spray
Dip Coating
Conventional Spray
Air Assisted Airless Spray
Electrostatic Spray
HVLP Spray

Airless Spray:

Pressure 2,000-2,500 psi
Tip 0.017-0.019 in.

Dip Coating (small dip tanks only):

Reducer 10-20% (vol.) of 4:1 blend
R2K5 (Hi-Flash Naphtha) &
R1K4 (Mineral Spirits)

Designed for small dip tanks. Tank maintenance, including agitation, turnover rate, viscosity control and stability are required for trouble-free operation.

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup:

Clean tools/equipment immediately after use with R2K5 (Hi Flash Naphtha 100) or R1K4 (Mineral Spirits).

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. A minimum of 1.0 mil DFT is required. Films of 1.25-1.75 mils offer optimum corrosion protection.
2. Do not topcoat with lacquers, polyurethanes, epoxies or alkyds containing strong solvents (xylene, toluene, MEK, etc.).
3. This primer may exhibit lifting or have a critical recoat when topcoated with alkyds containing strong solvents (xylene, toluene, MEK, etc.). User should test for intercoat adhesion and lifting.
4. On sand blasted surfaces, apply sufficient film thickness to protect the blast profile. This is typically 1.0 mil more than the blast profile. Multiple coats may be required.
5. Do not apply at temperatures below 40° F
6. Compatible with Phoenix®, Opticolor® Express and GIS Colorants.

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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