



Protective & Marine Coatings

STEEL SPEC™ WATERBASED SHOPCOAT PRIMER

RED OXIDE
GRAY
COIL GRAY
COIL RED

B66R583
B66A580
B66AW580
B66RL585

Revised: January 14, 2021

PRODUCT INFORMATION

2.56

PRODUCT DESCRIPTION

STEEL SPEC WATERBASED SHOPCOAT PRIMER is a fast drying, water reducible primer designed for the steel fabricator market. It is intended as a general application product with quick dry-to-touch and dry-to-handle times that allow for quick turnaround in the shop. It is easy to apply by spray application and provides excellent coverage over bare steel.

PRODUCT CHARACTERISTICS

Finish:	Flat
Color:	Red Oxide, Gray, Coil Gray, and Coil Red
Volume Solids:	34% ± 2%, may vary by color
Weight Solids:	41% ± 2%, may vary by color
VOC:	<250 g/L; 2.08 lb/gal

Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet mils:	3.0	4.5
Dry mils:	1.25	1.75
~Coverage sq ft/gal:	310	435
Theoretical coverage sq ft/gal @ 1 mil dft	544	

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:	30 minutes	10 minutes	10 minutes
Tack-Free:	5 hours	45 minutes	45 minutes
Dry-Hard:	6 hours	2 hours	1 hour
To handle:	7 hours	2.5 hours	1.5 hours
To recoat:	10 hours	2.5 hours	1.5 hours

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

Shelf Life:	12 months, unopened at 77°F Protect from freezing
Flash Point:	N/A
Reducer/Clean Up:	Water If Dried, clean with a blend of ammonia and water 1:9. Spray equipment may also be cleaned with MIBK. After Cleaning, flush equipment with solvent to prevent rusting.

RECOMMENDED USES

For industrial and commercial application to steel to protect against atmospheric corrosion.

- Interior and exterior use
- Fast drying maintenance primer
- Excellent turnaround times in the shop

PERFORMANCE CHARACTERISTICS

- Water reducible acrylic latex
- Low odor - improves working conditions
- Good corrosion resistance
- Primer that may be used under a variety of topcoats
- Free of lead and chromate hazards
- Use water for reduction and cleanup
- Lowers V.O.C. emissions and clean up thinner hazards

LIMITATIONS

- High humidity will slow drying
- Excessive film thickness may cause mudcracking
- Due to the wide variety of substrates, surface preparation methods and application methods and environments, the full system should be tested for adhesion and compatibility prior to full scale application.

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, alkalis, or strong solvents.



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SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, fingerprints and other foreign material 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 using a non-hydrocarbon solvent per SSPC-SP1. Minimum surface preparation is Hand Tool Clean per SSPC-SP2. For optimum performance, the surface should be blast cleaned to Commercial Blast Clean per SSPC-SP6.

APPLICATION CONDITIONS

Temperature: 55°F minimum, 100°F maximum
(air, surface, and material)
Relative humidity: At least 5°F above dew point
85% maximum

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

APPLICATION METHODS

Airless Spray, Conventional, and Brush

Airless Spray:
Unit: 1500 - 2100 psi
Tip: .011 - .013
Filter: 60 Mesh
Hose: 1/4"

Conventional:
Air Pressure: 45-55 psi
Fluid Pressure: 10-15 psi
Cap/Tip: 704FF
Reducer: Water
Reduction Rate: Up to 10%

Brush:
Confine to small areas and touch-up.

Do not over-reduce. Water reducible coatings spray easier at high viscosity than solvent reducible products.

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.

CAUTIONS

Refer to MSDS Sheet before use.

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

NOTE: This product should not be used under high performance topcoats, i.e. epoxies and polyurethanes. Alkyd or oil-based topcoats should be checked for compatibility prior to application.

Steel-Spec Water based Primer is extremely sensitive to hydrocarbon containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon solvents.

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

Stripe coat all crevices, welds, and sharp edges to protect against early failure in these areas. For best results on rusty surfaces, always apply first coat by brush. No painting should be done immediately after a rain or during foggy weather.

Do no use hydrocarbon solvents for cleaning.

SAFETY PRECAUTIONS

Refer to the SDS 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.