

GALVANIZED METAL PRIMER

K00024000

Product Data Sheet

KRYLON

INDUSTRIAL
COATINGS™

DESCRIPTION

Galvanized Metal Primer is a solvent-based, acrylic coating with low VOC. It is intended for use in mild industrial and commercial environments. It may be used untopcoated or topcoated with select waterborne or solvent-based coatings.

ADVANTAGES

- Excellent adhesion to galvanized and aluminum surfaces
- High light reflectance
- Early moisture resistance
- Good acid and alkali resistance
- Acceptable for use in federally inspected meat and poultry plants.

RECOMMENDED USES

For use over prepared:

- Galvanized steel
- Primed ferrous metal
- Galvalume
- Zinc-rich primers

Examples:

- Joists
- Metal deck ceiling
- Railings
- Ducts
- Conduits

SPECIFICATIONS

Galvanized Metal or Aluminum, Interior:

1-2 cts. Galvanized Metal Primer (K00024000)
@ 3.0 - 4.5 mils dft/ct

Galvanized Metal or Aluminum, Exterior:

2 cts. Galvanized Metal Primer (K00024000) @ 3.0 - 4.5 mils dft/ct

Galvanized Metal or Aluminum:

1 ct. Galvanized Metal Primer (K00024000) @ 3.0 - 4.5 mils dft/ct
2 cts. Industrial Alkyd Enamels (K0053) Series
@ 2.0 - 4.0 mils dft/ct or Dry Fall Paints

SURFACE PREPARATION

Surfaces must be clean, dry, and in sound condition. Remove all oil, grease, dirt, loose rust, visible contaminants, peeling paint, and other foreign material. Always remove contaminants before applying subsequent coats.

Aluminum: Remove all oil, grease, dirt, oxide and other foreign material by Solvent Cleaning per SSPC-SP1.

New Galvanized Metal: Allow to weather a minimum of six months prior to coating. Remove grease, oil, dirt, soil, drawing compounds, and other contaminants by use of solvents, emulsions, cleaning compounds, or steam cleaning per SSPC-SP1. If weathering is not possible or if the metal has been treated with chromates or silicates, first Solvent Clean per SSPC-SP1 and apply a test patch (minimum area of 2 square feet) and allow to dry for at least one week before testing adhesion. If adhesion is unacceptable, Brush-Off Blasting per SSPC-SP7 or NACE 4 is required to remove these treatments.

SURFACE PREPARATION cont.

Old Galvanized Metal: If metal is covered with white powder (white rust) and there is little or no rusting, Solvent Clean per SSPC-SP1. If zinc surface has weathered away and general rusting is taking place, Hand Tool Clean per SSPC-SP2, and spot prime only the rusted areas.

Factory Finished Interior Metal Roof Deck: This surface may be hard and slick and prohibit adequate adhesion. Spot test. Solvent Clean per SSPC-SP1 and apply a test patch of Galvanized Metal Primer. Allow paint to dry at least one week before testing adhesion. Be sure decking manufacturer certifies it is paintable. If adhesion is poor, Hand Tool Clean per SSPC-SP2 or Brush Blast per SSPC-SP7.

APPLICATION

APPLICATION CONDITIONS

Temperature: 40°F minimum, 100°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 compatible with the existing environmental and application conditions.

Reducer/Clean-up: Below 80°F: Xylene (166-1530)

Above 80°F: Aromatic Naphtha (Hi-Flash) (166-4659)

Airless Spray: Pressure: 2400 psi; Hose: 1/4" ID; Tip: .015"
Filter: 60 mesh; Reduction: As needed, up to 3% by volume

Conventional Spray: Gun: Binks 95; Fluid Nozzle: 63A; Air Nozzle: 63PB; Atomization Pressure: 50 psi; Fluid Pressure: 15 psi;
Reduction: As needed, up to 3% by volume

Brush: Nylon/Polyester; reduction not recommended

Roller: 3/8" nap synthetic or lambswool; reduction not recommended

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

APPLICATION PROCEDURES

- Surface preparation must be completed as indicated.
- Mix paint thoroughly by boxing and stirring before use.
- Apply paint at the recommended film thickness and spreading rate as indicated.

PERFORMANCE TIPS

- Stripe coat all 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.
- 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.

CHARACTERISTICS

FINISH: Flat

COLOR: Off White

VOLUME SOLIDS: 63% ± 2%

WEIGHT SOLIDS: 81% ± 2%

VOC (EPA Method 24):

Unreduced: 312 g/L; 2.60 lb/gal

Reduced 3%: 335 g/L; 2.79 lb/gal

SHELF LIFE: 36 months, unopened, at 77°F

RECOMMENDED SPREADING RATE:

Wet mils: 4.8 - 7.1; Dry mils: 3.0 - 4.5

Coverage: 337 - 225 sq/ft @ 100% utilization

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

DRYING SCHEDULE @ 50% RH @ 5.0 MILS WET:

	@ 40°F	@ 77°F	@ 100°F
To touch:	8-10 hours	1 hour	15 minutes
To handle:	16 hours	3 hours	30 minutes
To recoat:	24 hours	4.5 hours	1 hour
To cure:	21 days	14 days	7 days

Note: Drying time is temperature, humidity, and film thickness dependent.

FLASH POINT: 100°F, PMCC

Reducer/Clean-up: Below 80°F: Xylene, (K01661530)

Above 80°F: Aromatic Naphtha, (Hi-Flash) (K01664659)

PERFORMANCE TESTS

System Tested: (unless otherwise stated)

Substrate: Galvanized Steel

Surface Preparation: SSPC-SP1

Finish: 1 ct. Galvanized Metal Primer @ 3.0 mils dft

Abrasion Resistance: Method: ASTM D4060, CS17 wheel, 1000 cycles, 1 kg load; Result: 265 mg loss

Adhesion: Method: ASTM D4541; Result 325 psi

Direct Impact Resistance: Method: ASTM G14; Result: 80 in lb

Dry Heat Resistance: Method: ASTM D2485; Result: 275°F

Exterior Durability: Method: 1 year, 45° South; Result: Excellent

Flexibility: Method: ASTM D522, 180° bend, 1/8" mandrel; Result: Passes

Moisture Condensation Resistance: Method: ASTM D4585, 100°F, 500 hours; Result: Good-Excellent

Pencil Hardness: Method: ASTM D3363; Result: 5B

Salt Fog Resistance: Method: ASTM B117, 500 hours; Result: Fair

Thermal Shock: Method: ASTM D2246, 15 cycles; Result: Passes

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

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