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TECHNICAL DATA
P-20 PRIMER

COATING DATA

DESCRIPTION:

A high solids, low VOC, low HAPS, spray application industrial primer which is tolerant of poorly prepared surfaces. P 20 Primer will dry rapidly and give excellent corrosion protection. P 20 Primer is formulated free of lead, mercury, chromates and other toxic pigments.

USE:

Use as the primer for structural steel or tankage which will be subjected to normal industrial environments. May be used as a shop primer or for industrial maintenance applications

PERFORMANCE:

PANEL: Steel SYSTEM: One coat Induron P-20 Primer @ 2.0 mils Dry Film Thickness.
PREPARATION: SSPC-SP 6 Commercial Blast

TEST	METHOD/CONDITIONS	DURATION	RESULTS
Flexability	1/4" Mandrel		Pass
Salt Spray	ASTM B 117	500 hours	< 1/8" Undercutting at scribe
Cross Hatch Adhesion	ASTM D 3359B	5B No Failure	

RECOATABILITY:

This product may be recoated after three hours with Induron alkyd finishes. If exposed to weather for 30 days or more, surface must be abraded.

LIMITATIONS:

Not suitable for immersion service or strong chemical environments. Not for use at temperatures above 200°F (93°C).

SURFACE PREPARATION:

Steel (Non Immersion)—Remove all surface contaminants including rust, dirt, grease, water, and mill scale. Minimum surface preparations are either SSPC-SP 2 Hand Tool Cleaning or SSPC-SP 3 Power Tool Cleaning. If metal surfaces are sandblasted, use sufficient paint to provide a dry film which will cover the blast profile. **Note:** Service life is directly proportional to the quality of the surface preparation.

COVERAGE:

642 ft² per gallon at 1.0 mil dry film thickness.

DRY FILM THICKNESS:

1.0 to 2.5 mils dry.

WET FILM THICKNESS:

2.0 to 4.8 mils.

APPLICATION DATA

APPLICATION:

Airless Spray—Use .015-.017 tip; 60 mesh filter; 30:1 pump ratio at 50-80 operating air pressure. **Conventional Spray**—Follow the instructions of equipment manufacturer for the application of alkyd paints. **Roller**—Not recommended. Limit to very small areas for touch-up. **Brush**—Not recommended. Limit to very small areas for touch-up.

THINNING:

Not normally required. If necessary, thin up to 10% by volume with Induron K-1113 Reducer.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid condensation occurring on wet paint.

DRY TIME:

TO HANDLE—30 minutes at 80°F.

TO RECOAT—3 hours at 80°F.

Note: High film thickness, low temperature, and/or poor ventilation will retard dry time.

PHYSICAL DATA:

VOLUME SOLIDS: 52% ± 1%

SOLIDS BY WEIGHT: 71% ± 1%

WEIGHT PER GALLON: 11.7 ± .2 lbs/gallon mixed

VOLATILE ORGANIC COMPOUNDS:

Unthinned - < 3.5 lbs/gallon; < 420 grams/liter

Thinned 10% - < 3.8 lbs/gallon; < 450 grams/liter

HAZARDOUS AIR POLLUTANTS (HAPS):

Thinned or Unthinned - 1.7 lbs/gallon solids; 204 grams/liter solids

SAFETY DATA:

See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request. 20