

**6100 SYSTEM
SHOP COAT PRIMER**

DESCRIPTION AND USES

A fast-dry, low VOC modified alkyd shop coat primer. Use on clean, abrasive-blasted, or lightly rusted steel in mild to moderate industrial environments. Use two coats of primer over abrasive-blasted or rusted steel. Not for use on galvanized steel.

PRODUCTS

1-Gallon	5-Gallon	Description
206329	206330	Red Primer
206331	206332	Gray Primer

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® Original Cleaner Degreaser or other suitable cleaner. Mold and mildew areas must be cleaned with a chlorinated cleaner or bleach solution. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE 3) with a 1-2 mil (25-50µ) surface profile is recommended for optimal performance. Abrasive blast cleaned steel requires two coats of primer

PRODUCT APPLICATION

APPLICATION

Apply only when the air and surface temperatures are between 32-100°F (0-38°C) and the surface temperature is at least 5°F (3°C) above the dew point.

EQUIPMENT RECOMMENDATIONS

BRUSH: For touch up only. Use a good quality natural or synthetic bristle brush.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomization
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP (var.)	0.043-0.070	8-14 oz./min.	60-90 psi*

*(10 psi maximum at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600-2400 psi	0.013-0.017	100

THINNING

BRUSH: Normally not required.

AIR-ATOMIZED SPRAY: 333402 Thinner—Use up to 20% by volume.

AIRLESS SPRAY: 333402 Thinner normally not required. If needed use up to 5% by volume.

CLEAN UP

633402, 333402 Thinners or mineral spirits.

TECHNICAL DATA

6100 SYSTEM SHOP COAT PRIMER

PHYSICAL PROPERTIES

		SHOP COAT PRIMER
Resin Type		Oil Modified Alkyd
Pigment Type		Magnesium Silicate, Calcium Carbonate
Solvents		Aliphatic Hydrocarbons
Weight	Per Gallon	13.3-13.6 lbs.
	Per Liter	1.60-1.63 kg
Solids	By Weight	79.0-79.6%
	By Volume	57.8%
Volatile Organic Compounds		<340 g/l (2.8 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5 μ)
Wet Film to Achieve DFT (unthinned material)		2.5-4.5 mils (62.5-112.5 μ)
Theoretical Coverage at 1 mil DFT (25μ)		930 sq.ft./gal (22.9 m ² /l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		315-525 sq. ft./gal. (7.7-12.9 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	Tack-free	15-30 minutes
	Handle	1 hour
	Recoat	4 hours
Dry Heat Resistance		212°F (100°C)
Shelf Life		5 years
Safety Information		For additional information, see SDS

Calculated values are shown and may vary slightly from the actual manufactured material.

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