



Heavy Duty Inhibitive Primers
100R9913 Red
100D9914 Gray

PRODUCT DESCRIPTION

99-Series Heavy Duty Inhibitive Primers are high solids, rust inhibitive primers designed to protect steel and iron substrates from corroding prior to erection. Heavy Duty Inhibitive Primers are VOC and HAPS compliant and contain no heavy metals. These primers contain a high level of inhibitive pigment to increase corrosion resistance, thereby extending exposure time before topcoating becomes necessary. The primers of choice for long-term protection.

Recommended Use: Heavy Duty Inhibitive Primers are intended for use where exterior exposure, prior to erection and enclosure, may exceed three months, or where the exposure life may be unpredictable. They are recommended for use in humid environments such as coastal areas. For long-term exterior exposure, topcoat with a quality alkyd enamel.

99-Series Heavy Duty Inhibitive Primers meet or exceed the performance requirements of SSPC Paint No. 25, SSPC Paint No. 15 and TT-P-636.

PERFORMANCE PROPERTIES

System Tested:

Substrate: Steel
 Surface Preparation: SSPC-SP6
 1 ct. Inhibitive Primer @ 2 mils dft

Adhesion:

Method: ASTM D4541 Type II
 Result: 7-day cure: Passes 250 lbs/sq in

Pencil Hardness:

Method: ASTM D3363
 Result: 7-day cure: HB-F

Direct Impact Resistance:

Method: ASTM G14
 Result: 24-hour cure: Passes 90 lbs/sq in
 7-day cure: Passes 90 lbs/sq in

Flexibility:

Method: ASTM D522
 Result: 24-hour cure: Passes 1/8" bend
 7-day cure: Passes 1/8" bend

Humidity Resistance:

Method: ASTM D4585
 Result: Passes 120 hours @ 100°F
 Moderate lightening and no blistering.

Dry Heat Resistance:

Method: ASTM D2485 Method A
 Result: Passes 200°F

Salt Spray Resistance:

Method: ASTM B117
 Result: Passes 500 hours

Thermal Shock:

Method: ASTM D2246 – 5 cycles
 Result: Passes

TECHNICAL INFORMATION

Gloss: Flat 0 – 5 units @ 60° Maximum
Use: Protective / Decorative
Color: Red and Gray
Recommended Film Thickness: 2.0 – 4.0 Mils Dry
 3.6 – 7.3 Mils Wet
Spread Rate: 440 – 220 sq ft/gal
 @ Recommended Dry Film – No Loss
Dry Time: @ 4.5 Mils Wet
 @ 77°F (25°C) & 50% Relative Humidity
 To Touch: 30 minutes
 Tack Free: 2 hours
 To Handle: 3 hours
 To Topcoat: Overnight or 8 hours

Drying times are dependent upon film thickness, temperature and humidity.

Flash Point: 105°F (40°C) SETAFLASH

Viscosity: 85 – 95 KU @ 77°F (25°C)

VOC: 100R9913 2.90 lbs/gal (348 g/l)
 100D9914 2.87 lbs/gal (344 g/l)

#HAPS / Gal Solids: 100R9913 0.126
 100D9914 0.127

Solids By Volume: 100R9913 54.90 ± 2%
 100D9914 55.33 ± 2%

Solids By Weight: 100R9913 77.31 ± 2%
 100D9914 77.56 ± 2%

Weight Per Gallon: 100R9913 12.80 lbs
 100D9914 12.82 lbs

Shelf Life: Two years unopened from date of manufacture.

Reducer: 560X3502 (VM&P Naphtha) or
 560X0194 (Mineral Spirits) if
 slower flash-off time is desired.

Clean Up: 560X3502 (VM&P Naphtha) or
 560X0194 (Mineral Spirits)

APPLICATION INFORMATION

SURFACE PREPARATION:

Surface of substrate should be dry, clean, and in sound, paint worthy condition. The surface must be free of dirt, grease, oil, salts, loose rust, loose mill scale, and any other foreign materials or contaminants.

Steel and Iron:

The minimum surface preparation for steel and iron is Hand Tool Cleaning per SSPC-SP2. Prior to this procedure, the surface should be solvent cleaned per SSPC-SP1. For better performance, begin with SSPC-SP1 followed by SSPC-SP6, Commercial Blast Cleaning. Bare metal should be primed as soon after surface preparation as possible, or before flash rusting occurs.

APPLICATION CONDITIONS:

Temperature:

Temperature should not exceed 120°F or go below 40°F during application. This applies to air, surface of substrate and the primer itself. The temperature should be at least 5° F above the dew point.

Relative Humidity:

Dry times may be adversely affected as the relative humidity increases. Caution should be taken when painting in very humid conditions.

MIXING & THINNING INSTRUCTIONS:

Before use, mix paint thoroughly by boxing and stirring. Mechanical agitation is preferred. Be sure all settlement, if any, is well incorporated. Thinning of this product is not normally required; however, if it is deemed necessary, use 560X3502 (VM&P Naphtha). If dry spray becomes an issue during very hot weather, use 560X0194 (Mineral Spirits) to retard flash-off time.

Note: The addition of thinner reduces viscosity, which, in turn, affects spread rate and application characteristics. If thinner is used, make sure it is well incorporated into the paint prior to application.

FIREPROOFING:

99-Series Heavy Duty Inhibitive Primers have been tested for compatibility and adhesion with certain cementitious fireproofing materials and were found to exhibit excellent performance. They have also been tested and approved under a limited number of intumescent fireproofings with satisfactory adhesion and compatibility. Contact Sumter Coatings or your Sumter Coatings representative for specific information.

WELDABILITY:

Independent lab tests have found no evidence **99-Series Heavy Duty Inhibitive Primers** adversely affected the welding process. These primers may be welded through to yield sound welds.

Prices may be obtained from your Sumter Coatings Sales Representative, or by calling Sumter Coatings Customer Service at 1-888-471-3400.

APPLICATION EQUIPMENT:

The following are general recommendations. Pressure and tip size may be varied due to temperature changes and for proper spray characteristics.

Thinner: Typically not recommended. If deemed necessary, use 560X3502 (VM&P Naphtha).

See Mixing and Thinning Instructions for further information.

Airless Spray:

Pump Ratio: 30:1
Hose: 1/4" or 3/8"
Tip Size: .015 – .019
Pressure: 1800 – 3000 psi
Filter: 60 Mesh

Air-assisted Airless

Pump Ratio: 15:1 – 30:1
Fluid Pressure: 800 – 1200 psi
Air Pressure: 5 – 20 psi
Fluid Hose: 1/4" – 3/8"
Tip Size: .015 – .019

Conventional Spray:

Gun: Graco AirPro or equal
Fluid Nozzle: 1.4 mm
Air Cap: 289773
Atomization Pressure: 40 – 50 psi
Fluid Pressure: 15 – 20 psi

Brush: Natural Bristle – for small areas only.

HINTS FOR BETTER PERFORMANCE:

A clean substrate is necessary for optimal performance of the primer, as direct contact of primer and steel surface is required for rust inhibition and good adhesion.

All welds, sharp edges, angles, and other areas prone to early rusting due to insufficient coverage should be stripe-coated prior to full application in order to help prevent premature failure in these areas.

Over-thinning of the coating material can result in an insufficient film-build, poor adhesion and overall poor appearance.

During the spray application, use a 50% overlap with each pass of the gun. This will help ensure complete and thorough coverage, avoiding low build areas, which may corrode prematurely due to insufficient primer.

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The technical data furnished are true and accurate to the best of our knowledge at the date of issuance. It is subject to change without prior notice. It is suggested the user verify with Sumter Coatings, Inc. prior to specifying or ordering. Test results are believed to be reliable, however, no guarantee of accuracy is given or implied. We guarantee all products to conform to Sumter Coatings, Inc.'s quality control standards. Liability, if any, is limited to replacement of product. No other warranty or guarantee of any kind, expressed or implied, is made by Sumter Coatings, Inc., including fitness for a particular purpose.