



Inhibitive Shopcoat Primers

100R7713 Red

100D7714 Dark Gray

100D7720 Light Gray

PRODUCT DESCRIPTION

77-Series Inhibitive Shopcoat Primers are fast drying, rust inhibitive primers designed to protect steel and iron substrates from corroding prior to erection. These primers are VOC and HAPS compliant and contain no heavy metals. Ease of application, performance and environmental friendliness combine to make these very desirable primers.

Recommended Use: Inhibitive Shopcoat Primers are designed to protect steel and iron against atmospheric corrosion in mild industrial environments such as schools, metal buildings, shopping centers, etc.

77-Series Inhibitive Shopcoat Primers meet or exceed the performance requirements of SSPC Paint No. 15 and TT-P-636.

PERFORMANCE PROPERTIES

System Tested:

Substrate: Steel

Surface Preparation: SSPC-SP6

1 ct. Inhibitive Shopcoat Primer @ 2 mils dft

Adhesion:

Method: ASTM D4541 Type II

Result: 7-day cure: Passes 435 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

Dry Heat Resistance:

Method: ASTM D2485 Method A

Result: Passes 200°F

Salt Spray Resistance:

Method: ASTM B117

Result: Passes 200 hours

Thermal Shock:

Method: ASTM D2246 – 5 cycles

Result: Passes

TECHNICAL INFORMATION

Gloss: Flat 0 – 5 units @ 60° Maximum

Use: Protective / Decorative

Color: Red, Dark Gray and Light Gray

Recommended Film Thickness: 2.0 – 4.0 Mils Dry
4.4 – 8.8 Mils Wet

Spread Rate: 363 – 181 sq ft/gal
@ Recommended Dry Film – No Loss

Dry Time: @ 4.5 Mils Wet
@ 77°F (25°C) & 50% Relative Humidity

To Touch: 15 minutes

Tack Free: 45 minutes

To Handle: 60 minutes

To Topcoat: Overnight or 8 hours

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

Flash Point: 65°F (18°C) SETAFLASH

Viscosity: 60 – 65 KU @ 77°F (25°C)

VOC:	100R7713	3.47 lbs/gal (416 g/l)
	100D7714	3.44 lbs/gal (413 g/l)
	100D7720	3.25 lbs/gal (390 g/l)

#HAPS / Gal Solids:	100R7713	0.37
	100D7714	0.36
	100D7720	0.25

Solids By Volume:	100R7713	44.50 ± 2%
	100D7714	44.94 ± 2%
	100D7720	47.79 ± 2%

Solids By Weight:	100R7713	69.66 ± 2%
	100D7714	69.35 ± 2%
	100D7720	72.55 ± 2%

Weight Per Gallon:	100R7713	11.44 lbs
	100D7714	11.24 lbs
	100D7720	11.85 lbs

Shelf Life: Two years unopened from date of manufacture.

Reducer: 560X3502 (VM&P Naphtha) or 560X0194 (Mineral Spirits) if slower dry 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:

77-Series Inhibitive Shopcoat 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 **77-Series Inhibitive Shopcoat 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.