

205 Industrial Primer

Updated: January 2015

Specification Data

Generic Type: Alkyd

Description: APCO 205 is a proven, thin film, economical metal primer. Provides tight barrier protection to properly prepared steel surfaces. User friendly application, can be applied with brush, roller or spray.

Features:

- VOC compliant
- Corrosion resistant

Solids Content: 52% by Volume

Theoretical Coverage:

- 834 mil ft²
- 278 ft² @ 3 mil DFT

Allow for loss during mixing & application.

VOC Value:

- 3.15 lbs/gal per EPA Method 24

Color: 2018 Red Oxide

Substrate & Surface Preparation

Must be clean and dry. Any dirt, dust, oil, contaminants, loose rust or loose mil scale must be removed.

Immersion Carbon Steel: Not Recommended

Non-Immersion Carbon Steel: Minimum SSPC-SP3 Power tool Cleaning. For optimum performance SSPC- SP6 Commercial Blast, surface profile 1.5-3.0 Mil.

Galvanized Steel: Not recommended

Previously painted surfaces: Surface must be sufficiently roughened, either by abrasive blasting or mechanical abrasion. Surface must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" test. Apply a test patch to check compatibility, prior to primary application.

Topcoats: APCO201 Industrial Enamel, 202 Industrial Aluminum Paint

Application Equipment

Spray Application:

- **Conventional:** Pressure pot with dual regulators, 3/8" I.D. material hose, Binks 2001 Gun w/66 series nozzles and 565 needle.
- **Airless:** Graco 36:1 Min. 1/4" material line. Tip size .013. Output PSI- 3000-3600

Brush & Roller:

- **Brush:** Natural Bristle
- **Roller:** 1/4" Nap cover with Phenolic Core

Mixing & Thinning

Components: One

Mixing: Power mix to uniform color & consistency

Thinning:

- **Spray:** Up to 12 oz/gal with S102

Application

Pre-application: Flush all equipment with thinner S102 or Mineral Spirits

Temperature: Application range from 50°F-110°F surface temperature. Do not apply below 50°F.

Method: Apply one coat maintaining a wet edge to achieve a WFT of 4-6 Mils. Maximum performance will be achieved with two coats totaling 4-6 mils DFT.

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Application Continued

Inspection: Visually inspect film to ensure adequate coverage.

Clean up & disposal: After use immediately flush all equipment with thinner S102 or mineral spirits. Dispose of all containers, solvents and unused materials in accordance with all local, state and federal regulations.

Curing schedule:

Times based upon 75°F

Dry to touch: 2 hours

Dry to topcoat: 24 hours

Dry through: 48 hours

Dry times are greatly affected by weather conditions and film thickness.

Packaging & Handling:

Unit sizes: Ones, Fives and Drums

Shipping Weight: 12 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII