

## 245FP Universal Primer

Updated: January 2015

### Specification Data

**Generic Type:** Phenolic alkyd

**Description:** APCO 245FP is a proven, fast drying, thin film, non-lifting universal alkyd primer. Provides tight barrier protection to properly prepared steel surfaces. Quick dry times ensure high production rates and limited bottlenecks in the paint booth. Can be used under high performance topcoats containing hot keytone solvents. Can also be used as a barrier coat over conventional coatings that would normally be attacked by stronger solvents.

**Features:**

- Fast Drying
- Corrosion resistant
- No critical recoat window
- Non-lifting

**Solids Content:** 42% by Volume

**Theoretical Coverage:**

- 665 mil ft<sup>2</sup>
- 221 ft<sup>2</sup> @ 3 mil DFT

Allow for loss during mixing & application.

**VOC Value:**

- 4.15 lbs/gal per EPA Method 24
- VOC value is an average and may differ depending upon color. For specific value refer to SDS sheet.

**Color:** Multiple grays, and 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:** APCO 220, APCO 400HS, APCO 427

### 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: Touch up only**

- **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 S100

### Application

**Pre-application:** Flush all equipment with thinner S100 or xylene

**Temperature:** Application range from 40°F-110°F surface temperature. Do not apply below 40°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 S100 or xylene. 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: 20 minutes

Dry to topcoat: 30 minutes

Dry through: 6 hours

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

**Packaging & Handling:**

Unit sizes: Ones, Fives and Drums

Shipping Weight: 11.75 lbs/gal Unit

UN Classification: UN1263, PAINT, CLASS 3, PGIII