

H.D. FABRICATION PRIMER

PRODUCT NAME:	Heavy Duty Fabrication Primer
PRODUCT NUMBERS:	A543
DESCRIPTION:	A high solids, lead & chromate free low VOC primer that inhibits rust, penetrates cracks around light rust and mill scale. Protects and resists exposure to weather.
SUGGESTED USES:	Machinery, steel railings, doors, fire escapes and all metal fabrication. For interior or exterior use.
COLORS:	Red
FINISH:	Low sheen
VEHICLE TYPE:	Alkyd
SOLVENT TYPE:	Mineral Spirits
FLASH POINT:	105° F. Seta Flash
SOLIDS BY VOLUME:	50%
RECOMMENDED DRY FILM:	2.0 – 3.5 Mils
COVERAGE:	Theoretical coverage at 1 mil dry is 880 square feet per gallon, and 440square feet at 2 mils dry.
VISCOSITY:	80-90 KU (Kreb Units)
RECOMMENDED DRY TIME:	Dries to handle in 2-4 Hours. Can be recoated in 12 hours.
REDUCER:	Mineral spirits, adding reducer in excess of 20% will exceed VOC limits
CLEAN UP:	Mineral Spirits
PHYSICAL PROPERTIES:	ASTM 3359 Cross hatch Adhesion- 5 ASTM B117 Salt Fog Spray -800 Hours –No Effect ASTM D522 Flexibility (conical Mandrel) – 1/8 "-Pass
RECOMMENDED PRIMERS:	Not Applicable
SURFACE PREPERATION:	Remove all grease, dirt, oil, wax and other foreign matter from surfaces by washing with suitable cleaners. For weather exposed steel a commercial blast is recommended (SSPC-SP-6). Fro enclosed or protected steel, power tool cleaning (SSPC-SP-3) or hand cleaning (SSPC-SP-2) can be used when factors do not require SSPC-3 cleaning.

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APPLICATION:

Brush, Roller Spray.
 Roll: ¼" lambswool or ¼" – ½" synthetic roller cover

Conventional Air Spray:	Binks	Graco	Devilbiss
Spray Gun:	#18 Or #62	800 or 900	JGA502 or MBC-510
Fluid Nozzle:	66 or 67	047 or 086	D or E
Air Cap:	66PE or 63PB	02,03, 952	704,765,78
Airless Spray:	Binks	Graco	
Pump:	37:1 B8-36	30:1 Bulldog	
Pressure Filter:		60 Mesh	
Fluid Hose:	71-7507x 100'		
Airless Gun	M1	208-663	
Tips:	9-1860-9-2180	.015-.019	
Minimum Pressure:		2000 PSI	
HVLP:	Binks		
Spray Gun:	Mach 1		
Fluid Nozzle:	94F or 905F		
Orifice	.007 or .086		
Air Nozzle:	95P or 905P		

POT LIFE:

Not Applicable

SHELF LIFE:

12 Months minimum.

MIXING:

Stir thoroughly and apply as it comes from the container.

SAFETY INFORMATION:

COMBUSTIBLE! HARMFUL OR FATAL IF SWALLOWED, CONTAINS MINERAL SPIRITS. Keep away from heat, sparks and flame. To avoid breathing vapors or spray mist, open windows and doors or use other means to ensure fresh air entry during application and drying. If you experience eye watering, headaches or dizziness, increase air or wear respiratory protection (NIOSH/MSHA TC23C or equivalent) or leave area. Do not take internally. Close container after each use. Avoid contact with skin or eyes.

FISRT AID:

If swallowed, do not induce vomiting. Call a physician immediately. In case of eye contact, immediately flush thoroughly with water and call a physician. For skin contact, wash thoroughly.
USE WITH ADEQUATE VENTILATION. KEEP OUT OF REACH OF CHILDREN.
 Notice: Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. **Keep away from heat, sparks and flame.**

All technical data, recommendations and services are accurate to the best of our knowledge. Seller assumes no responsibility for the results obtained or damages incurred from their use by the Buyer in whole or in part. No Warranty, including those of merchantability or fitness for a particular purpose, is expressed or implied since the method of application and its use is beyond our control. There are no warranties that extend beyond the description or the face hereof.