

Fastech ShopCoat™

Fast Dry, Lead and Chromate Free Alkyd Primer

SELECTION DATA

DESCRIPTION:

Fastech ShopCoat primer is a spray only, fast dry, solvent reducible, alkyd primer. This fast recoat primer is designed for simple OEM application to contaminate free iron and steel surfaces prepared to, SSPC-SP1, SP2, or SP3 specifications. It provides protection against undercutting and covers well over irregular surfaces, open seams and around nuts/washers. The alkyd resin system has excellent resistance to water and high humidity providing corrosion resistance to the applied parts while in transit. It is designed for application by air assisted HVLP airless spray and HVLP systems.

USES:

Fastech ShopCoat primer is formulated for OEM application to metal fabrications, parts, structural steel and wrought iron finishing. Primarily used by job shops or metal parts manufacturers that want to supply their customers with a finished product that will not rust in transit and be ready for topcoating. Recommended topcoats include; alkyd, silicone alkyd and acrylic finishes.

ADVANTAGES:

- Lead and chromate free.
- Contains no 1,1,1, trichloroethane.
- Fast recoat.
- Coated products will not rust while in transit.
- Very easy application.
- Lead and chromate free; no chemical hazard in dry state.

LIMITATIONS:

- It has poor resistance to caustics and direct contact with alcohols, strong solvents and acids.
- Not recommended for galvanized steel or aluminum.
- Limited chemical resistance.
- Not recommended for submersion, severe chemical environments or use under urethanes or epoxies.

PHYSICAL PROPERTIES

VOC: [as packaged] 420 g/l – (3.5 lbs./gal.)

APPEARANCE: [Gloss at 60°]

Flat (F) 7 – 15

WEIGHT PER GALLON: [average] 11.4 lbs.

FLASH POINT: [setaflash] 54° F.

PACKAGE VISCOSITY: 90 – 100 KU

SOLIDS: [average]

By Weight 69 ± 1 %

By Volume 47 ± 1 %

COVERAGE: [average]

Theoretical at 1 mil DFT 754 sq.ft./gal.

Theoretical at 1.5 mils DFT 503 sq.ft./gal.

Recommended DFT per coat 1.5 mils

DRY SCHEDULE: [at 50% RH and 1.5 mils DFT]

	45° F.	60° F.	75° F.	90° F.
Tack Dry	50 mins	35 mins	20 mins	7 mins
Dry to Touch	2¼ hrs	1¼ hrs	50 mins	25 mins
Dry to Handle	5 hrs	3 hrs	2 hrs	1½ hrs
Dry Hard ¹	36 hrs	30 hrs	24 hrs	24 hrs
Recoat ²	1¼ hrs	40 mins	20 mins	15 mins

¹ Also water resistant.

² After 1 week wash off all foreign matter. Light sanding will be necessary if cured primer is subject to exterior exposure for more than 5 days.

FORCE CURE: [194° F.] 15 min.

COLOR AVAILABILITY:

Only available in red oxide.

ORDER CODE: AM356

PACKAGING: [average]

One ea. 5 gallon metal pail 62 lbs.

One ea. 50 gallon metal Ddrum 620 lbs.

Continued 

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TRIANGLE™



Fastech ShopCoat™

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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Both surface and ambient temperatures must be above 50° F.
- Surfaces to be primed must be dry, +5° F. above dewpoint and protected from all moisture until rainproof as per chart above.
- Surfaces must be clean, 100% free of contaminants through which water cannot penetrate including accumulated dirt/dust, mud, oils, grease and any form of silicone.
- Over new steel hand clean per SSPC-SP1, SP2 or SP3.
- All loose, peeling and/or marginally adherent paint must be removed.
- Hard slick surfaces including oil enameled surfaces must be abraded to dull.
- Performance over mill scale cannot be predicted. Mill scale is never acceptable.

FILM DEVELOPMENT & THICKNESS:

Fastech Shopcoat is designed for one coat application at 2 mils DFT. On smooth surfaces **Fastech Shopcoat** applied at 377 sq.ft./gal. will produce dry films with an average thickness of 2 mils. Decrease spread rate as surface irregularities, e.g. bolts, welds, etc., or surface profile, e.g. boiler plate or corrugation, increases total surface area.

REQUIRED THINNING: None
If desired xylene can be used as thinner.

APPLICATION METHOD:

Depending on local regulation this coating may be applied by conventional, HVLP or HVLP air assisted airless spray application methods. Apply using crossing pattern.

TIP SELECTION:

High Volume Low Pressure Air Assisted Airless:

Use fluid tip size013 – .016
Paint fluid pressure 800 – 1500 psi
Air pressure to gun 65 – 70 psi
Aircap pressure 10 psi maximum

Conventional Air Spray:

Use fluid tip size040 – .055
Paint fluid pressure 10 – 15 psi
Aircap pressure 65 – 75 psi

High Volume Low Pressure Air Spray:

Use fluid tip size040 – .055
Paint fluid pressure 10 – 15 psi
Air pressure to gun 75 – 80 psi
Aircap pressure 10 psi maximum

Conventional Airless:

Use fluid tip size .015 – .017 @ 1800 – 2100 psi.

CLEANUP: AT17 Wash Thinner
Rinse equipment with clear mineral spirits. Clean hands with a "paint removing" waterless hand cleaner.

SAFETY AND HANDLING

FLASH POINT: [setaflash] 54° F. (12° C.)

SHIPPING DESCRIPTION: [CFR 49]

Ground/Air/Vessel: Paint, 3, UN1263, PG II

Required Label: FLAMMABLE LIQUID

Required Marking: PAINT UN1263

IMDG PACKAGING:

FLAMMABLE LIQUID, class 3.2, UN1263, II

IMDG STOWAGE: Category B

UNIFORM FIRE CODE: [CFR 29] CLASS I-B

STORAGE TEMPERATURE: 120° F. max.

SHELF LIFE: [warranted] 1 Year

"HMIS" RATINGS: H - 2; F - 3; R - 0; PP - H

(11/20/01)

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