



ALKYD SHOPCOAT PRIMER

K-S3102 Gray
K-S4501 Red Oxide

Alkyd Shopcoat Primer is a fast drying, heavy-duty primer that offers outstanding protection up to 6 months for steel in normal industrial environments. Its high volume solids makes it an economical primer with good coverage and excellent hiding power.

- ✓ Corrosion and rust-inhibitive protection
- ✓ Weld-through formula
- ✓ Abrasion resistant
- ✓ Good coverage and excellent hiding power
- ✓ Fast drying — dries to touch in 15 minutes
- ✓ Interior/exterior use
- ✓ Topcoat with latex and alkyd enamels

INDUSTRIAL USE ONLY!
AS OF 01/01/16 COMPLIES WITH:

NATIONAL/EPA

krylonindustrial.com
1-800-247-3266

Revised June 2016

RECOMMENDED USES

Use this product on properly prepared surfaces of steel such as structural steel, machinery and equipment, racking, piping, bar joists, joists, handrails and tank exteriors.

RECOMMENDED SYSTEM

Steel (Alkyd Topcoat):

1 coat Krylon® Industrial Alkyd Shopcoat Primer
1–2 coats Krylon® Industrial Tough Coat® Alkyd Enamel

Steel (Acrylic Topcoat):

1 coat Krylon® Industrial Alkyd Shopcoat Primer
1–2 coats Krylon® Industrial Waterborne Acrylic Enamel

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust and other foreign materials to ensure adequate adhesion. **Do not use hydrocarbon solvents for cleaning.**

Iron And Steel:

Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6/ NACE 3. Primer recommended for best performance.

According to AISC, shop coat primers are intended for protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating. Primer coats used for exterior applications should not be left untopcoated in excess of six months.

CLEAN UP

Clean spills, spatters and tools immediately with mineral spirits. After cleaning, flush spray equipment with mineral spirits to prevent rusting of the equipment. Follow manufacturer's safety recommendations when using mineral spirits.

TECHNICAL DATA

Vehicle	Alkyd
Finish	Flat (0–10 units @ 60°F)
Flash Point	45°F, PMCC
Volume Solids	
Gray	49 ± 2%
Red Oxide	45 ± 2%
Weight Solids	
Gray	73 ± 2%
Red Oxide	69 ± 2%
Weight Gallon	
Gray	11.7 lb/gal
Red Oxide	11.0 lb/gal
VOC (less exempt solvents)	
Gray	378 g/L (3.15 lb/gal) as per 40 CFR 59.406
Red Oxide	411 g/L (3.43 lb/gal) as per 40 CFR 59.406
Rec. film thickness	
	Wet mils: 4-5
	Dry mils: 2-2.5

TECHNICAL DATA CONTINUED

Spread Rate	400 f2/gal
Application	Apply by airless or conventional spray, brush
Drying Time	(@ 77°F, 50% RH) Note: Drying times are temperature, humidity and film thickness dependant.
To Touch:	10 minutes
Tack Free	30 minutes
To Topcoat:	12 hours min, 48 hours max After maximum topcoat time, primed surface must be abraded prior to recoating or topcoating. Primer coats used for exterior application should not be left untopcoated in excess of six months.
Reduction	Not Required
Clean-Up	Mineral spirits
Tinting	Do not tint
Sizes	5 gallon
Shelf Life	12 months

APPLICATION

Temperature (air, surface and material)
40°F min, 120°F max,
at least 5°F above dew point

Relative humidity 85% maximum

Reducer/Cleanup Mineral spirits

Airless Spray

Pressure 1800–2300 psi

Hose 1/4" ID

Tip .015"–.017"

Filter 60 mesh

Reduction Not recommended

Conventional Spray

Gun Binks 18 (or similar)

Fluid Nozzle 63C

Air Nozzle 63PB

Atomization Pressure 50 psi

Fluid Pressure 15–20 psi

Reduction As needed up to 5% by volume

Brush (small areas and touch-up)

Nylon/polyester

Roller Not recommended

PHYSICAL TEST DATA**System Tested**

Substrate Steel

Surface Preparation SSPC-SP1

Primer 1 coat Krylon® Industrial Alkyd Shopcoat Primer

Abrasion Resistance K-S4501 — 340 mg loss @ 1000 cycles

ASTM D4060, CS17 wheel, 1 kg load K-S3102 — 350 mg loss @ 875 cycles

Adhesion

ASTM D3359 Passes at 3B, 5%–15% loss

Elongation K-S4501 — passes 1/4" mandrel

ASTM D522 Method B K-S3102 — passes 1" mandrel

Salt Fog Resistance K-S4501 — passes 250 hours

ASTM B117 K-S3102 — passes 100 hours

Moisture Cond. Resistance

ASTM D4585, 100°F, 500 hours Passes



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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.