![Diamond Vogel Industrial Coatings logo]

TECHNICAL DATA SHEET

Product Description: Gray Structural Primer

IRON PRIME 100

PRODUCT CODE: PB05-51376

Formulated to meet performance of SSPC 15, Type 1.

DESCRIPTION: This structural steel primers was developed specifically for use on ferrous metals as a steel joist shop paint. This structural steel primers may be applied over dry, oil-free, steel surfaces by airless spray, dip, or other suitable methods. This formulation has passed the performance requirements of SSPC-15 type 1. This specification includes shop paints that provide protection for steel joists during delivery and erection. Product is weldable and can be topcoated with epoxy, vinyl, chlorinated rubber, alkyd, acrylic, and urethane coatings as well as conventional oil and oleoresinous paints.

PHYSICAL PROPERTIES:

Weight Solids:	67%
Volume Solids:	44%
Resin Type:	Alkyd
Gloss:	Flat
Theoretical Coverage:	704 square feet at 1.0 mil
Weight per Gallon:	11.0 pounds
Viscosity:	#3 Zahn – 29 to 32 seconds at 77º F
EPA VOC:	3.5 pounds per gallon maximum

SURFACE PREPARATION: Service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits.

REDUCTION: Mineral Spirits or VM&P

APPLICATION: Thin with recommended reducer as needed. For additional instructions, consult your Diamond Vogel Industrial representative.

Dry Film Thickness: 1.0 to 2.0 mils

DRY TIMES:
Dry Tack Free: 10 to 15 minutes at 77º F and 50% RH
Dry Through: 3 to 6 hours at 77º F and 50% RH

CLEAN UP: Mineral Spirits or Xylene

PERFORMANCE: Typical, tested on B-1000 panels at 1.0 to 1.5 mils DFT
CCT-E Cyclic Salt Fog/UV: ASTM D5894 - 1,000 hours – Pass – Less than 1mm scribe creepage, no blistering
Salt Spray: ASTM B-117 - 300 hours – Pass – Less than 3mm scribe creepage

SAFETY PRECAUTIONS: See Safety Data Sheet that is available upon request.

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