



**Ultra-Rust Inhibitive Primer System**

**PRODUCT CODES:** PL-0577 - Gray | PL-0568 - Buff White | PL-9561 - Black | PL-1559 - Mist White

**DESCRIPTION:** This new generation of primers comes with the latest in polymer and corrosion inhibitor technologies. It can be used under the Nexgen topcoat system along with most other topcoats as both a single component (1K) or two component (2K) mixed at a 8A - 10A:1B ratio with IG-0267. These primers exhibit fast dry times along with excellent gloss holdout and corrosion resistance. It is ideal for industrial uses including the finishing of agricultural and construction equipment. This fast drying system also has excellent film build characteristics over blasted and abraded metals.

**PHYSICAL PROPERTIES:**

Weight Solids: 67% to 72%  
Volume Solids: 50% to 53%  
Resin Type: Modified Epoxy Ester  
Gloss: Satin  
Theoretical Coverage: 800 to 840 square feet at 1.0 mil  
Weight per Gallon: 12.0 pounds  
Viscosity: #2 Zahn – 37 to 32 seconds at 77° F  
EPA VOC: 3.5 pounds per gallon

**SURFACE PREPARATION:** The 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. They may be applied over steel and other properly prepared substrates.

Steel: Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.  
Aluminum: Aluminum should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils and then coated before flash rusting occurs.

**REDUCTION:**

Airless: For airless application no reduction is necessary.  
Conventional Air: For conventional air spray some reduction may be necessary. Thin sparingly with Butyl Acetate or other aromatic solvents.

**APPLICATION:**

Airless: These primers can be sprayed with all types of application equipment. For airless application no reduction is necessary. Airless tip sizes should be in the .011 to .017 range. Adjust pressures accordingly for best atomization and transfer efficiencies. Air-assist airless pressures will be in the 800 to 1,000 pound range for fluid and 30 to 60 pound range for atomizing air. In-line heaters should be set at 120°F.  
Conventional Air: Pressures will be dependent upon the type of gun and fluid nozzle, but atomizing air pressures will typically be in the 45 to 60 pound range.  
Dry Film Thickness: For best results, dry film thicknesses should be about 1.0 to 2.0 mils above surface profile. This will require wet film thicknesses of around 2.0 to 4.0 mils. This primer system has good film build characteristics and can be applied up to 6.0 mils wet over blasted profile.

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- DRY TIMES:** Recoat times may vary according to film thicknesses and curing conditions, but typically can be topcoated immediately and up to 24 hours. After 24 hours, care should be taken to ensure good inter-coat adhesion by re-priming, lightly scuffing, or solvent wipe before topcoating. If catalyzing at 10A:1B with IG-0267 please allow up to one hour of flash time before topcoating
- CLEAN UP:** Use Butyl Acetate or Xylol to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.
- PERFORMANCE:** Typical, tested on B-1000 panels at 1.0 to 1.5 mils DFT
- Crosshatch Adhesion: ASTM D3359 – 5B
- Pencil Hardness: ASTM D3363 - HB
- Gravelometer: ASTM D3170 – 3A
- 1,000 Hour Salt Spray: ASTM B-117 - Pass
- SAFETY PRECAUTIONS:** Contains ketone solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice.