



### 3.5 VOC Rust Inhibitive Primer System

**PRODUCT CODES:** PN-0543 – Gray | PN-1545 – Mist White | PN-3544 – Buff Yellow  
PN-5532 – Red Oxide | PN-9534 - Black

**DESCRIPTION:** This is a 3.5 VOC, HAP's compliant primer system that exhibits fast dry times, good gloss holdout, corrosion resistance and lift resistant properties. This primer system is ideal for industrial uses including the finishing of agricultural and construction equipment.

**PHYSICAL PROPERTIES:**

Weight Solids: 72% to 74%  
Volume Solids: 52% to 54%  
Resin Type: Modified Alkyd  
Gloss: Flat  
Theoretical Coverage: 840 to 860 square feet at 1.0 mil  
Weight per Gallon: 12.6 pounds  
Viscosity: #2 Zahn – 26 to 30 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: Workhorse Modified Alkyd Primers can be sprayed with all types of application equipment. 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.  
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. To maintain less than 2.8 pounds per gallon VOC, thin with TBAC or acetone.  
In-Line Heat: In-line heaters should be set at 120°F.  
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.

**DRY TIMES:**

Recoat times may vary according to film thicknesses and curing conditions, but typically can be topcoated after it reaches tack free or 10 to 15 minutes. Workhorse Modified Alkyd Primer system has good lift

**Workhorse Rust Inhibitive Primer System 3.5 VOC**

resistant properties, and may be recoated at later dates as long as care is taken to clean the surface to be coated. Solvent wiping will also aid inter-coat adhesion.

**CLEAN UP:** Use Butyl Acetate to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.

**PERFORMANCE:** Typical, tested on B-1000 panels at 2.0 mils DFT  
Gravelometer: ASTM D3170 – 2A  
Crosshatch Adhesion: ASTM D3359 – 5B  
500 hour Salt Spray: Pass – less than 3 mm creepage, no blistering, no face rust

**SAFETY PRECAUTIONS:** Contains Butyl Acetate & D-100. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice.