



Pre~Fab

Steel Shop Primer

Data Sheet

FEATURES

- Fast dry allows rapid handling of coated steel
- Modified zinc phosphate anti-corrosive pigmentation
Higher ZP content than other shop primers
- Free of chromates and other heavy metal compounds
- Suitable for acrylic and alkyd topcoats
- Available in Red Oxide or Grey
- Very economic cost per square metre
- Can be applied using conventional spray equipment as well as airless spray
- Highly re-coatable with itself or other alkyd undercoats or finish coats

Limitations:

- Not designed for extended exterior exposure.

RECOMMENDED USES

Pre~Fab Steel Shop Primer is a fast dry, economical, primer designed for use in engineering fabrication shops.

Pre~Fab Steel Shop Primer is suitable as a stand-alone coating in mild interior environments and provides good protection to structural steel in moderate exterior environments when topcoated with compatible alkyd or acrylic coatings.

Pre~Fab Steel Shop Primer is the primer of choice for a SP2 surface preparation for structural steel to be enclosed within wall framing.

SPECIFICATION DATA

Coating Type:	QD Alkyd Zinc Phosphate
Colour:	Red Oxide & Grey
Packaging:	4 litre & 20 litres Single Package
Mix Ratio:	N/A - Single Package
Pot life:	N/A
Gloss:	Flat
Flash Point:	15°C
Thinner:	Spray Altex Thinner #53 (formerly S53) Brush Altex Thinner #10
Storage:	Store under cool, dry conditions

Density:	Red	1.29 kg/litre
	Grey	1.27 kg/litre
VOC:	479 gm/litre (Red & Grey)	
Temperature Resistance:	100°C Dry	
Volume Solids:	43% (Red & Grey)	
Theoretical Coverage Rate:	8.6 square metres per litre at 50 microns dry	
Recommended Film Thickness Per Coat:	98-140 microns wet to obtain 38-60 microns dry	
Application:	Spray, brush	
Dry Times (38 µm DFT / 50% R.H. / 25°C):		
Tack Free	15 - 30 minutes	
Through Dry	16 hours	
Recoat Min:		
Acrylic	18 hours	
Alkyd	36 hours	

SURFACE PREPARATION

All surfaces must be sound and free of oil, grease, dirt, form release agents, curing compounds, loose and flaking paint, moisture and other foreign substances.

Steel Surfaces:

For the best results, abrasive blast to AS1627.4 Class 2 /SSPC SP6 (Sa2). For mild conditions hand or power tool cleaning to SSPC SP2 or 3 may be satisfactory.

DIRECTIONS FOR USE

Mixing:

Use mechanical agitation for proper mixing to ensure homogeneous condition. Stir until thoroughly mixed.

Thinning:

For spray application thin up to 10% with Altex Thinner #53 (formerly S53).

For Brush application thin up to 10% with Altex Thinner #10 if necessary.

Note: Excessive thinning can cause low film thickness, sagging and other film defects.

Application:

Pre-Fab Steel Shop Primer may be applied by brush or spray.

For spray Pre-Fab Steel Shop Primer should be applied in one wet coat, overlapping each pass 50%.

Suggested spray equipment:

Conventional Air Spray

1.4mm to 1.8mm Fluid tip with appropriate air cap.

Airless Spray

Pump Ratio	30:1
Material Hose	3/8" I.D min
Tip Size	0.015 – 0.019

(Note: The above is a guide. Other equipment to the above may be used.)

Clean-up:

Use Carboline Thinner #10 or Cleaning Solvent.

PRECAUTIONS

For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label and the Material Safety Data Sheet (MSDS) for health and safety information prior to use.

Pre-Fab Steel Shop Primer is flammable. Keep away from heat, sparks and open flame. Use with adequate ventilation. May cause eye and skin irritation. Do not breathe vapour or spray. Wear suitable protective clothing such as gloves and eye and face protection.

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It is the users' responsibility to ensure they have the latest product data sheet and Material Safety Data sheet. Check the data sheet date with the listings at www.altexcoatings.com.