



SHOP COAT PRIMER

DESCRIPTION AND USES

Rust-Oleum® Commercial Shop Coat Primer is a fast-drying modified alkyd primer designed to provide excellent adhesion to structural steel and fabricated metal. Shop Coat Primer is versatile enough to be topcoated with many different products including two component epoxies and polyurethanes. Use on clean, abrasive-blasted or lightly rusted steel in mild to moderate industrial environments. Use two coats of primer over abrasive-blasted or rusted steel. Not for use on galvanized steel.

PRODUCTS

SKU	Description
297200	5-Gallon Red Primer
305372	50-Gallon Red Primer

COMPATIBLE PRODUCTS

The Shop Coat Primer is suitable for use with most industrial finishes.

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® Cleaner Degreaser or other suitable cleaner. Mold and mildew areas must be cleaned with a chlorinated cleaner or bleach solution. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings.

For optimal performance, abrasive blast clean to a minimum SSPC-SP-6 Commercial Grade (NACE 3) with a surface profile of 1-2 mils (25-50µ). Abrasive blast cleaned steel requires two coats of primer.

PRODUCT APPLICATION (cont.)

APPLICATION

Apply only when air and surface temperatures are between 32-100°F (0-38°C), and the surface temperature is at least 5°F (3°C) above dew point. This coating can be applied by brush, roller or spray.

EQUIPMENT RECOMMENDATIONS

BRUSH: For touch up only. Use a good quality synthetic brush.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomization
Pressure	0.055-0.070	16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP (var.)	0.043-0.070	8-14 oz./min.	60-90 psi*

*(10 psi maximum at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600-2400 psi	0.013-0.017	100

THINNING

BRUSH: Normally not required.

AIR-ATOMIZED SPRAY: 333402 Thinner – Use up to 15% by volume.

CLEAN UP

633402 Thinner

**TECHNICAL DATA****SHOP COAT PRIMER****PHYSICAL PROPERTIES**

Resin Type		Modified Alkyd		
Pigment Type		Varies		
Solvents		Aliphatic and Aromatic Hydrocarbons		
Weight	Per Gallon	12.3-12.4 lbs.		
	Per Liter	1.47-1.49 kg		
Solids	By Weight	75.0-77.0%		
	By Volume	55.0-57.0%		
Volatile Organic Compounds		<340 g/l (2.80 lbs./gal.)		
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5 μ)		
Wet Film to Achieve DFT		2.5-4.0 mils (62.5-100 μ)		
Theoretical Coverage at 1 mil DFT (25μ)		900 sq. ft./gal. (22.4 m ² /l)		
Practical Coverage at Recommended DFT (assumes 15% material loss)		300-550 sq. ft./gal. (7.4-13.5 m ² /l)		
Dry Times at 50% Relative Humidity	Temperature	40°F	60°F	70-80°F
	Dry to Touch	45 minutes	30 minutes	30 minutes
	Dry to Handle	90 minutes	60 minutes	60 minutes
	Recoat	90 minutes	60 minutes	60 minutes
Dry Heat Resistance		212°F (100°C)		
Shelf Life		5 years		
Safety Information		For additional information, see SDS		

Calculated values are shown and may vary slightly from the actual manufactured material.

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.



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