



### Product Description

TCI liquid industrial coating Primer is an economical, fast drying primer formulated to provide corrosion protection on steel substrates.

### Advantages

- Good corrosion protection – 500 hours salt spray
- Can be applied by spray or dip
- Fast dry, can be recoated with aliphatic alkyd enamels in 30 minutes or less

### Physical Properties/Specifications

<b>Wt% Solids</b>	63 - 66
<b>Vol% Solids</b>	42 - 45
<b>Density, lb/gal</b>	11.11
<b>Formulation Viscosity</b>	18-25 sec. #3 Sig. Zahn
<b>Recommended Mills</b>	
• Wet	2.3 – 4.7
• Dry	1.0 – 2.0
<b>Sheen</b>	Flat
<b>Formula Flash Point, F</b>	65
<b>Material VOC #/Gal</b>	3.95

### Performance Test Results

<b>Substrate</b>	B-1000 CRS
<b>DFT</b>	1.3-1.8 mils
<b>Pencil Hardness (ASTM D3363)</b>	HB
<b>Impact (D/R) (ASTM D2794)</b>	140/10
<b>Mandrel Bend (1/4") (ASTM D633)</b>	Pass
<b>Crosshatch Adhesion</b>	5B
<b>Salt Spray (ASTM B117)</b>	500 hours
• 1-2 mm scribe creep, no field blisters	
<b>Humidity (ASTM D2247)</b>	500 hours
• No field blisters	

### Application

<b>Catalyst and Catalyst Ratio</b>	N/A
<b>Pot Life of Catalyzed Formula</b>	N/A
<b>Reducer and Amount</b>	Up to 5% Aromatic 100
<b>Retarder and Amount</b>	N/A
<b>Air Dry Schedule</b>	15 minutes
<b>Oven Dry Schedule</b>	N/A
<b>Recoat Instructions</b>	30 minutes to topcoat w/ aliphatic alkyd enamels
<b>Spreading Rate</b>	699 sq. ft./gal

### Settings

<b>Conventional Spray Air</b>	50-60 PSI
<b>Conventional Spray Fluid</b>	10-20 PSI
<b>Air Assisted Airless Air</b>	20-30 PSI
<b>Air Assisted Airless Fluid</b>	500-1,000 PSI
<b>Airless Fluid</b>	1000-2000 PSI
<b>High-Volume Low-Pressure Air</b>	20-30 PSI
<b>High Volume Low Pressure Fluid</b>	10-14 fl. oz./min

### Storage

- Do Not Store above 100°F or Below 50°F.
- Adverse temperature can affect storage life.
- Keep containers closed all times.



### Additional Information

- Clean up using n- butyl acetate, aromatics or ketones.
- Maximum Cure (Ambient Conditions) achieved after 7 days
- Refer to SDS for proper Personal Protection Equipment and Safety measures.
- Check Local and State regulations for VOC, HAPS and any other environmental regulations.
- Pretest each system on your substrate (under normal line conditions) to verify performance.
- DO NOT exceed Total Dry Film Thickness Recommendation.
- Agitate and mix thoroughly before each use.
- Agitate gently during use.
- Extreme temperature and humidity conditions can adversely impact dry times and cure.
- Always use stainless steel equipment when using Acid Catalyst or WB or UV Products
- Do Not Freeze
- Exterior Use
- Freeze Thaw Stable
- In Catalyzed Products/ Do NOT adjust catalyst or amounts without consulting your local representative

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**Date** 2/20/2024

*The data on this sheet are calculated values (as formulated) and will not represent exact values for every product. SOS and CPDS sheets are available upon request. Drying times and viscosities reported are as tested under laboratory conditions (77°F {25°C) with relative humidity of approximately 45%. Changes in temperature and humidity will affect product data. The following definitions are being utilized for HAP content: "HAPS-Compliant": < or = .8 lb. HAPS/lb. Solids; "low-HAPS" <,5 lb. HAPS/lb. Solids; "Ultra-low-HAPS" <2 lb. HAPS/lb. Solids; "HAPS Free": <.05 Lb. HAPS/Lb. Solids. HAP content is based upon the presence of HAP compounds utilizing limits as defined in 29 CFR 1910.1200. Manufacturer assumes no liability for use of this information which is intended to serve as a general guide.*

*It is the user's responsibility to verify product compliance with all applicable regulations or permits before proceeding with use. Always pretest any finishing products to verify suitability to the desired use before proceeding with any application. Manufacturer makes no warranties, express or implied, including {but not limited to) warranties of merchantability and fitness for particular purposes. Manufacturer will not be liable for any incidental, consequential or special damages or losses derived, directly or indirectly, from or as a consequence of purchaser's use of this product.*

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