



SPECTRACRON® 111 FAST DRY ALKYD NON-LIFT PRIMERS

DESCRIPTION:

SPECTRACRON® 111 Fast Dry Alkyd Non-Lift Primers are recommended for industrial use on metal surfaces. Suitable applications include metal fabrication, castings, machinery and heavy equipment.

HIGHLIGHTS:

- ❖ Fast drying
- ❖ Contains no heavy metals
- ❖ Can be applied over blasted surfaces
- ❖ Excellent salt spray performance
- ❖ No recoat or topcoat window

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Colors		Custom Colors (Q111-xxxx) Gray (QAP111-GRY) Red Oxide (QAP111-ROX) White (QAP111-WHT) Tintable Base (QAP111-CLR)
Gloss Range @ 60° Angle	ASTM D523	~20
Pencil Hardness	ASTM D3363	HB
Conical Mandrel (1/8")	ASTM D522	Pass
Adhesion	ASTM 3359	5B, Excellent
Humidity Resistance – 300 Hrs.	ASTM D2247	Excellent, No Blistering
Salt Spray Resistance – 300 Hrs.	ASTM B117	Excellent, 1-2mm creep
Chemical Resistance		Good
Substrates		CRS, HRS, Aluminum
Recommended Topcoat(s)		See Compatibility Chart

*These results were obtained over iron phosphated CRS panels.

PHYSICAL PROPERTIES:

PROPERTY	VALUE
Weight per gallon	10.7 ± 0.3 lbs./gal.
Weight Solids (%)	60.0 ± 4.0
Volume Solids (%)	40.0 ± 2.0
VOC (less exempts)	4.5 ± 0.2 lbs./gal.
VOE (actual)	4.5 ± 0.2 lbs./gal.
Coverage (@ 1 mil, no loss)	610 - 666 sq. ft./gal.
Flash Point	68°F (20°C)
Shelf Life - unopened container	2 years

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SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

APPLICATION DATA:

Mixing Instructions: Mix thoroughly before and during use
 Wet Film Thickness: 3.0 – 4.0 mils
 Dry Film Thickness: 1.0 – 1.5 mils
 Spray Viscosity: 25 - 35" #3 EZ Zahn
 Reducer: Typically not required but up to 10% Q80 (xylene) or Q50 (aromatic 100) can be used
 Clean up: Q80 (xylene), Q60 (MEK) or Q30 (acetone)

SPRAY APPLICATION	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001	20 - 25	50	66SS (0.070", 1.8mm)	67PB
Conventional	DeVilbiss MBC-510	20 - 25	50	E (0.070", 1.8mm)	92
Air Assisted Airless	Graco G-15	900 - 1300	20 - 40	0.017 - 0.019"	249596
HVLP	DeVilbiss JGHV	20 - 25	50 - 55**	E (0.070", 1.8mm)	83MP
Airless	Graco G-40	1400 - 2000	n/a	0.017 - 0.019"	n/a

*or equivalent

**atomization pressure should read <10 psi @ the cap

CURE SCHEDULES:

Air-dry (assumes 77°F & 50% Relative Humidity)	Bake / Force Cure
To Touch: 10 – 20 min.	Flash Time: 10 min. (ambient)
To Handle: 25 – 45 min.	Substrate Temp: 160°F
To Recoat: after 20 min. but before 14 days	Bake Time: 20 min.
To Topcoat: after 20 min. but before 14 days	

ADDITIONAL INFORMATION:

- ❖ Do not apply at temperatures below 40°F
- ❖ Excess film thickness will retard dry times and affect recoat window
- ❖ Coating is not considered fully cured until 7 days
- ❖ In-Service Temperature: 180°F (slight discoloration may occur after 150°F)
- ❖ Not recommended for use on galvanized, galvaneal or zinc rich surfaces

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