



Technical Data Sheet

Allcolour Paint Ltd.. Tel: 905-827-4173 Fax: 905-827-6487

03-4128

Grey Hi Sag LF Primer

Allcolour 03-4128 Grey Hi Sag primer is specifically designed to offer excellent corrosion resistance while maintaining an economical cost balance. This product shows exceptional performance characteristics on ferrous metals in metal fabrication and light duty OEM use.

Outstanding Characteristics

- Chromate Free
- Meets CISC/CPMA Std 2-75
- Quick Drying
- 1,000 Humidity Resistance (aluminum)
- 150 Hours Salt Spray per ASTM B117
- 50+ MEK Double Rubs (2 weeks air dry)
- 8-10 Mil Sag Resistance*

*Sag resistance will decrease at lower temperatures

Physical Data

Finish:	Low Gloss
Colour:	Grey
Weight Solids:	62.0 +/- 3.0%
Volume Solids:	43.65 +/- 3.0%
VOC	4.1 lbs/usg

Resistance Table

This product will resist most mild chemicals such as oil and gasoline in splash and temporary spill applications. In addition, this product is well suited as a temporary anticorrosive coating in humid environments.

Recommended Line Systems

- 55-Line: Allguard Polyurethane Rust Paint
- 01-Line: Auto Finish Industrial Enamel
- 23-Line: Fast Dry Enamel

Note: 03-4128 is not intended for use with two component products as wrinkling or lifting may occur



Surface Preparation

Ferrous (Steel)

Must be clean and free from dirt, oil, grease, rust or other contaminants. Sandblasting to SSPC SP-6 or better is recommended. Proper surface preparation will enhance the performance of the coating system. Galvanized or Satin Cote substrates may require a Vinyl Wash primer such as 36-6001 or 36-6018 to ensure good adhesion and coating performance.

Aluminum

Clean using an appropriate conversion treatment then prime with Allcolour 36-6001 or 36-6018 Vinyl Wash primer

Wood

Not recommended



Instructions for Use

Application...
Application Instructions...

Allow for application loss and surface irregularities.



Mixing Instructions

Components: One
Reducer: 20-4100 see reverse

Shelf Life...1 year from shipment date



Viscosity

Viscosity... 45+/- 3 seconds #4 Ford

Application Method

- Conventional Air Spray** Reduce up to 30% with 20-4100 to 22-28 seconds #2 Zahn Cup.
- Air Assisted Airless** Reduce up to 20% with 20-4100 to appropriate viscosity to suit the particular spray equipment, tip size and pressure.
- Airless** Reduce up to 10% with 204100 to appropriate viscosity to suit the equipment in use, tip size and pressure.
- Electrostatic Spray** Not recommended.
- Dip** Adjust reduction to allow appropriate run off based on part configuration.
- Brush or Roller** Use as supplied for small surface areas only.

Do not paint unless the temperature is a minimum of 5°F (3°C) above the dew point.

Recommended Film Build Thickness & Cover Rate

Allow for application loss and surface irregularities.
 Total Dry Film Recommendation.. 1.5-2.0 mils (37.5-50.0 microns) over surface profile
 Calculated Coverage

1.0 Mil DFT...	669 ft ² /usg
25 microns DFT...	17.0 m ² /L

Safety Precautions

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only

Dry Time

Dry time @ 25°C (77°F), 50% Rel. Humidity

To Touch:	5-10 Minutes
Tack Free:	10-20 Minutes
To Recoat:	
1 st Window	1-16 Hours
2 nd Window	After 3 days
DFT less than 2 mils**	
Hard:	24 Hours

Other

034128 may be reduced with a variety of solvents, however different solvents will effect the reduction rate, set times and potentially recoatability with itself. We recommend aromatic solvents only.
 Temperature range at application:

50-65°F (10-20°C)	Allcolour 20-4100, 20-4101
65-85°F (20-30°C)	Allcolour 20-4100, 20-4102
85-110°F (30-40°C)	Allcolour 20-4100, 20-4102, 20-4104

Clean Up

Cleaner: 204100

Storage & Shipping

Flash Point... 11°C 52°F