

# Dipping Primer

## General Properties

A general purpose red oxide primer which does not require a topcoat for interior uses when subjected to mild industrial atmospheres. This product features excellent pigment suspension and stability properties as required for dip tank operation. This product meets the requirements for CISC/CPMA 1-73, Quick Dry Primer for structural steel.

## Recommended Uses

For shop application on interior structural steel, beams and joists. See your Cloverdale Technical Representative for other applications.

## Product Information

<b>GENERIC TYPE</b>	Alkyd Resins
<b>PIGMENT TYPE</b>	Iron Oxide
<b>COLOR</b>	71358 Red Oxide
<b>BASES</b>	N/A
<b>FINISH</b>	Flat
<b>AVERAGE VOLUME SOLIDS</b>	35%
<b>AVERAGE WEIGHT SOLIDS</b>	56%

<b>RECOMMENDED FILM THICKNESS</b>	Wet: 4.3 - 5.7 mils Dry: 1.5 - 2 mils See your Cloverdale Representative for project recommendations.
<b>THEORETICAL COVERAGE</b>	561 ft <sup>2</sup> /gal @1 mil (25 microns) DFT 13.8 m <sup>2</sup> /L @ 1 mil (25 microns) DFT Actual coverage may vary depending on substrate and application methods.
<b>VISCOSITY</b>	55 - 58 K.U.
<b>TEMPERATURE RESISTANCE (DRY)</b>	93°C (200°F) Continuous 120°C (250°F) Intermittent
<b>V.O.C. AS APPLIED</b>	Less than 561 g/L (4.66 lbs/gal)
<b>THINNER</b>	78011 Xylene

## Methods of Application

<b>AIRLESS SPRAY</b>	Speeflo Atlas 30:1 with tip sizes .017" - .019" or equivalent
<b>H.V.L.P.</b>	N/A
<b>CONVENTIONAL</b>	N/A
<b>BRUSH / ROLLER</b>	Limited to touch-up areas only

**Drying Time** - Temperature, Relative Humidity, and Film Thickness will affect dry and re-coat times.

Substrate Temperature	Touch Dry	Hard Dry	Minimum	Overcoat Interval	
				Maximum	Normal
25°C (77°F)	1 hour	6 hours	2 hours	indefinite	4 hours

**Recommended Topcoat**

Solvent or water based Architectural paints. See Limitations.

**Surface Preparation**

Surfaces must be clean, dry and free of contaminants such as wax, oils, grease, weld spatter, loose mill scale or rust. A minimum SSPC-SP3 Power Tool Cleaning is recommended for interior exposure, however, an SSPC-SP6 Commercial Blast Cleaning will provide improved product performance.

**Limitations**

Not recommended for chemical or moderate to severely corrosive environments. Topcoats containing strong solvents may "lift" the primer. Always do a test patch before proceeding. Not recommended for wood or concrete.

**Mixing Instructions**

Mix well before using. Keep dip tank covered when not in use.

**Safety Precautions**

This product is for industrial use only. **Refer to Material Safety Data Sheet for proper health and safety information.**

**Storage and Handling**

<b>FLASH POINT</b>	-7°C (19°F) TCC
<b>PRODUCT WEIGHT</b>	10.07 lbs/gal (container extra)
<b>STORAGE</b>	Cool, dry, secure location. See your Cloverdale Paint Representative.
<b>PACKAGE SIZE</b>	5 gallon pail, 55 gallon drum

Some package sizes or colors may be by special order only. Please check with your Cloverdale Representative when ordering.

**Warranty Disclaimer**

Cloverdale Paint manufactures quality products. In the event that this product is defective or in any way unsuitable for the application for which it is sold, Cloverdale Paint Inc. will replace the product free of charge. The warranty provided by this data sheet is the only warranty or guarantee of quality made in respect of this product by Cloverdale Paint Inc. By purchasing this product the customer accepts this warranty in lieu of all others, and waives all claims to any other remedy arising from any warranty or guarantee of quality, whether such warranty or guarantee of quality was made expressly to the customer or implied by any applicable law.

Check for recent amendments to this data sheet at [www.cloverdalepaint.com](http://www.cloverdalepaint.com)

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