

# Equipment/Shopcoat Primer

## Technical Data Sheet (TDS)

### Product Description

**Crown Equipment/Shopcoat Primer** is one component fast drying industrial finishing primer intended for coating a large variety of metal products. Not for use on galvanized steel.

#### Product features:

- Quick drying
- Rust inhibitive
- Lead, chromate, and heavy metal free
- For use on ferrous metals
- Brush, roll, spray application

### Recommended Uses

**Crown Equipment/Shopcoat Primer** is intended for industrial applications; either new build or maintenance. It is ideal for OEM finishing or refinishing “production line” environments due to its versatility and efficiency of application

#### Industries:

- Oilfield & Energy Service
- Industrial Equipment
- Construction Equipment
- Agricultural equipment
- General Metal applications

### Mixing

**Stir each container thoroughly prior to use.**

Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment. For other spray methods, refer to Spray Gun Setup section.

### Product Characteristics

#### Typical Physical Properties

**Gloss:** Flat <10 GU at 60°

**Volume Solids (Single Component):** 46% +/- 2%

**VOC Single Component (Unreduced):**  
(EPA Method 24): White: 403 g/l (3.37 lb/gal)

**Note: The VOC level will vary per color.**

**Weight Gallon:** 10.9 lbs/gal± 0.2 lb/gal

**Shelf Life:** 2 years at 77°F (25°C)

**Note: For unopened product.**

### Surface Prep

Surfaces to be finished must be clean, dry and free of dirt, oil or any contamination that would adversely affect adhesion, protective properties or appearance of the coating.

Prepare metal surfaces to SSPC-SP2, SSPC-SP3 for normal requirements.

**Note: for optimal corrosion resistance and adhesion, iron phosphate treatment is recommended and/or P300 Series Metal Primer.**

All other substrates contact your Crown representative.

### Application Method

**Crown Equipment/Shopcoat Primer** can be applied by most spray painting systems including heated systems, dip application and flowcoat processes. It can also be applied by advanced application equipment such as turbo disk or bell.

May be brush or rolled.

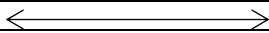
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### Spray Gun Setup

Feed Type	Fluid Tip	Application Pressures (heel of gun )	Fluid Delivery
Siphon Feed	1.6-1.8 mm	40-50 psi	
Gravity Feed	1.6-1.8 mm	30-40 psi	
Pressure Feed	1.4-1.8 mm	50-60 psi	10-14 oz/min
Air Assist Airless	0.009-0.017"	1,000-1,800 psi	
Airless	0.011-0.015"	1,700-3,000 psi	

### Spray Viscosity

60-65 KU at 77°F	Reduce as necessary*
	
Conventional	Airless

**Note: Spraying viscosity and thinning will depend on ambient conditions, spray equipment used, and the desired surface finish.**

**Note: Material is packaged at a viscosity requiring little or no reduction for application by airless spray equipment**

#### IF THINNING IS REQUIRED:

**Cool Weather: Below 65°F (18 °C)**

**Use:** Toluol/TS100

**Normal Weather: Below 65°F- 80°F (18 °C-27 °C)**

**Use:** Xylol /TS105

**Hot Weather: Above 80°F (27°C)**

**Use:** Xylol /TS105

SC-100 or SC-150 can be used as a retarder solvent to reduce dry spray and increase flow and leveling. Limit the level of SC-150 to 5% as a retarder solvent.

**Note: VM&P Naphtha (TS117) or Mineral Spirits (TS108) may be used.**

### Film Build

**Crown Equipment/Shopcoat Primer** has a recommended film build thickness of:

**Wet (unreduced): 3-4.5 mils wet  
(75-100 microns)**

**Dry: 1.5-2.2 mils dry (38-60 microns)**

Theoretical coverage at 1.0 mil (25 microns)  
 DFT: 737 ft<sup>2</sup> per gallon at 100% transfer efficiency.

### Dry Times

	70°F (21°C)
<b>To Touch</b>	5-10 minutes
<b>To Handle</b>	15 minutes
<b>To Recoat</b>	1 Hour
<b>Through Dry</b>	18 Hours

Optimum drying conditions are 60°F to 90°F (16°C to 32°C) at 50% R.H.

Lower temperatures and high humidity will slow dry.

Surface must be dry and at least 5°F above the dew point.

**Note: Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F may be utilized to accelerate solvent evaporation and speed oxidation.**

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### Topcoating Information

Crown Equipment/Shopcoat Primer may be topcoated with the entire range of Crown Topcoats.

### Clean Up

Clean all equipment immediately after use with xylol, aromatic solvent, acetone, or MEK for spray guns and line, pots and other equipment

Follow manufacturer's safety recommendations when using any solvent.

### Ordering Information (sizing)

Available in Aerosol, Gallon, 5-gallon, 55-gallon drum, and 300 gallon tote.

Custom colors and sizes may be available.

### Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be above 50°F (10°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point at all times.

**Note: For use outside this range please contact your Crown Representative.**

### Specifications

Test	Method	Result
Salt Spray / Corrosion	ASTM B117	240 hours. no field rusting, less than 1/8" creep from scribe 336 hours w/P315
Adhesion:	ASTM D3359	5A; 100% B-1000 panel
Impact resistance	ASTM D2794	20 lbs direct 10 lbs reverse
Flexibility	ASTM D522	1/8 mandrel bend: Pass

### Storage Conditions

#### Storing partially used container:

Pour a small amount of the recommended thinner over the surface.

Do not stir. Replace lid securely.

Store away from heat or open flame

#### Mix thoroughly before reusing.

### Safety Precautions

Please refer to all Safety Data Sheets (SDS) before using this product. SDS sheets can be obtained by contacting Crown Paint.