Tufcote™ 2.1 PR- 690 series 692, 693 Primer

(Formerly Ellis Shop Primer 692, 693)

GENERAL

DESCRIPTION

Tufcote 2.1 PR primers are solventborne, 2.1 lbs/gal (250 g/l) VOC made from a durable, alkyd co-polymer resin, designed to have good adhesion to practically any firm surface. These primers contain rust inhibitive pigments for anti-corrosion protection. Tufcote 2.1 PR 692, 693 primers are ideal for priming projects which require a low cost, low VOC, compliant primer.

SUGGESTED USES

As an economy coating for use on properly prepared steel, such as: buildings, railings, and structural steel surfaces where the following attributes are desirable:

- Low VOC
- Good bonding characteristics
- Fast dry excellent hide and coverage
- Good weather and corrosion resistance
- Easily applied using conventional methods of equipment

COMPATIBILITY WITH OTHER COATINGS

- Tufcote 2.8 HG Acrylic Alkyd 3100 series topcoat
- Tufcote 2.8 HG VT Alkyd 3300 series topcoat
- Tufcote LV HG Arylic Alkyd 4400 series topcoat

COLOR

692 Red Oxide
693 Grey

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Tufcote 2.1 PR 690 Series Primer	1 gallon container 100% full (128 oz.)

MIX RATIO

Ready to use

MIXING

Mix thoroughly before use and/or after thinning.

Reduction

If thinning is necessary, reduce with Tufcote 8020 Zero VOC Exempt Solvent, up to 10%.

POT LIFE

n/a

APPLICATION

APPLICATION CONDITIONS

Application at air and surface temperatures lower than 125°F (52ºC) and above 50°F (10ºC) and more than 5°F (-15ºC) above the dew point is suggested.

SURFACE PREPARATION

All surfaces to be primed must be clean, dry and in fit condition to be painted. Be sure to remove all wax, silicone, oil, powdery or scaling rust, lose or peeling paint and all other foreign matter. Smooth, slick surfaces should be sanded to promote adhesion.

BARE FERROUS METALS: Clean off all dirt, grease, oil, wax or other foreign matter. All loose, powdery or scaling rust must also be removed. A completely de-rusted surface is recommended.

For best results on steel, abrasive blast surface to an SSPC-SP-6 Commercial Blast. Profile should be 2.0 to 2.5 mils. Average peak to valley surface profile shall be 1.5 to 2.5 mils. If blasting is not possible or practical, hand tool clean to an SSPC-SP 2 or power tool clean to an SSPC-SP 3 may be used with sacrifice in performance vs. blasted surfaces.

Aluminum surfaces should be properly treated. Surface preparations may include sanding, brush off blasting (SSPC-SP7), alodine treatment, treatment with an acid, or other preparation necessary to ensure adhesion. All aluminums are not alike, it is strongly suggested that adhesion testing be done to assure system robustness.

PAINTED SURFACES: Be sure all loose and peeling paint is completely removed, and the surface is clean. Remove excess chalkiness with a wire brush or by sanding.

APPLICATION

Tufcote 2.1 PR 690 Series Primer may be used as a temporary coating on steel which is in between the fabrication and top-coating stages. If there is an extended time between priming the metal and application of the topcoat (more than 2 days), be sure surface is properly inspected, cleaned, and prepared prior to the application of the topcoat.

Spray apply 1 or more coats. Time between coats is not critical. Thin to spray viscosity.

Brush and rolling: Not recommended, except for small surfaces. Apply at package consistency.

Note: Tufcote 2.1 PR 690 Series Primer should not be top coated with any epoxy, vinyl or acrylic coating until full cure is achieved. This can take as long as two weeks depending on temperature and dry film thickness. Always use a patch test when using these strong top coatings to be sure of success.

CLEAN UP THINNERS

Equipment should be thoroughly cleaned immediately after use in an enclosed spray equipment cleaner with Tufcote 8020 Zero VOC Exempt Solvent.

To avoid spontaneous combustion, soaked, soiled rags, spray booth filters, overspray waste and dry dust sweepings must be properly discarded in water filled containers and disposal regulations.

DRY TIMES

Cure Time at Recommended Thickness @ 50% RH

	77°F (25°C)
To Touch	15- 20 minutes
To Handle	3-4 hours
Recoat Time	4-6 hours

PHYSICAL PROPERTIES

Viscosity	75-80 Kreb Units @ 77ºF
Volume Solids	60-64%
Weight Solids	76-80%
Theoretical Coverage Per Gallon	972-1013 ft² per gallon @ 1 mil DFT
Solvents Used	Aromatic & Aliphatic Hydrocarbons / Ketones
Flash Point	1ºF/TCC 111
Gloss	Flat
Shelf Life	12 months
Recommended DFT	2-3 mils DFT (5-7 mils WFT)

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between 35ºF (2ºC) and 90ºF (32ºC).

VOC REGULATIONS

VOC (Theoretical, varies with color).

2.1 lbs/gal (250 grams per liter) or less

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States:
1.855.6.AXALTA
axalta.us/industrial

In Canada:
1.800.668.6945