

220D3-946

Gray WB Spray Primer



GENERAL

DESCRIPTION

220D3-946 is a waterbased spray primer which provides corrosion protection to steel components and fabricated steel units. This coating is intended to provide temporary protection to steel members during storage and delivery in an atmosphere comparable with SSPC Environmental Zone 1, normally dry. This coating is intended to be used as a holding primer that may or may not be removed before or after erection or assembly in the field.

SUGGESTED USES

This product is specifically designed for use on various steel components coated by spray operations. This coating has also been specifically designed to replace higher VOC solvent based products for use on steel as a shop or field applied primer coating.

- Low VOC
- Fast dry time
- Good corrosion resistance
- Good water resistance

COMPATIBILITY WITH OTHER COATINGS

Many commercial topcoats can be applied over this primer, including alkyds, epoxies, polyurethanes, and acrylics. Always test for lifting, bubbling and adhesion to assure compatibility prior to full-scale painting. Contact your Axalta representative for specific recommendations.

COLOR

Gray



MIXING

COMPONENTS

220D3-946

MIX RATIO

Ready to use

REDUCTION

No thinning is required. If thinning is necessary, use potable water.

POT LIFE

Not applicable.



APPLICATION

SURFACE PREPARATION

Poor surface preparation will reduce the overall performance and service life of the coating. Steel surface should be clean, dry and free of any oil or dirt. To achieve the maximum benefits of the coating, this coating should be applied over cleaned or abrasive blasted substrates such as SSPC-SP 2, 3, 6, 7 or 10 surface preparations.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 40°F (5°C) or above 110°F (43°C). Apply only in good weather or in covered areas protected from environmental conditions. Substrate and air temperatures must be at least 5°F above the dew point and rising. Avoid painting late in the day when temperatures fall and relative humidity increases toward the dew point. Water condensation on the new film may cause surface imperfections and poor cure.

SPRAY APPLICATION

Conventional pressure pot spray, airless spray, or air-assisted airless spray applications are recommended. Touch-up of small areas may be performed by using nylon brushes or short-nap, rosin-core rollers.

CLEAN UP THINNERS

Water



DRY TIMES

Cure time at recommended thickness @ 77°F (25°C) / 50% RH, with good air movement

To touch	10-15 min
To handle	15-30 min
Recoat	60 min (minimum)
Dry Hard	12 hrs



PHYSICAL PROPERTIES

Maximum Service Temperature	120°F (50°C) in continuous service
Volume Solids	30.0%
Weight Solids	42.5%
Theoretical Coverage Per Gallon	480 ft ² @ 1 mil DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Suggested Film Thickness	2 +/- 0.5 mils DFT
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Application by brush and roller may require additional coats to achieve recommended films thickness.

Gloss	Flat
Package Size	5 gal pail, 50 gal drum, 330 gal plastic tote
Shelf Life	1 year minimum (unopened)

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between 40°F (5°C) and 110°F (43°C).

This product may settle during transit or storage. Agitate well before each use.

VOC REGULATIONS

VOC (as supplied)	0.14 lbs./gal
VOC (minus water and exempt solvent)	0.45 lbs./gal
Flash Point	See SDS



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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