



PRODUCT DATA

111 South Maple Avenue, South San Francisco, CA 94080

800-877-5997 • (650) 873-5990 • FAX: (650) 873-7441

INHIBO RUST INDUSTRIAL PRIMERS "SOLVENT BASE"

PRODUCT CODE: **101-03X**

PRODUCT DESCRIPTION: A high solids, low V.O.C. universal alkyd resin primer formulated for Professional, Commercial, Industrial environments where protection against atmospheric corrosion on Iron, Steel and Ferrous Metal substrates is required.

PRODUCT USE: These primers are specifically designed to be used as a combined Corrosive Protective Primer/Finishing Performance System with Simpson Coatings Inhibo Rust Industrial Enamels #101-0XX over: **Interior and Exterior properly prepared Iron, Steel and previously painted Ferrous Substrates.** The versatile application ability to be finish coated with a variety of Interior and Exterior Alkyd and Latex finishes makes these products the choice corrosive protective metal primers for the Farm, Industrial Shop/Industrial Maintenance and Structural Steel Environment.

Inhibo Rust Industrial Primers are available in one and five gallon containers.

**101 – 031
Red Oxide Primer**

**101 – 032
Grey Primer**

**101 – 033
Red Lead shop Coat**

**101 – 034
Yellow Zinc Chromate**

**101 – 035
Green Zinc Chromate**

**101 – 036
Wrought Iron White**

**101 – 037
Wrought Iron Black**

SURFACE PREPARATION

WARNING!

If you scrape, sand, or remove Old Paint, you may release Lead Dust. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a NIOSH-Approved Respirator to control Lead Exposure. Clean up carefully with a HEPA Vacuum and Wet Mop. Before you start, find out how to protect yourself and your family by contacting The National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

ALL SURFACES:

Surfaces must be clean, dry and free of dust, oil, grease, wax or any contaminants that would adversely affect the adhesion or performance of this coating. Remove all oils, dirt and other contaminants by cleaning with a V.O.C. compliant commercial cleaner/degreaser. Rinse thoroughly and allow to dry.

ALL MILDEWED SURFACES:

Existing mildew should be removed by washing the affected area with a 3:1 solution of water and chlorine bleach or a reliable commercial mildewcide. Keep applying until all discoloration is removed. Rinse thoroughly and allow surface to dry before recoating.

NEW SURFACES

NEW METAL SURFACES: Prepare new metal surfaces as directed with all surfaces.

FERROUS, GALVANIZED SURFACES:

Galvanized steel surfaces can be variable substrates due to the changing process of the Galvanizing Industry and/or the age of the galvanizing. Etch all galvanized and ferrous metal surfaces with Simpson Coatings #111-055C DOD-P-15328 Pretreatment Vinyl Wash Primer, a two component system composed of 4 parts #111-055A and one part #111-055B, applied at .25 to .5 mils dry. Allow 3 to 4 hours dry time to recoat with finishing coat.

NOTE:

Pretreatment Vinyl Wash Primer is intended to be used as a surface treatment to increase maximum adhesion to the primer system. To insure best results, the Pretreatment must be recoated within 4 hours with Inhibo Rust Industrial Primer #101-03X as soon as the material is sufficiently dry as directed.

PREVIOUSLY COATED SURFACES

ALL PREVIOUSLY COATED SURFACES:

Clean thoroughly as directed for all surfaces. Remove all loose peeling paint and chalk oxidation by sanding or pressure washing. Glossy surfaces should be dulled by sanding for maximum adhesion. Sand blasting or high-pressure water jet is recommended for the more severely deteriorated surfaces.

PREVIOUSLY COATED METAL SURFACES:

Remove loose rust, mill scale, chalky oxidation and deteriorated previous coating by wire brushing or coarse sandpaper. If rust is underneath the paint film, remove the paint finish until a ring of bright metal is exposed around the edges of rusted areas. Sand blasting or mechanical sanding is recommended for the more severely heavily contaminated surfaces.

APPLICATION INFORMATION

Estimation of practical coverage of this product can be variable and is completely dependent on application technique i.e., (determine amount of wet film thickness application to achieve dry film thickness) and the porosity of the substrate.

Drying time and curing time can be adversely affected by extreme high/low substrate and atmospheric temperature variances, along with extreme high/low humidity. Apply when **air, product and surface temperatures** are between **60 °F – 90 °F**, the relative humidity is no greater than **85%**, and surface is at least **5 °F** above the dew point.

ALL METAL SURFACES:

Apply Simpson Coatings Inhibo Rust Primers with Professional Airless, Conventional or HVLP Spray Technology. Apply two coats @ 3.1 to 4.3 mils wet to achieve 1.5 to 2.0 mils dry film thickness, allowing an average of 8 to 24 hours drying time in between each coat. An average of 6 to 36 hours dry time must be allowed before applying the finish coat. Please see the following Product Technical Data/Physical Properties sheets (pages 4 through 10) for individual products scheduled recoat time and full cure time specifications.

THINNING/CLEAN – UP

BRUSH/ROLLER: Do Not Thin.

AIR ATOMIZED/AIRLESS
OR HVLP SPRAY:

DO NOT THIN THESE PRODUCTS. These products are ready-to-apply as packaged. Thinning these products can adversely affect film building properties, dry/cure times, and volatile organic compound (V.O.C.) emissions. Please review the U.S. E.P.A. National Rule and your Local Air Quality Management Districts Rules and Regulations regarding V.O.C. emissions and Clean Up Products Regulations for Architectural and Industrial Maintenance Coatings. If it is necessary to thin these products, ***Do Not Exceed Two Ounces of Simpson Coatings Inhibo Rust Spray Thinner #309–027 per gallon of Inhibo Rust Primers #101–03X.***

CLEAN – UP:

Use Simpson Coatings Acetone #304–013 for cleaning Application Tools and Spray Equipment only! **EXCEPT AS RESTRICTED BY YOUR LOCAL AIR QUALITY MANAGEMENT DISTRICT.**

EQUIPMENT RECOMMENDATIONS

BRUSH/ROLLER:

Use good quality synthetic brush or roller cover (1/4"-3/8"). Apply with full brush, avoid rebrushing or reworking material.

SPRAY:

Inhibo Rust Primers can be applied by Professional Airless, Conventional or HVLP Spray Technology.

101-03X Inhibo Rust Industrial Primers "Solvent Base" Technical Data/Physical Properties

Resin Type: Alkyd
Solvents: Aliphatic and Aromatic Hydrocarbons
Coatings V.O.C. < 420 G/L

PRODUCT	ANALYSIS						PRODUCT COVERAGE			
	Pigment % by weight	% Solids by weight	% Solids by volume	Gloss	Viscosity	Wt. Per Gallon	Recommended Dry Film Thickness	Recommended Wet Film Thickness	Practical Coverage (assume 15% material loss)	Theoretical Coverage @ 1 mil D.F.T.
101-031 Red Oxide Primer	43.7-44.3%	68.7-70.7%	50.0-52.0%	Flat	65-70 KU	10.8-11.2	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-032 Grey Primer	58.6-59.2%	70.8-72.8%	46.9-48.9%	Flat	77-83KU	12.1-12.5	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-033 Red Lead Shop Coat	45.0-45.6%	69.7-71.7%	46.9-48.9%	Flat	68-75 KU	11.5-11.9	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-034 Yellow Zinc Chromate	33.3-33.9%	64.5-66.5%	48.0-50.0%	Flat	70-80 KU	9.8-10.2	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-035 Green Zinc Chromate	33.7-34.3%	64.5-66.5%	48.2-50.2%	Flat	70-80 KU	9.8-10.2	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-036 Wrought Iron White	50.2-50.8%	67.8-69.8%	45.8-47.8%	Flat	65-70 KU	10.7-11.1	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-037 Wrought Iron Black	35.7-36.3%	63.7-65.7%	46.9-48.9%	Flat	60-70 KU	9.0-9.4	1.5-2.0 mils	3.0-4.0 mils	250-350 sq. ft.	340-390 sq. ft.

Dry times @ 77° F and 50% R.H.

Tack Free: 15-20 Minutes

Handle: 30-60 Minutes

Sand/Recoat: 1-2 Hours

Full Dry/Cure: 8-12 Hours

Special instructions:

Proposition 65 Warning
WARNING: THIS PRODUCTS CONTAINS CHEMICALS KNOWN TO THE STATE OF CALIFORNIA TO CAUSE CANCER AND BIRTH DEFECTS OR OTHER REPRODUCTIVE HARM.

TECHNICAL SERVICE: Technical Services are available through Simpson Coatings Technical Service Support at 1-800-877-5997

LIMITED WARRANTY: The statements on this bulletin product label, or by any of our agents concerning these materials are given for information only. They are believed to be true and accurate and intended to provide a guide to approved construction practices and materials. As workmanship, weather, construction equipment, quality of other materials and other variables affecting results are all beyond our control. The Simpson Coatings Group does not make nor does it authorize any agent or representative to make any warranty of MERCHANTABILITY OR FITNESS for any purpose or any other warranty, guarantee or representation, expressed or implied, concerning this material except that it conforms to the minimum standards set forth in the Simpson Coatings quality control standards. Any liability whatsoever of Simpson Coatings Group