

# PRODUCT

## INFORMATION



## Steeltech® Shopcoat Primer S4501

### DESCRIPTION:

Steeltech® Shopcoat Primer is a quality alkyd shop coat primer for priming structural steel and miscellaneous fabricated metal pieces. The high volume solids increases coverage rates compared to standard shop coat primers, and allow for single coat coverage. One 2.5 mil DFT coat protects steel in mild to moderate environments for 3 to 6 months prior to topcoating or enclosure.

Steeltech® Shopcoat Primer dries to a tough film capable of protecting the substrate during transit to the job site and during erection. It does not have a tendency to skin-off as easily as other oil based primers and dries to a hard finish which will accept alkyd topcoats without fear of alligatoring or cracking the topcoat. It becomes the base for many corrosion resistant coating systems.

Steeltech® Shopcoat Primer may be welded-through during erection to produce sound welds. It is formulated without the use of lead or chromate pigments and is VOC compliant below 3.5 lbs./gal. (420g/l).

### USES:

Marine structures	Hand trucks	Hoists
Structural steel	Racking	Handrails
Machinery	Piping	Tank exteriors
Equipment	Bar joists	

**SIZES:** Available in 1 gallon cans, 5 gallon pails, and 53 gallon drums.

### SURFACE PREPARATION:

All steel must be free of dirt, oil, moisture, grease, mill scale, and rust. May be applied over SSPC SP-2 or SP-3. For best results prepare surface according to SSPC SP-7, brush-blast clean.

**MIXING:** Mix well before use. Iron oxide may settle.

### TECHNICAL DATA

**Vehicle:** Oil Based Alkyd-Red Oxide

**Components:** One (color: red oxide)

**Sheen:** Flat

**Flash Point:** 45°F

**% Solids:** By Volume: 46.0%

**VOC Level:** 3.5 lbs./gal. (420 gm/l)  
maximum

**Rec. Film Thickness:** 4.0 - 5.0 mils wet film

**Rec. Film Thickness:** 2.0 - 2.5 mils dry film

**Spreading Rate:** 365-400 sq. ft./gal.

**Pot Life:** N/A

**Shelf Life:** 12 months

**Application:** Apply by airless, conventional spray, brush, or roller

**Drying Time @ 77°F (25°C):** Set to touch 20 mins. Dry to handle 3 hours. Dry to topcoat minimum 18 hrs., max. 48 hrs. After maximum topcoat time, primed surface must be abraded prior to recoating or topcoating.

**Thinning:** Not required

**Cleanup:** Mineral Spirits.

**Limitations:** NOT INTENDED FOR IMMERSION SERVICE. Do not apply when surface temperature is less than 5°F (3°C) above the dew point. Do not apply when surface temperature is less than 50°F.

**Heat Resistance:** Up to 250°F dry heat (121°C)

**FOR INDUSTRIAL USE ONLY**

**Technical Information Line:**  
1-800-BUY-PRAT (1-800-289-7728)

**Website Address:**  
[www.prattandlambert.com](http://www.prattandlambert.com)

**2.03 IM**

## APPLICATION:

<b>Airless:</b>	Pressure	2000-2200 psi
	Tip	015" orifice tip
	Hose	1/4" ID
<b>Conventional:</b>	Atomization pressure	50 psi
	Fluid Pressure	15-25 psi
	Aircap	63PB
	Fluid Cap	63C
<b>Brush</b>	Natural Bristle (Thinning not recommended)	
<b>Roller:</b>	Woven, phenolic core (Thinning not recommended)	

## PHYSICAL TEST DATA\*

- Salt Fog (ASTM B-117): Passes 100 hours
- Chemical Resistance: (24 hr. Spot Test)
  - 50% Sodium Hydroxide ..... Very Good
  - Motor Oil ..... Good
  - Water ..... Very Good
  - Ammonia ..... Good
  - Acids ..... Poor

\*Testing based on:

- one coat at 3.0 mils DFT
- steel substrate (smooth)
- SSPC SP-1 surface preparation

## RECOMMENDED SYSTEMS

### FERROUS METAL:

(mild environments- indoors)

- Steeltech® Red Oxide Shopcoat Primer

(and)

- 1 or 2 coats Techgard Maintenance Gloss Enamel S4500 series at 1.5 - 2.0 mils DFT/coat

### FERROUS METAL:

(moderate environments- exterior exposure)

- 1 coat Steeltech® Red Oxide Shopcoat Primer S4501 at 2.0 - 3.0 mils DFT

(and)

- 1 or 2 coats Techgard Maintenance Gloss Enamel S4500 series at 1.5 -2.0 mils DFT/coat

or

- 1 coat Steeltech® Red Oxide Shopcoat Primer S4501 at 2.0 - 3.0 mils DFT

(and)

- 1 or 2 coats Enducryl DTM Gloss Acrylic Enamel 2.5 - 4.0 mils DFT/coat

For Additional Recommended Coating Systems Contact Your Pratt & Lambert Sales Executive.