

AMERCOAT® 5108

December 2012

Revision of October 2012

DESCRIPTION	Alkyd Shop Primer
PRINCIPAL CHARACTERISTICS	<ul style="list-style-type: none">– VOC Compliant <2.8 lb/ gal– Excellent sprayability– Resists corrosion
COLOR AND GLOSS	Oxide Red, Gray Flat
BASIC DATA	
Volume solids	51% ± 3%
VOC	2.8 lbs/gal (340 g/L)
Recommended	
Dry film thickness (per coat)	2 - 3 mils (50-75 microns)
Theoretical Spread Rate	@ 2 mils dft 409 ft ² / gallon
Components	1
Shelf Life	2 years from date of manufacture
SURFACE PREPARATION	
Steel	<p>Coating performance is, in general, proportional to the degree of surface preparation.</p> <ul style="list-style-type: none">– Remove all rust, dirt, moisture, grease or other contaminants from the surface. Power tool clean in accordance with SSPC SP-3 or hand tool clean to SSPC SP-2 requirements. Alternately, abrasive blast to SSPC SP-7 requirements. Abrasive blasting to SSPC SP-6 or better is also allowable and will give the best possible system performance. Achieve a blast profile of 1.0-2.0 mils. Avoid over-blasting as pin-point rusting may develop.– Remove all rust, dirt, moisture, grease or other contaminants from the surface. Lightly abrasive blast with fine abrasive to produce a uniform and dense anchor profile of 1.0 – 2.0 mils in accordance with SSPC SP-16. Alternately, disc grind or power sand with a hard grit to achieve a uniform and dense profile (minimum of 1 mil). Do not apply over galvanizing, zinc coatings, or concrete.
Non-ferrous metals	
ENVIRONMENTAL CONDITIONS	
Ambient temperatures	40°F to 100°F (5°C to 38°C) Surface temperature must be at least 5°F above the dew point temperature.
Material temperatures	50°F to 90°F (10°C to 32°C)
Relative humidity	85% maximum
Surface temperature	40°F to 110°F (5°C to 43°C)
General air quality	Area should be sheltered from airborne particulates and pollutants. Ensure good ventilation during application and curing. Provide shelter to prevent wind from affecting spray patterns.
INSTRUCTIONS FOR USE	
Mixing	Agitate with a power mixer for 1-2 minutes until completely mixed.
Airless spray	Pre-mix with a pneumatic air mixer at moderate speeds to homogenize the container.
Air spray	30:1 pump or larger, 0.015-0.017 fluid tip Thin up to 20%, standard conventional equipment, 0.070" fluid orifice, Separate air and fluid pressure regulators and a moisture and oil trap in the main air supply line are recommended.

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Brush & roll	Use a high quality natural bristle brush and / or solvent resistant, 1/4" nap roller. Ensure brush / roller is well loaded to avoid air entrainment. Level air bubbles with a brush. Multiple coats may be necessary to achieve adequate film build.
Thinner	<i>Amercoat 5108 is typically used without thinning. If thinning is desired, use Amercoat 15 (mineral spirits).</i>
Cleaning solvent	<i>Amercoat 12 Cleaner or Amercoat 65 thinner (xylene)</i>
Primers	Direct to substrate, application over aged coatings that are cleaned and abraded <i>(a test patch is recommended)</i>
Topcoats	<i>Amercoat 5400-series alkyls, 7-line alkyls</i>
Safety precautions	For paint and recommended thinners see safety sheet 1430, 1431 and relevant material safety data sheets This is a solvent borne paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes.

DRY/CURE TIMES*

	50°F	70°F	90°F
Dry to touch	60 min.	40 min.	30 min.
Dry through	24 hours	12 hours	6 hours
Dry to recoat / topcoat	24 hours	12 hours	6 hours
Maximum recoat / topcoat	unlimited		

* Dry times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Surface must be clean and dry. Any contamination must be identified and removed.

AVAILABILITY

Packaging	Available in 1-gallon and 5-gallon units	
Product codes	AT51082	Gray
	AT51087	Oxide Red

Worldwide statement

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