



Protective Industrial Coatings

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## Material Processing & Handling Information

**Material:** PW-1

**Material Type:** Primer

**Application:** Steel Surfaces

**Application Process:** Airless or Pump Spray, Roll or Brush

<b>Process Equipment:</b>	<b>Pump</b>	<b>Dispensing Gun</b>
<b>Graco:</b>	Ultra 395 Airless Sprayer (or similar)	Contractor Gun (or similar)
<b>Process Temperature:</b>	Ambient	
<b>Process Pressure:</b>	500 to 1,000 psi	
<b>Hand Process:</b>	1/4" or 3/8" nap roller or bristle brush	
<b>Moisture Content:</b>	Tramex concrete moisture meter: 5% maximum	
<b>Application Temperature:</b>	20°F and higher. Note that <b>PW-1</b> will cure at these temperatures, but cure times will be retarded with colder temperatures.	
<b>Dew Point:</b>	Substrate temperature must be 5°F above dew point and rising before application of coating materials.	
<b>Surface Prep:</b>	<b>Steel:</b> Minimum acceptable preparation levels for proper adhesion are SSPC SP 6.	
<b>Surface contaminates:</b>	Check for soluble salts on surfaces to be coated. Test with Chlor*Test. If amount of soluble salts exceeds recommended limits, treat with Chlor*Rid. Repeat process until acceptable limits are reached. Maximum amounts of soluble salts (micrograms per square centimeter): Chlorides - 3 immersion, 7 non-immersion Nitrates - 5 immersion, 10 non-immersion Sulfates - 10 immersion, 20 non-immersion	
<b>Adhesion Testing:</b>	Adhesion to steel: Minimum 500 psi.	
<b>Application:</b>	Apply in one coat using spray, roller or brush. Avoid ponding of material on horizontal surfaces. Excess materials should be wiped dry with a clean cotton rag.	
<b>Application Rates:</b>	<b>Steel:</b> Apply at rate of 400-500 square feet per gallon. Maximum overcoat time: 24 hours, after which a light recoat is required (1 to 2 wet mils).	
<b>Storage Temperature</b>	<b>Storage</b>	<b>Special Handling</b>
50°F minimum 70°F optimum	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Keep containers closed and protected from atmospheric contamination.

