



# CHEMCOAT, INC.

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*"Consistent Coatings . . . Superior Service"*

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## Product Data Sheet

PRODUCT: AC Hybrid Gray Spray Primer      FORMULA NUMBER: 41K-489  
OBJECT FINISHED: Structural Steel

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WEIGHT/GALLON:	10.68 lbs	RECOMMENDED REDUCTION:	None
VISCOSITY:	45-50" Zahn #2	REDUCER:	Water
GRIND:	5 hegman	REDUCED VISCOSITY:	Use as received
WEIGHT SOLIDS:	52.66%	RECOMMENDED FILM THICKNESS:	
V.O.C.:	0.77 lbs/gal minus water 0.86 lb VOC/gal of solids 3.31% VOC by weight 0.35 lbs/gal VOC emissions 44.03% water by weight	WET:	5-8 mils
VOLUME SOLIDS:	38.78%	DRY:	2-3 mil
COVERAGE:	622 sq ft/gal @ 1 mil dry	FLASH TIME:	30 minutes dry to touch
SUBSTRATE PREP.:	Recommended SSPC-SP2, Hand Tool Clean. For instances of extreme performance SSPC-SP6 Commercial Blast	BAKE TIME:	N/A
APPLICATION METHOD:	Air or Airless Spray	BAKE TEMPERATURE	Air Dry
EQUIPMENT SETTINGS:	For Air spray: Binks Model 18 spray gun w/#66 fluid nozzle and air cap. Use 50 - 70 lbs. of air pressure.	OVEN TYPE:	N/A
APPLIED OVER:	Clean Substrate	GLOSS:	Flat
USED UNDER:	Suitable topcoats are oil and water based enamels.	HARDNESS:	n/a
		IMPACT RESISTANCE:	n/a

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REMARKS: Please read Material Safety Data Sheet before Using. This product is based on a modified alkyd and is lead chromate free. This product should be stored indoors at temperatures between 60-100°F. This is a water based product and needs to be protected from freezing. Air, substrate, and paint temperature must be above 60 deg F to achieve proper film formation. Cleans up with water while wet, or small amounts of Acetone if dry. This primer can be welded through to produce sound welds. This product was designed as a low VOC primer to meet the performance requirement of SSPC #15.

DATE ISSUED: 12/21/2016

COMPLETED BY:

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