



Commercial Performance Coatings

AWP-404

CPC 84

Waterborne Acrylic Primer

| PRODUCT DESCRIPTION | |
|---|--------------------------|
| AWP-404 WATERBORNE ACRYLIC PRIMER | |
| TYPE: Waterborne Acrylic | |
| RECOMMENDED USE: AWP-404 Waterborne Acrylic Primer is designed for corrosion resistance when applied over properly prepared steel, galvanized steel and aluminum. This product is particularly suited for applications over shot or abrasive blasted metal including castings and fabrications for moderate exposure. | |
| PHYSICAL CONSTANTS | |
| WEIGHT PER GALLON: | 9.3 lbs +/- 0.2 lbs |
| PERCENT SOLIDS BY WEIGHT: | 45.1 +/- 2% |
| PERCENT SOLIDS BY VOLUME: | 38.1 +/- 2% |
| FLASH POINTS: | AWP-404 188°F (87°C) |
| VOC: | 2.0 lbs/gallon (maximum) |
| SHELF LIFE: | 12 months |
| PERFORMANCE FEATURES | |
| Color: | Gray |
| Gloss @ 60° Angle: | 25 |
| Pencil Hardness: | B |
| Conical Mandrel: | Pass |
| Impact Resistance: | 140 in-lbs. Direct |
| Adhesion: | 5B - Excellent |
| Topcoats: | WTR-100 |
| Above results obtained over iron phosphated Cold Rolled Steel panels | |
| CHEMICAL/SOLVENT RESISTANCE | |
| Chemical Resistance | Good |
| 100 Hours Humidity Resistance | Excellent |
| 250 Hours Salt Spray Resistance | Good |

SURFACE PREPARATION

The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.

| Metal | Recommended Primers | Direct To Properly Treated Substrate |
|--------------------|---------------------|--------------------------------------|
| Cold Rolled Steel | N/A | Excellent |
| Hot Rolled Steel | N/A | Excellent |
| Galvanized | N/A | Excellent |
| Aluminum | N/A | Excellent |
| Plastic/Fiberglass | N/A | |

APPLICATION DATA

MIXING DIRECTIONS

Stir thoroughly before and during use.

THINNING

N/A

POT LIFE

N/A

RECOMMENDED WET FILM BUILD

Spray Application: 5.5 – 8.0 mils

RECOMMENDED DRY FILM BUILD

2.0 - 3.0 mils

Film in excess or below these recommended film builds might cause problems such as: adhesion failure, pigment floatation, solvent popping.

DRYING TIME

Air-dry at 77°F

Dry to Touch: 1 hour

Dry to Handle: 3 hours

To Recoat: 1 hour

FORCE DRY

Flash: 10 min @ ambient
30 minutes @ 120°F
(peak metal temperature)

Drying time listed may vary, depending upon film build and temperature.

Application of film thickness in excess of that recommended for this product will substantially extend dry time.

RECOMMENDED SPREADING RATE

612 SQ. FT at 1.0 mil dry film per U.S. Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularity.

CLEAN UP: Soap and warm water

APPLICATION PRECAUTIONS AND LIMITATIONS: Do not apply at temperature below 60°F

PROTECT FROM FREEZING: In –Service Temperature 160°F

Brush and roller application is not recommended

| SPRAY APPLICATION | SPRAY EQUIPMENT | PRESSURE POT | PRESSURE (PSI) | ATOMIZING AIR (PSI) | TIP |
|----------------------|--------------------------------|--------------|----------------|---------------------|--------------|
| Conventional | Binks 95SL or equivalent | ¼ Fluid Line | 60 | 0 - 5 | 66SK |
| Conventional | Graco Air or equivalent | ¼ Fluid Line | 60 | 0 - 5 | .042 |
| Air Assisted Airless | Graco Alpha A.A. or equivalent | NA | 1000 - 1500 | 30 - 50 | .013 or .015 |

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.

SAFETY

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (304) 843-1300. CANADA (514) 645 - 1320 Have label information available.

MATERIAL SAFETY DATA SHEET

Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor.

FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.

PPG Industries
Commercial Coatings
We're Everywhere You Look

