



ACR-A-LAC™ Acrylic Primer Red 330-7

Acrylic Emulsion

PRODUCT DESCRIPTION	A premium quality, 100% acrylic latex corrosion inhibiting primer for ferrous metal, galvanized metal or aluminum. Lead, mercury and chromate free. Low VOC
TYPICAL USES	For industrial, commercial and residential use on machinery, piping, structural steel, storage tank exteriors and plant equipment. For priming properly prepared steel, galvanized metal and aluminum. Highly recommended as a metal primer for use under ACR-A-LAC™ Acrylic Latex Gloss Enamels.
PRODUCT ADVANTAGES	ACR-A-LAC™ Acrylic Primer Red offers excellent protection in exposures including mild industrial and marine environments. Excellent adhesion, flexibility, blister resistance and mild chemical resistance. Offers good durability when used as a shop primer when extended periods exist between priming and topcoating. Contains very effective nontoxic, non-chromate anticorrosive pigments to inhibit corrosion. Easy to apply, fast drying and low odor. Lead, mercury and chromate free. Low VOC. Meets the performance requirements of SSPC-Paint 23.
COLORS	Red
GLOSS	Flat
PHYSICAL CONSTANTS	Nonvolatile - By weight - 51.2 + 1.0% By volume - 41.2 + 1.0% VOC (Calculated) - 2.10 lbs./gal. (excluding water) 223 grams/liter Flash Point - > 250°F (Setaflash) Weight per gallon - 10.2 + 0.2 lbs.
APPLICATION	Recommended Film Thickness - 2.0 mils dry, 4.8 mils wet Theoretical Coverage @ 2.0 mils dry - 330 sq. ft./gal. Method - Brush, roll, conventional and airless spray. Thinner - Water Dry time @ 75°F - To touch - 1 hour To handle - 4 hour To recoat - 4 hours
SHIPPING & STORAGE	Consists of - 1 Gallon Unit 5 Gallon Unit Unit Shipping Weight 11 lbs. 54 lbs. Shelf Life - 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

APPLICATION INSTRUCTIONS

Consult your Mobile Paint Representative for the protective coating system best suited for your requirements.

Limitations: Apply in good weather when air and surface temperature are above 50°F and surface temperature is at least 5°F above the dew point. For optimum application properties, material should be between 70 to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40 - 100°F. Do not apply to uncured wood or masonry. May be applied to damp but not wet surfaces. Do not apply late in the afternoon or when there is a threat of rain or moisture condensing on the uncured paint. Do not apply in direct sun or on hot surfaces.

Surface Preparation: Good surface preparation is essential to a satisfactory coating system. Trapped internal moisture is the main cause of blistering paint. Vent problem areas prior to painting. Surfaces to be coated should be clean and dry. Remove all dirt, dust, oil, grease, mildew, rust, loose or cracked paint or other contamination. Remove mildew by scrubbing with a solution of 3 tablespoons of non-ammoniated dry household laundry detergent and 1 quart hypochlorite bleach in 1 gallon of warm water. Protective gloves, clothing and goggles should be worn when using this solution to avoid skin and eye irritation. Quickly wash off any of the solution that touches your skin. After scrubbing, rinse thoroughly with water and allow to dry.

New or Unfinished Surfaces: Ferrous metal: For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as the minimum for blast cleaning. Proper blast media and blasting equipment shall be used to produce an average profile depth of 1.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. If blasting is not possible, use "Hand or Power Tool Cleaning: (SSPC-SP2 or -SP3). **Galvanized metal:** Remove oil with mineral spirits. **Aluminum:** Etching with a phosphoric acid pretreatment solution is recommended for maximum adhesion. Clean all contamination by scrubbing with a mixture of household detergent and water or other effective means. Rinse clean with water and allow to dry.

Previously Painted Surfaces: Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7) Remove rust, corrosion products, heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). Spot prime any bare areas as required. If doubt exists concerning compatibility of this coating with the previous

system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

Tinting: Do not tint.

Mixing: This is a one component coating. Always mix thoroughly with a power agitator before application.

Thinning: This product is supplied at normal brushing viscosity. If thinning is necessary thin up to 1/2 pint per gallon with water.

Application: Apply by brush, roller or conventional or airless spray. Roller application may require special care to prevent bubbling and more than one coat to obtain proper film thickness. Apply at 4.8 mils wet film thickness which will yield 2.0 mils dry film thickness.

Equipment: Brush - Use a good quality nylon brush. Roller - All purpose, good quality roller with 3/8" nap maximum. Conventional spray - For suction feed, use DeVilbiss MBC gun with E tip and needle and 30 air cap or equivalent at 40-45 psi atomizing pressure. For pressure feed, use DeVilbiss MBC gun with E tip and needle and 704 air cap or equivalent at 40-45 psi atomizing pressure and 5-8 psi fluid pressure, 3/8" ID material hose, double regulated pressure tank with oil and moisture separator. Airless Spray - Minimum of 28:1 ratio pump, .013"-.015" orifice tip, 1/4" ID material hose.

Cleanup: Clean all equipment immediately after use with warm, soapy water. Completely flush all spray equipment with this solution. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging. Final flushing of spray equipment with mineral spirits will prevent corrosion.

Safety: Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

Notice: The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

330-7(7/99)

LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.