ROYAL COATINGS

AQ610 PRIMER

(WITH FLASH DRY TECHNOLOGY)

PRODUCT BULLETIN

Royal AQ610 Primer is a universal primer for steel fabrication that does not use submerged arc welding. Formulated using Royal's proprietary Flash Dry Technology surface rust is completely encapsulated with no bleed through. In addition to its outstanding protection properties, it significantly reduces the hazards of working with volatile compounds found in other VOC coatings. Royal AQ610 Primer cannot ignite and because it does not create any toxic vapors, the odor, headaches, and nausea often associated with other coatings are completely eliminated. Royal AQ610 Primer provides greater corrosion resistance for metals and greater health protection for workers.

KEY FEATURES

- SCAQMD VOC COMPLIANT
- EARLY WATER RESISTANCE
- SURFACE: SSPC-SP2
- WIDEST APPLICATION TEMPERATURE RANGE (37F – 120F)
- CERTIFIED TO BOTH MPI#107 / MPI#79 CROSS COMPATIBILITY
- ISOLATEK FIREPROOF COMPATIBILITY CERTIFIED

PHYSICAL DATA

Colors	Grey, Red & Black
Finish	5 – 10 GU
Components	1
Packaging	275 Gal Totes 55 Gal Drum 5 Gal Pail
VOC	25 grams/liter
Shelf Life	1 Year unopened
Surface Temp(F)	40 - 120
Volume Solids (%)	38% +/- 2
Viscosity (Stormer)	80 – 85 KU
Flashpoint(F)	>230 closed cup

MIXING INSTRUCTIONS

Mix paint thoroughly to a uniform consistency with low speed power agitation prior to use.

Do not let hydrocarbon solvents come in contact with this coating. For equipment and fluid line cleaning use only an emulsifying industrial detergent followed by a water rinse.

DRYING , 2 MIL DFT , 77F , 50% RH

(Results will vary with temperature, humidity and DFT)

Tack Free: 8 minutes To Touch: 15 minutes Tack Handle: 20 minutes

To Recoat: 30 minutes (with solvent or water-based topcoat)

Note:Consult your technical representative before topcoating

SAFETY PRECAUTIONS

Read material safety data sheet before use. Wash and clean up thoroughly with soap and water after handling.

APPLICATION METHODS

CONVENTIONAL -Fluid Pressure: 10 – 20 psi , Tip: .040" - .045"
-Atomization Pressure: 45 – 60 psi, Airless….Pressure: Adjust as needed ,Tip: .015" - .019"

HVLP -Brush, Roller or Dip

SPECIFICATIONS

A Minimum of 1 DFT is required.
Films of 1.5 – 2.0 DFT offer optimum corrosion protection.
Reduce with a maximum of 5% water *(DO NOT THIN WITH SOLVENTS)*

SURFACE PREPARATION

Minimum SSPC-SP2

RECOMMENDED SPREAD RATE PER COAT

	Minimum	Maximum
Wet mils (microns)	**4.0**(100)	**8.0**(200)
Dry mils (microns)	**2.0**(50)	**4.0**(100)
Coverage ft2/gal (m2/l)	**200**(5)	**400**(10)

PERFORMANCE CHARACTERISTICS

Scratch Resistance Method ASTM D3363	Result:	H , No visible damage
Adhesion Method ASTM D4541	Result:	350 psi
Flexibility Method ASTM D522 3/8"	Result:	180 degree bend passes
Water Resistance Method ASTM D1308	Result:	300 HRS , No blistering
Sag Resistance ASTM D4400-99	Result:	12 mil

MANUFACTURED BY

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