



Gillespie Coatings. Inc.
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G.C.I. PRODUCT DATA SHEET PR-571 0 VOC ACRYLIC WATERBORNE PRIMER

DESCRIPTION Premium quality water-borne primer

CHARACTERISTICS

- VOC compliant
- Resists corrosion
- Designed for long lived general service protection
- Excellent spray ability
- Superior lift resistant
- Tough and flexible
- Excellent adhesion to metal surfaces
- Excellent thermal performance properties
- Withstands bake cycles of 2 to 5 hours at 450 °F
- Withstands tank car temperatures of 300 °F
- Contains no lead or chromate pigments
- Single stage component

PRINCIPAL USE

- Rail car tank shells and inside tank jackets
- Truck parts, i.e. frames, bolsters, etc.
- For use in industrial, structural and transportation applications
- Industrial fabrication
- Interior or exterior metal surfaces
- Superior resistance to moisture or fumes

GLOSS AND COLOR

- Gloss Level of Finish; Flat: 3 – 5 @ 60' gloss
- Color: Black

PHYSICAL DATA

Vehicle	Acrylic emulsion Phenolic modified alkyd
Pigment Type	Carbon black, selected rust inhibitors & inerts
Solvent Type	Water
VOC	0 lbs. /gal.
Flash Point	Not applicable
Weight Per Gallon	10.2 lbs. /gal.
Recommended DFT	Dry Film Thickness: 4.0 – 6.0 mils DFT
Theoretical spread rate	544 Ft ² per gallon @ 1 mil
Volume Solids	34 %
Weight Solids	46 %
Viscosity	70 ± 5 KU @ 78 ° F.

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Limitations: Not for severe chemical, water immersion, or physical abrasion service.
Do not allow product to freeze. Improper storage, allowing material to freeze can make this product unusable.

APPLICATION DATA

Surface preparation Coatings performance is dependent upon surface preparation. Remove abrasive residue and dust from surface. Surface must be clean, dry and free from all oil, moisture, grease, mill scale and rust or other foreign material

Mixing Each container should be examined and stirred. No pigment settling should be encountered. A slight liquid separation may be encountered.

Method of application: Airless Spray

Recommended Thinning None required. If thinning needed, use water only.

Application Equipment Airless equipment type recommended. The following is a guide; suitable equipment from other manufacturers may be used. For proper spray characteristics, changes in pressure and type size may be needed.

Airless: ratio 30:1
Non-cycling, air pressure to pump, approximately 70 psi
Tip pressure approximately 1500 – 2000 psi

Airless tip sizes: .017-inch to .019-inch tip sizes

Film Thickness	Minimum / Maximum	
Wet Mils	14 Mils	16 Mils
DFT Mils	4 Mils	6 Mils

Application Conditions Optimum application temperatures are at temperatures above 50°F and surface temperatures must be at least 5° F above the dew point to avoid condensation formation. Do not apply when substrate temperature is below 50°F. Do not apply when humidity is high and condensation is possible.

Average Drying Time	
To touch	30 minutes
Tack free	1 hour
Through dry	2 hours

Dry times are affected by air and surface temperatures, relative humidity, ventilation and film thickness. Times based on 78°F

Clean Up Solvent Use soap and water

Clean equipment immediately after use.

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All surplus materials and empty containers should be disposed of according to regional regulations.

Recommended Top Coats Enamels:

Packaging Five gallon size container
 55 gallon size drum
 275 gallon tote

Shipping Data DOT Name : Paint
 Hazardous Class : not applicable
 UN Number : not applicable
 Packing Group : not applicable

Caution Statement Eye protection recommended

Avoid contact with skin and breathing of vapors or spray mist.

Gillespie Coatings, Inc. is responsible for technical accuracy and conformation to GCI specifications.