Gillespie Coatings. Inc.
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G.C.I. PRODUCT DATA SHEET
PR-1003 WHITE; PR-1113 YELLOW; PR-1123 GRAY; PR-1193 PRIMERS

DESRIPTION Premium quality phenolic epoxy ester modified alkyd primer

CHARACTERISTICS

- Resists corrosion
- Excellent spray ability
- Superior lift resistant
- Contains no lead or chrome pigments
- Single stage component
- Typical uses
  - 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: 5 to 15 @ 60 ^{o} gloss
- Colors
  - PR-1003 White
  - PR-1113 Red Oxide
  - PR-1123 Gray
  - PR-1193 Black

PHYSICAL DATA

Vehicle	Phenolic epoxy ester modified alkyd
Pigment Type	Exterior durable primer and inert pigments, rust inhibiting zinc phosphate and modified zinc phosphate. No lead or chromate pigments
Solvent Type	Aromatics blends and higher boiling point aromatics
VOC	4.5 $\pm$ 0.1 lbs. /gal.
HAP's	0.67 lbs. /gal. paint 1.28 lbs. /gal. solids
Flash Point	89^{o} F (minimum)
Weight Per Gallon	11.5 lbs. /gal.; varies with color
Recommended DFT	Dry Film Thickness - 1.5 – 2.5 mils
Theoretical spread rate	580 - 610 Ft^{2} per gallon @ 1 mil (varies with color)
Volume Solids	36 - 38%; (varies with color)
Viscosity	65 $\pm$ 5 KU @ 78 F.
Resistance	General service protection on metal surfaces. Superior moisture resistance for Alkyd system. Dry heat tolerance up to 250^{o} F
Limitations:	Temperature is limited to 250^{o} F. Not for severe service in environments such as acids, base or continuous immersion

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APPLICATION DATA

Surface preparation (*)

SSPC: SSP1 – solvent cleaning

SSPC: SSP2 – hand tool cleaning

SSPC: SSP6 to achieve 1.5 to 2.0 mils anchor profile (*****) as determined with a Keane-Tator Surface Profile Comparator, Testex Tape or similar device.

Remove abrasive residue and dust from surface. Remove weld splatter, round off rough welds and sharp edges. Surface must be clean and free from oil, moisture, grease, dust, mill scale and rust.

Mixing

Paint must be thoroughly mixed to a uniform consistency with a low speed air powered or explosion proof power agitator

Method of application:

Spray only

Application Equipment

Airless spray

The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure and type size may be needed.

Airless pump ratio 30:1
Non-cycling, air pressure to pump, approximately 40 - 50 psi
Tip pressure approximately 1600 - 2000 psi
Tip size: .015-inch to .017-inch

Conventional Spray

The following is a guide suitable for equipment from various manufacturers. For proper spray characteristics, changes in pressure and type size may be needed. Main line air supply with moisture and oil trap are recommended

Main airline pressure	100 psi
Fluid (pot) pressure	60 – 65 psi
Atomizing (gun)	40 – 70 psi
Quart cup	40 psi

Tip size: .046-inche to .070-inch

Recommended Thinning

Conventional equipment under normal conditions use GCI ES-5 (xylene). In high ambient temperatures, use GCI ES-2

Film Thickness

	Minimum / Maximum	
Wet Mils	3 Mils	5 Mils
DFT Mils	1.5 Mils	2.5 Mils

Application Conditions

Optimum application temperatures are at temperatures above 50°F (painting in direct sunlight not recommended in hot weather) and surface temperatures must

be at least 5° F above the dew point to avoid condensation formation. Do not apply when humidity is high and condensation is possible.

Average Drying Time

To Touch	10 - 15 minutes
Tack free	30 minutes
Through dry	8 hours
Re-coat	30 – 60 minutes for Alkyds; 6 months max

Dry times are affected by air and surface temperatures, relative humidity ventilation and film thickness.

Clean Up Solvent

GCI ES - 5 (xylene)
GCI ES - 19 (MEK)

Clean equipment immediately after use.

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

Recommended Top Coats

Enamels:
GCI Alkyd Enamel Series: 11, 25, 41, 44, 55, 75
Intermediate service, top coat with epoxy or polyurethane enamel
GCI 244 Compliant Series alkyd

Packaging

One gallon size container
Some colors available in five gallon pail or 55 gallon size drum

Shipping Data

DOT Name	: Paint, Liquid
Hazardous Class	: Flammable Liquid
UN Number	: 1263
Packing Group	: PGIII

Caution Statement

WARNING - Flammable Liquid

Primers are flammable. Keep away from open flames and heat. Use adequate ventilation. Avoid contact with skin and breathing of vapors or spray mist. Improper use and handling of this product can be hazardous to health and cause fire. Close container after each use.

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

(*) anchor profile reference by NACE International Abrasive/Profile Comparative Chart.