

# AQ610 Primer

(With Flash Dry Technology)

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

- SAW Tolerant
- SCAQMD VOC Compliant
- EARLY WATER Resistance
- Surface: SSPC-SP2
- Widest Application Range (37F-120F)
- Certified To Both MPI#107 / MPI#79 Cross Compatibility
- Isolatek Fireproof Compatibility Certified

## PHYSICAL DATA

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

## 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 uid 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 ft <sup>2</sup> /gal (m <sup>2</sup> /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° bend passes

## DISCLAIMER

The information contained in this bulletin is, to the best of our knowledge, true and accurate; but all recommendations or suggestions are made without guarantee, since the conditions of use are beyond our control. However, each user should review these recommendations in the specific context of the intended use and determine whether they are appropriate.