

AQ610 WATERBASED

Shopcoat Primer

RED OXIDE DRUM	634240415470	RED OXIDE PAIL	634240413947
GRAY DRUM	634240415487	GRAY PAIL	634240419927
WHITE DRUM	634240415492	WHITE PAIL	634240412830
BLACK DRUM	634240411562	BLACK PAIL	634240416181

PRODUCT INFORMATION

PRODUCT DESCRIPTION

AQ610 WATERBASED SHOPCOAT PRIMER is a universal primer for steel fabrication. Formulated using Royal's proprietary Flash Dry Technology surface rust is encapsulated with no bleed through. In addition to its outstanding protective properties, it significantly reduces hazards of working with volatile compounds found in other VOC coatings.

PRODUCT CHARACTERISTICS

Finish	Flat
Color	Red Oxide, Gray, White and Black
Volume Solids	34% ± 2%, may vary by color
Weight Solids	41% ± 2%, may vary by color
VOC	<25 g/L; 0.21 lb/gal

RECOMMENDED SPREADING RATE PER COAT

	Minimum	Maximum
Wet mils	3.0	4.5
Dry mils	1.25	1.75
~Coverage sq ft/gal	310	435
Theoretical coverage sq ft/gal @ 1 mil dft	544	

Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

DRYING SCHEDULE @ 4.0 MILS WET @ 50% RH

	@ 40°F	@ 77°F	@ 120°F
To touch	30 minutes	10 minutes	10 minutes
Tack-Free	5 hours	45 minutes	45 minutes
Dry-Hard	6 hours	2 hours	1 hour
To handle	7 hours	2.5 hours	1.5 hours
To recoat	10 hours	2.5 hours	1.5 hours

If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent. In high humidity use airflow to improve dry time.

Shelf Life	12 months, unopened at 77°F Protect from freezing
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RECOMMENDED USES

Flash Point N/A

Reducer/Clean Up Water

If Dried, clean with a blend of ammonia and water 1:9.
Spray equipment may also be cleaned with MIBK. After Cleaning,
flush equipment with solvent to prevent rusting.

For industrial and commercial application to steel for
protection against atmospheric corrosion.

In some cases, this primer can be top-coated with solvent based
urethanes and epoxies depending on solvent blend. A test patch is highly
recommended to test compatibility.

PERFORMANCE CHARACTERISTICS

SAW Tolerant

SCAQMD VOC Compliant

Early Water Resistance

Surface Tolerant: SSPC-SP2

MP#107 , MP#79 Compliant

Isolatek Fireproof Compatibility Certified

LIMITATIONS

High humidity will slow drying

Excessive film thickness may cause mudcracking

Due to the wide variety of substrates, surface preparation methods and applica-
tion methods and environments, the full system should be tested for adhesion and
compatibility prior to full scale application.

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease,
dirt, loose rust, fingerprints and other foreign material to ensure good adhesion.

For maximum performance, the surface must be abrasive blasted
for proper adhesion. All blasted steel must be primed the same day.

IRON AND STEEL

Remove all grease and oil from the surface by solvent cleaning using a
non-hydrocarbon solvent per SSPCSP1. Minimum surface preparation is Hand
Tool Clean per SSPC-SP2. For optimum performance, the surface should be blast
cleaned to Commercial Blast Clean per SSPC-SP6.

APPLICATION CONDITIONS

Temperature 40°F minimum, 100°F maximum
(air, surface, and material).
At least 5°F above dew point



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APPLICATION METHODS

AIRLESS SPRAY

CONVENTIONAL

BRUSH

CAUTIONS

SAFETY PRECAUTIONS

WARRANTY

Relative humidity 85% maximum

Primer coats used for exterior applications should not be left untopcoated in excess of six months.

Airless Spray, Conventional, Roller and Brush

Unit: 1500 - 2100 psi **Tip:** .011 - .013 **Filter:** 60 Mesh **Cap/Tip:** 704FF

Air Pressure: 45-55 psi **Fluid Pressure:** 10-15 psi **Hose:** 1/4"

Reducer: Water **Reduction Rate:** Up to 10%

Confine to small areas and touch-up.

Refer to MSDS Sheet before use.

NOTE: SOLVENT BASED COMPATIBILITY SHOULD BE CHECKED PRIOR TO USE.

AQ610 Water based Primer is extremely sensitive to hydrocarbon containing solvents. When cleaning the surface per SSPC-SP1, use only an emulsifying industrial detergent, followed by a water rinse. Do not use hydrocarbon solvents.

During the early stages of drying, the coating is sensitive to rain, dew, high humidity, and moisture condensation. Avoid these conditions for the first 24 hours.

Stripe coat all crevices, welds, and sharp edges to protect against early failure in these areas. For best results on rusty surfaces, always apply first coat by brush. No painting should be done immediately after a rain or during foggy weather.

DO NO USE HYDROCARBON SOLVENTS FOR CLEANING.

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Royal Coatings representative for additional technical data and instructions.

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