

SSPC-PAINT 25
Red Iron Oxide, Zinc Oxide,
Linseed Oil, Alkyd Primer
28-DR-169

Modified Alkyd

P.O. BOX 717 • THEODORE, ALABAMA 36590 -0717 • PHONE (251) 443-6110 • FAX (251) 408-0410**PRODUCT DESCRIPTION**

A slow drying iron oxide, zinc oxide, linseed oil modified alkyd primer for steel. Meets the requirements of SSPC-Paint Specification No. 25 (1 November 1982).

TYPICAL USES

For industrial and commercial use as a primer suitable for exposures in Environmental Zones 1A (interior, normally dry) and 1B (exterior, normally dry), and is intended for brush or spray application over properly prepared steel surfaces or a minimum surface preparation of SSPC-SP2 "Hand Tool Cleaning". SSPC-Paint 25 is suitable as a shop primer, field primer, maintenance primer or intermediate and is to be applied in accordance with SSPC-PA 1, "Shop, Field and Maintenance Painting". If the primer is to be exposed to the weather, it should be topcoated as soon as practical.

PRODUCT ADVANTAGES

SSPC-Paint 25 is lead and chromate free. Low VOC. Exhibits good substrate wetting ability, even for non-blast cleaned steel surfaces. Good resistance to weathering for normal periods, up to 30 days, before topcoating.

COLORS

Red/Brown oxide

GLOSS

Eggshell to low semigloss

PHYSICAL CONSTANTS

Nonvolatile -	By weight - 77.0 minimum
	By volume - 63.0 ± 2%
VOC (Calculated) -	2.29 lbs./gal.
	274 grams/liter
Flash Point -	106°F (Setaflash)
Weight per gallon -	12.0 minimum

APPLICATION

Recommended Film Thickness - 2.0 to 3.0 mils dry, 3.3 to 4.8 mils wet
 Theoretical Coverage @ 2.0 mils dry - 505 sq. ft./gal.
 Number of Coats - As required by specification and application desired.
 Method - Brush, roll, conventional or airless spray
 Thinner - MoPaxOI Low Odor Paint and Varnish Thinner 75-1 or Mineral Spirits
 Dry time @ 75°F -

Tack Free	-10 hours maximum
Dry hard -	24 hours maximum
To recoat -	24 hours minimum (at 50% relative humidity)

SHIPPING & STORAGE

Consists of -	1 Gallon Unit	5 Gallon Unit
Unit Shipping Weight	13.5 lbs.	65 lbs.

Shelf Life - 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

APPLICATION INSTRUCTIONS

Consult your Mobile Paint Representative for the protective coating system best suited for your requirements.

Limitations: Apply in good weather when air and surface temperature are above 40°F and surface temperature is at least 5°F above the dew point. For optimum application properties, material should be between 70° to 90°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40° - 100°F.

Surface Preparation: Good surface preparation and cleaning of the substrate is essential to the performance of the coating system. All surfaces to be coated should be dry, clean and free of all contaminants. SSPC-Paint 25 is intended as a primer over hand cleaned steel in atmospheric exposures. Its performance is related directly to the degree of substrate cleaning that is accomplished. Blast cleaning, power tool cleaning or pickling are acceptable. All rust scale, loose or non-adherent paint, oil, grease and dirt shall be removed. Residues of oil, grease and dirt remaining on the surface will result in decreased paint performance.

Steel - For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP 6) is recommended as the minimum. Proper blast media and blasting equipment shall be used to produce an average profile depth of approximately 1.5 mils. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. When blasting is not practical the surface may be prepared in accordance to "Hand Tool Cleaning (SSPC-SP 2), "Power Tool Cleaning" (SSPC-SP 3), or "Pickling" (SSPC-SP 8). Longevity and performance is determined by the surface preparation performed.

Previously Finished Surfaces - Repair all damaged areas. Remove gloss from previous coats of system by hand sanding or "Brush Blasting" (SSPC-SP 7). Remove rust, corrosion, heavy chalk and loose or peeling paint by "Hand Tool Cleaning" (SSPC-SP 2) or "Power Tool Cleaning" (SSPC-SP 3). Spot prime any bare areas as required. If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (25 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed. If heavy rust, corrosion or peeling exist prepare surface as recommended under "Steel".

Mixing: This is a single component material. All material should be thoroughly mixed with mechanical agitation prior to use. If the pigment has settled, pour off most of the liquid, thoroughly mix the pigment with the remaining liquid, taking care to scrape all the pigment off the bottom of the can. Gradually add the poured-off liquid and mix thoroughly. Mixing may be made easier by transferring contents to a larger container or by pouring the paint to and from another container. Examine bottom of container for unmixed pigment. Strain paint before applying.

Thinning: This product is supplied at normal brushing viscosity. Under normal conditions, no thinning should be necessary. Thin paint only if necessary. Thin up to 1/2 pint of thinner per gallon for brush application and up to 1 pint of thinner for spray application, using only MoPaxOI 75-1 or Mineral Spirits. The paint should be kept covered at all times to prevent contamination.

Application: Apply by brush or spray to the specified film thickness or, if not specified, to at least 2 mils (51 microns) dry or approximately 3.3 mils (84 microns) wet. Brush - Use a good quality bristle brush. Conventional spray - Binks 18, 62 or 2001 gun with 63B Fluid Nozzle and Needle set-up and 63PB Air Cap or equivalent at 40 - 60 psi atomizing air pressure and 5 - 30 psi fluid pot pressure, 3/8" ID Fluid Hose, 5/16 Air Hose, Double Regulated Pressure Pot, with Oil and Moisture Separator. Airless Spray - Minimum of a 28:1 ratio pump, .011" - .017" tip, 1/4" ID Teflon material hose. The finished coating shall be free from holidays, pinholes, bubbles, runs, drops, ridges, waves and laps. Allow a minimum of 24 hours drying between coats at 2 mils dry (3.3 mils wet) 75°F ambient temperature with a maximum of 50% relative humidity. A longer recoat period may be required if conditions vary.

Cleanup: Clean all equipment immediately after use with MoPaxOI 75-1 or Mineral Spirits. Completely flush all spray equipment with either of these solvents. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

Safety: Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

Notice: The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard Conditions of Sale. Published technical data and instructions are subject to change without prior notice.

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LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.