



SPECTRACRON® 611 - 1K ORGANIC ZINC RICH PRIMER

DESCRIPTION:

Spectracron 611 1K Organic Zinc Rich Primer is uniquely formulated as a fast dry ready to use zinc rich maintenance coating. When properly applied and topcoated, this galvanic zinc rich primer will help achieve maximum corrosion protection on steel while minimizing red rusting. It continues to provide protection even after the film is damaged or stone chipped.

HIGHLIGHTS:

- ❖ Contains 87.6 +/- 2% zinc by weight in the dried film
- ❖ A truly unique 1K Organic primer – no adding or mixing in of zinc dust or 2nd component required
- ❖ No pot life concerns or issues – less waste
- ❖ No specific humidity requirements for cure
- ❖ Low film build requirements for proper protection – more sq. ft. coverage per gallon
- ❖ Fast Dry - Topcoat capable after 10 minutes ambient flash
- ❖ Excellent cathodic corrosion resistance – can be used as a touch up for galvanized substrate
- ❖ Chrome and lead free

TECHNICAL PROPERTIES*:

PROPERTY	METHOD	RESULT
Color		Gray
Gloss @ 60° Angle	ASTM D523	Flat
Adhesion	ASTM D3359	5B
Salt Spray Resistance 5,000 hrs*	ASTM B117	Excellent
Substrates		Blast preferred, CRS, HRS
In service temperature 400°F		With no loss of performance
Top Coat		SPECTRACRON 300, 360 For best corrosion protection and smoother finish, use SPECTRACRON 531 or 571 as a sealer/intermediate coat

*Results obtained over properly prepared iron phosphated CRS panel, sealed with 2K epoxy primer, and topcoated with Urethane under controlled testing conditions – ASTM B117

PHYSICAL PROPERTIES:

PROPERTY	BASE
Weight per gallon	16.5 ± 0.3 lbs./gal
Solid % (Weight)	70.3 ± 3%
Solid % (Volume)	30.0 ± 2%
Flash Point	68°F (19°C)
VOC	4.91 lbs/gal as packaged 4.60 lbs/gal less exempt solvents
Coverage	481 sq/ft per gallon (assuming 100% transfer efficiency @ 1.0 mil DFT)
Shelf Life	1 year
% Zinc by weight in Dried Film	87.6 +/- 2%

Do not attempt to use this product without the current Material Safety Data Sheet.
Revision Date: 9/2006



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SURFACE PREPARATION:

The surface must be clean and free of all contamination. Chemical pre-treatment before primer application will improve the overall performance properties of the finished coat.

APPLICATION DATA:

Mixing Instructions:	Mix well before using. Thin up to 20% with SPECTRATHIN TFS999-90 Slow Solvent as required. Do not use other thinners (i.e. Xylene or MEK) as these common thinners are not compatible
Wet Film Thickness:	2.4 – 4.5 mils WFT
Dry Film Thickness:	0.8 – 1.5 mils DFT
Thinner:	Use only SPECTRATHIN TFS999-90 Slow Solvent
Clean up:	SPECTRATHIN, TFS999-90
Pot Life:	N/A

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 *	NA	45	60	66 SD
Conventional	Graco Delta Air *	¼" Fluid	10	60	.042
Airless	Graco Alpha A.A.*	NA	1400-2000	N/A	.013-.015

*Or Equivalent

CURE SCHEDULE: Air Dry @77°F

Dry to touch:	10 minutes
Dry to topcoat:	10 minutes to 24 hours
Dry to handle:	20 – 30 minutes
To Recoat:	45 – 90 minutes – recoating should not be necessary
Force Dry:	Flash 10 minutes @ ambient: 10 minutes @ 300°F

ADDITIONAL INFORMATION:

- ❖ Apply in one wet pass. Do not build film – this product is designed for lower film builds than other zinc rich coatings. For blasted profiles, do not build to fill in the profile, apply one wet pass that changes the color of the metal from white blast to a gray primer appearance.
- ❖ A urethane topcoat can be applied directly to this zinc rich primer. For smoothest appearance, an epoxy seal or "tie" coat can be applied between the zinc rich and urethane topcoat.
- ❖ Ensure material being sprayed is agitated throughout the day. The heavy zinc particles will have a tendency to settle.
- ❖ Reduced material can be poured back into a sealed container and re-used at a later time to minimize waste.
- ❖ Apply at temperatures above 50°F

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It is recommended that the customer should trial the product for adhesion and compatibility using all substrates, surface preparation techniques and application processes in the environment the product will be intended to be used in prior to actual product application.

The technical data presented in this bulletin is based upon information believed by PPG to be currently accurate. However, no guarantees of accuracy, comprehensiveness or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in this bulletin.

