



## SPECTRACRON® 135 – 3.5 VOC ALKYD NON-LIFT PRIMER

### DESCRIPTION:

**SPECTRACRON® 135 – 3.5 VOC Alkyd Non-Lift Primer** is a fast drying, high solids, VOC-compliant primer recommended for industrial use on metal surfaces. Suitable applications include metal fabrication, castings, machinery and heavy equipment.

### HIGHLIGHTS:

- ❖ Fast drying 1-component
- ❖ Contains no heavy metals
- ❖ Can be applied over blasted surfaces
- ❖ Airless and air-assisted airless application capable
- ❖ Excellent salt spray performance
- ❖ No recoat or topcoat window

### TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Color		Custom (Q135-xxxx) White (QAP135-WHT) Tintable Base (QAP135-CLR)
Gloss Range @ 60° Angle @ 1.5 mils DFT (Custom Colors)	ASTM D523	Air Dry: 15 – 30; Force Cured: 40 – 60***
Gloss Range @ 60° Angle – QAP135-WHT	ASTM D523	<10 Units
Pencil Hardness	ASTM D3363	B - HB
Conical Mandrel (1/8")	ASTM D522	Pass
Impact (Direct / Reverse)	ASTM 2794	40 / 25
Adhesion	ASTM 3359	5B, Excellent
Humidity Resistance – 500 Hrs.	ASTM D2247	Excellent (no blisters)
Salt Spray Resistance – 300 Hrs.	ASTM B117	Excellent (no blisters, 1–2mm from scribe)
Chemical Resistance		Good
Substrates		CRS, HRS & Aluminum**
Recommended Topcoat(s)		See Compatibility Chart

\*These results were obtained over iron phosphated CRS panels.

\*\*Aluminum should have a fluoride containing conversion coating.

\*\*\* Air Dry and Force Cured gloss will increase as film build increases. Force Cure is per schedule listed below.

### PHYSICAL PROPERTIES:

PROPERTY	VALUE
Weight per gallon	11.3 ± 1.0 lbs./gal. (1356 g/L)
Weight Solids (%)	70.0 ± 4.0
Volume Solids (%)	53.4 ± 3.0
VOC (less exempts)	≤3.5 lbs./gal. (420 g/L)
VOE (actual)	≤3.5 lbs./gal. (420 g/L)
HAPs	none
Coverage (@ 1 mil, no loss)	808 - 905 ft <sup>2</sup> /gal. (75 – 84 m <sup>2</sup> /3.785L)
Flash Point	68°F (20°C)
Shelf Life - unopened container	2 years, unopened

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## SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. Chemfos® KA contains fluoride and is suitable for aluminum substrates. See your PPG Representative for specific recommendations.

## APPLICATION DATA:

Mixing Instructions: Mix thoroughly before and during use  
 Application Viscosity: 22" (Zahn #3 EZ cup)  
 Wet Film Thickness: 3.0 – 4.0 mils  
 Dry Film Thickness: 1.0 – 1.5 mils  
 Reducer: Not needed  
 Clean up: Q60 (MEK), Q80 (xylene), or Q30 (acetone)

SPRAY APPLICATION	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001	20 - 25	50	66SS (0.070", 1.8mm)	67PB
Conventional	DeVilbiss MBC-510	20 - 25	50	E (0.070", 1.8mm)	92
Air Assisted Airless	Graco G-15	900 - 1300	20 - 40	0.017 - 0.019"	249596
HVLP	DeVilbiss JGHV	20 - 25	50 - 55**	E (0.070", 1.8mm)	83MP
Airless	Graco G-40	1400 - 2000	n/a	0.017 - 0.019"	n/a

\*or equivalent

\*\*atomization pressure should read <10 psi @ the cap

## CURE SCHEDULES:

Air-dry (assumes 77°F (25°C) & 50% Relative Humidity)	Bake / Force Cure
To Touch: 30 – 40 min.	Flash Time: 10 min. (ambient)
To Handle: 2 hrs.	Substrate Temp: 160°F (71°C)
To Recoat: 15 – 30 min.	Bake Time: 20 min.
To Topcoat: 15 – 30 min.	

## ADDITIONAL INFORMATION:

- ❖ Do not apply at temperatures below 50°F (10°C)
- ❖ Excess film thickness will retard dry times and affect recoat window
- ❖ Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.
- ❖ In-Service Temperature: 200°F (93°C) (slight discoloration may occur after 150°F (66°C))
- ❖ Not recommended for use on galvanized, galvaneal or zinc rich surfaces

**CONTACT 1-866-PPG TRUE**  
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