



411 STRUCTURAL PRIMER

PRODUCT DESCRIPTION

Commercial Performance Coatings 411 Structural Primer is a fast dry, alkyd zinc phosphate primer, based on tough alkyd resins that impart good anti-corrosive properties on steel.

It is designed for use on steel substrates such as structural steel, mild steel, piping and equipment and tank exterior surfaces, to provide good corrosion protection in mild or moderate environments.

It is not recommended for direct application to galvanized steel or zinc dust primers.

PRODUCTS

411 STRUCTURAL PRIMER

Reducer

Normal Conditions

AER20 Alkyd Enamel Reducer Normal

Hot Conditions

AER30 Alkyd Enamel Reducer Slow

Cleaners

971-9119 PROTEC® Metal Conditioner

AA-6822 *Protec* Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Commercial Performance Coatings 411 Structural Primer can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE

PREPARATION

Structural Steel

AS1627.4 Class 2.5.

Mild Steel

Startline® Scourer

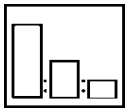


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



PRODUCT

411 STRUCTURAL PRIMER

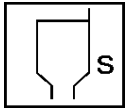
Reducer

PARTS

100

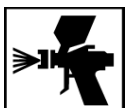
15-20% can be added

SPRAY VISCOSITY



15 - 20 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 1 - 2 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

DRYING TIMES



AIR DRY (25°C)

- TOUCH DRY: 10-15 minutes
- DRY TO HANDLE: 2-3 Hours
- HARD DRY: Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Topcoat with single pack enamels after 8 hours drying at normal ambient conditions, but for best results a 16 hour drying period is recommended.

TOTAL DRY FILM BUILD

40 - 50 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	37%
COVERAGE	12 metres squared per litre at 50µm (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	May be left uncoated for up to 6 months
ABRASION	Good
SOLVENT	Poor
CHEMICAL	Not recommended
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Not recommended

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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