



Industrial Painting  
 Paint Manufacturing  
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**PRODUCT DATA SHEET**

**PRODUCT DESCRIPTION:** Riley's High Solids Phenolic Sealer Primer is intended for use on properly prepared metal surfaces for finishing or refinishing. Suitable applications include agricultural, construction, and industrial equipment, castings, and metal fabrications.

<b>ADVANTAGES:</b> <b>WIDE BALANCE OF PERFORMANCE PROPERTIES:</b> <ul style="list-style-type: none"> <li>Fast Air Dry</li> <li>May Be Force Dried</li> <li>Fast Recoat Time</li> <li>Good One Coat Protection</li> <li>Good Humidity and Gasoline Resistant</li> <li>Very Good Salt Spray Performance</li> <li>Excellent Adhesion</li> <li>Excellent Recoatability</li> <li>Good Sandability</li> <li>Virtually any new or existing color standard can be matched</li> <li>Gloss can be matched to customer specifications</li> <li>Can be formulated for lower Hazardous Air Pollutants—HAP's</li> <li>Can be formulated to less than 3.5 lbs VOC</li> </ul>			<b>CHARACTERISTICS:</b> <b>GLOSS:</b> Flat <b>VOLUME SOLIDS:</b> Up to 55%, Varies by color <b>VISCOSITY:</b> 20-50 Seconds Zahn #3 <b>SPREADING RATE:</b> Up to 850 SQ. FT./GAL. At 1 Mil, No Application Loss <b>PACKAGE LIFE:</b> 2 Years <b>DRYING:</b> Air Dry @ 77°F (25°C) 45% RH To Touch: 15 MINUTES To Handle: 30 MINUTES To Recoat: AFTER 30 MINUTES To Pack: 24 HOURS <b>FORCE DRY:</b> Up to 200°F for 30 minutes for most colors. <b>RECOMMENDED FILM THICKNESS:</b> WET: 3.0-6.0 MILS DRY: 1.0-2.0 MILS <b>REDUCTION:</b> Xylene, Toluene, D-100, D-150, N-Butyl-Acetate <b>CLEAN UP:</b> Toluene or Xylene. WARNING. Residue from clean up is flammable.			<b>APPLICATION:</b> <b>APPLICATION PRECAUTIONS AND LIMITATIONS:</b> Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. Condensation will cause paint film failures. <b>SURFACE PREPARATION:</b> <b>METAL:</b> Apply to properly cleaned or treated metal surface. A solvent wipe to remove contaminants or sandblasting will work. Sand blasted metal may require more dry film thickness to fully cover blasted profile. Priming metal prior to topcoating is recommended for best overall properties. Preprimed surfaces may need to be lightly sanded and tacked off for best inner coat adhesion. Chemical treatment will improve the adhesion and performance properties of the paint. Treatment may consist of an iron phosphate chemical pretreatment. Riley manufactures several chemicals for surface preparation. <b>ALUMINUM AND GALVANIZED IRON (UNTREATED):</b> Prime with a vinyl wash primer then coat with an alkyd primer followed by a topcoat. <b>WOOD (INTERIOR):</b> May be used as a stain block under latex paints. For new wood priming is recommended. Riley has specialty wood coating products that may work better. <b>CONVENTIONAL SPRAY:</b> Reduce to the desired viscosity using a solvent that has the appropriate reduction strength and dry time. Add with agitation. Spray at 40-60 psi atomizing pressure and 15-20 psi fluid pressure. Viscosity 25-55 seconds #2 EZ. <b>AIRLESS SPRAY:</b> Reduce to the desired viscosity using a solvent that has the appropriate reduction strength and dry time. Use .013"-0.017" tips and 12"-16" fan for best application. Viscosity 20-30 seconds #3 EZ. WARNING. Over spray residues will spontaneously combust. <b>DIP:</b> Larger parts may require slower drying solvent to allow for better run off. Viscosity 35-55 seconds #2 EZ.		
<b>SOLVENT REDUCTION DATA:</b>								
<i>Solvent</i>	<i>Comparative Spot Dry</i>	<i>Reduction Strength</i>						
<b>Toluene</b>	<b>1 min. 5 sec.</b>	<b>Strong</b>						
<b>Xylene</b>	<b>2 min. 40 sec.</b>	<b>Strong</b>						
<b>D-100</b>	<b>6 min. 30 sec.</b>	<b>Average</b>						
<b>D-150</b>	<b>22 min.</b>	<b>Average</b>						
<b>N-Butyl-Acetate</b>	<b>2 min. 7 sec.</b>	<b>Strong</b>						
<b>Methyl Ethyl Ketone</b>	<b>35 sec.</b>	<b>Strong. Used to enhance electrostatic wrap.</b>	<b>PRODUCT LIMITATIONS:</b> <ol style="list-style-type: none"> <li>On sand blasted or rough surfaces, more dry film thickness may be necessary to fully cover profile</li> <li>Phenolic sealers offer a hard sandable film that can be brittle.</li> <li>Blocking or sticking may occur when flat surfaces are stacked before adequate cure. Allow at least 24 hours drying before stacking depending on dry film thickness.</li> <li>For best application of applying paint to a substrate the temperature of the paint should be between 65-90°F (18-32°C). If specified temperature is not met poor atomization can result.</li> <li>Stir thoroughly before and during use. Stirring is critical to maintaining consistent coating material parameters.</li> </ol>					

**KEEP OUT OF REACH OF CHILDREN**

**Consult MSDS for more information.**

\*\*DISCLAIMER\*\*

The information in this PDS and environmental data sheet was obtained from sources which we believe are reliable. However, the information is provided without any representation or warranty, expressed or implied, regarding its accuracy or completeness.

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