



TECHNICAL DATA SHEET #80

F-938 H.P. PRIMER

FOR INDUSTRIAL USE ONLY

DESCRIPTION:

F-938 H.P. PRIMER is a fast dry primer specifically developed to increase adhesion of PLASTI DIP® / F-820/ F-819 or F-698 to metal surfaces. F-938 H.P. PRIMER can be sprayed, dipped or brushed and offers fast set up time with a high coverage rate. Typically applied in one coat, only extreme corrosion and abrasion require a second coat, eliminating extensive preparation for most applications.

F-938 H.P. PRIMER is recommended on all metal surfaces, especially galvanized, to prevent peeling of PLASTI DIP® / F-820 if it becomes damaged, reducing the amount of time to repair the damaged area. For best results apply PLASTI DIP® / F-820 over F-938 H.P. PRIMER as soon as it is dry to the touch. F-938 H.P. PRIMER **is not** recommended for use as a protective coating on its own.

SPECIFICATIONS:

Solids: (wt.) 5%

Shelf life: 1+ years @ 77°F unopened container

Coverage: 50 sq.ft. per gallon at 1 mil

ALTERNATIVE PRODUCTS:

If F-938 H.P. PRIMER is not available, other high quality acrylic primers may be substituted. Always test substitutes before applying to actual application. **RUST-OLEUM® brand primers are not compatible.**

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**SURFACE PREPARATION:
MIX WELL BEFORE USE.**

All surfaces to be coated must be free of any oils, loose rust, dirt or dust. A sandblasted or rough surface allows for best adhesion of F-938 H.P. PRIMER to metal.

USE ADEQUATE VENTILATION.

SPRAYING: Pressure pot/conventional spray equipment may be used. Dilute with recommended thinners as needed. Gently mix before spraying. Apply wet overlapping coats, holding gun 6"-12" from surface, using a 4"-6" pattern. Allow 10-20 minutes dry time before applying additional coats to desired thickness or before applying PLASTI DIP®/ F-820.

RECOMMENDED EQUIPMENT AND SETTINGS:

Binks® model 62 gun

Nozzle: 63B

Cap: 63PB

Needle: 363-A

Material: 15-20psi

Atomization: 15-25psi

Dilution: not recommended

Clean up: Toluene

Industrial/commercial airless equipment may be used. Use as described above.

Tip sizes: .09 - .011

Pressure: as needed

Dilution: not recommended

DIPPING: Gently mix before each use. Do not introduce air bubbles. Insert item 1" every 5 seconds. Remove at same rate. Allow 30-40 minutes (dry to the touch) dry time before applying PLASTI DIP®/ F-820.

BRUSHING: Gently mix before each use. Apply wet overlapping coats using a soft natural bristle brush. Allow 10-20 minutes (dry to the touch) dry time before applying additional coats to desired thickness or before applying PLASTI DIP®.

HINTS:

Recommended thinners: Toluene. A dry film thickness of 1 mil is recommended for best results. Avoid excessive air movement, heat or humidity. If these conditions exist, use 10-20% Xylene to retard evaporation. Always use proper ventilation and protection. Always apply PLASTI DIP®/ F-820 over F-938 H.P. PRIMER as soon as it is dry to the touch.