



**3.5 VOC Shop Primers**

**ASP Series Primer 3.5 VOC**

**CPC 172**

ASP-435 3.5 VOC Shop Primer (Gray)  
 ASP-735 3.5 VOC Shop Primer (Red Oxide)

RECOMMENDED USE		SURFACE PREPARATION	
<p><b>Type:</b> Alkyd</p> <p><b>Recommended Use</b>            ASP-435 and ASP-735 are single component, 3.5 VOC alkyd shopcoat primers. They are intended for use as a temporary protective primer for fabricated metal products. These primers meet 3.5 lb. per gallon VOC limits in regulated areas.</p> <p>ASP-435 and ASP-735 exhibit limited performance properties when topcoated with alkyd or acrylic /alkyd enamels. PPG's HBA, CRE or EEP series primers are recommended where 3.5 lbs/gal VOC, long-term durability or service in severe environments is required.</p>		<p>Surface to be primed must be properly prepared, dry, clean and free of all contamination. SSPC-SPC2 Hand Tool or SSPC-SPC3 Power Tool Clean is Minimum. For best performance, SSPC-SP6 (NACE#3), Commercial Blast Cleaning is recommended.</p>	
		Metal	Direct To Properly Treated Substrate
		Cold Rolled Steel	Excellent
		Hot Rolled Steel	Excellent
		Galvanized	N/A
		Galvanized	N/A
		Aluminum	N/A
		Plastic/Fiberglass	N/A
PHYSICAL CONSTANTS			
<b>Voc</b>	3.5 lbs/gal		
<b>Percent Solids By Weight</b>			
ASP-435	70.6 +/- 2.0%		
ASP-475			
<b>Percent Solids By Volume</b>	46.1 +/- 2.0%		
(Varies By Color)			
<b>Weight Per U.S. Gallon</b>	11.8 +/- 5 lbs/gal		
(Varies By Color)			
<b>Flash Points</b>			
(Pensky-Martens)			
ASP-435	73°F (22°C)		
ASP-475	73°F (22°C)		
<b>Ready To Spray Viscosity</b>	#3 Zahn = 20 secs.		
(Varies By Color)	#2 Zahn = N/A		
PERFORMANCE FEATURES			
<b>Pencil Hardness</b>	(Varies By Color) N/A		
<b>Flexibility</b>	(Conical Mandrel) N/A		
<b>Fade Resistance</b>	N/A		
<b>96 Hour Humidity Resistance</b>	N/A		
<b>Sheen</b>	Flat		
<b>Adhesion</b>	Excellent		
<b>In Service Temperature Limitations</b>	N/A		

APPLICATION DATA	SAFETY							
<p><b>Mixing Directions</b> Stir thoroughly before and occasionally during use.</p>	<p>These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public. Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.</p>							
<p><b>Thinning</b> Do not thin.</p>								
<p><b>Pot life</b> N/A</p>								
<p><b>Application Methods</b> Apply with a high quality brush, roller, or by spray.</p> <p><b>Air Spray:</b> Conventional- DeVilbiss MBC-510 or JGA gun, 704 or 777 air cap with "E" tip and needle or equivalent equipment. Atomizing pressure 30-60- psi.</p> <p><b>HVLP:</b> DeVilbiss GTI or Plus gravity gun. 1.3 or larger fluid tip. Atomizing pressure 10 psi at the air cap.</p> <p><b>Airless Spray:</b> Equipment capable of maintaining a minimum of 1700 psi at the tip without surge. 0.011' (0.279mm) to 0.019" (0.48mm) orifice.</p> <p><b>Brush:</b> High quality, natural bristle brush.</p> <p><b>Roller:</b> 3/8 to 3/4 inch nap roller cover.</p>								
<p><b>Drying Times*</b> (3.3 – 3.9 mils wet @ 77°F(25°C) and 50% relative humidity)</p> <table border="1" data-bbox="240 905 526 1020"> <tr> <td>To Touch:</td> <td>20 minutes</td> </tr> <tr> <td>To Handle:</td> <td>1 hour</td> </tr> <tr> <td>To Dry:</td> <td>1 hour</td> </tr> <tr> <td>Recoat:</td> <td>1 hour</td> </tr> </table> <p><i>Recommended Wet Film Build:</i> 3.3 – 3.9 mils <i>Recommended Dry Film Build:</i> 1.5 – 1.8 mils</p>		To Touch:	20 minutes	To Handle:	1 hour	To Dry:	1 hour	Recoat:
To Touch:	20 minutes							
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<p>Film in excess or below these recommended film builds may cause problems such as, adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure.</p>	<p><b>PRECAUTIONARY INFORMATION</b> Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.</p> <p><b>KEEP OUT OF THE REACH OF CHILDREN</b></p>							
<p><b>Recommended Spreading Rate</b> 739 sq. ft. @ 1.0 mil dry film per U.S. gallon (varies by color). Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.</p>		<p><b>MEDICAL RESPONSE</b> Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available.</p>						
<p><b>Clean Up</b> Mineral Spirits</p>		<p><b>MATERIAL SAFETY DATA SHEET</b> Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.</p>						
<p><b>Application Precautions and Limitations</b> Apply only when air, product or surface temperature is above 50°F (10°C). Dry times may vary depending on temperature.</p>	<p>To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.</p>							

