



Series 412 Fast Dry Factory Finish Alkyd Primer

PRODUCT DESCRIPTION:

A field proven system based on a non-modified alkyd resin fortified with a balance of high-hiding pigments and solvents with a flash point below that of mineral spirits. For operations that prime raw lumber. Series 412 is a perfect choice for a wide variety of wood species wherein penetration, hiding and stain blocking is a requirement. High resin solids add additional performance and provides an excellent alternative to other oil based primers that are lower in overall solids. An excellent choice for operations that prime lumber via convection oven, spray or flood coating. Specifically formulated to minimize extractive bleeding and to be non-blocking. Series 412 is lead free and contains no carcinogens.

RECOMMENDED USES:

For machine coat operations, with oven drying equipment, flood coaters or spray equipment. Typically used on Pine, Fir, Spruce, Cedar, Redwood, and other architectural wood species

PERFORMANCE INFORMATION:

Matte finish to minimize imperfection in a variety of lumber products. 8-15 minutes dry time, to stack with convection heat (based on temperature and air circulation). 4-6 hours, to stack, when racked at ambient temperatures of 60-70 deg. F, 50% RH. Best performance with rack drying enhanced with air circulation provided by industrial fans. Infrared heating not recommended. Non-blocking. High hiding. Wide variety of chemical resistance. Can withstand 5 years of exposure before top coating is needed. Filtered for problem free spray or flood coat application. Low odor. Non-flammable. Non-toxic.

CHARACTERISTICS:

Vehicle: Alkyd

Finish: Matte

Spread Rate: Smooth surfaces: 250 sq. ft. per gallon @4 wet: 2.29 dry.

Drying Time: Convection Oven: 8-15 minutes based on temperature and air circulation

Spray and Flood Coating: 4-6 hours @60-70 deg. F, 50% RH, with air circulation

Weight: 13.87 lbs. per gal.

Percent Solids/Volume: 57.05% + or - 2%

Percent Solids/Weight: 79.10% + or - 2%

Recommended Film Thickness: 4 mils wet, 2.29 mils dry

Packaging: 275-gallon totes, 55-gallon drums, 5-gallon pails

Flammability: Non-Flammable

VOC's: 2.88 lbs. per gal



coatings and chemicals

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SPECIFICATIONS:

Surface Preparation:

Free surface of industrial soil, oily wastes and dirt. Spot prime knots with shellac based primer.

Application and Reduction:

This product is particularly suitable for airless spray and machine coat apparatus. Protect surrounding surfaces from over spray. Protect from freezing. Be sure to keep open pail covered as to not allow thickening of material. If material thickens, add up to 32 ounces Rule 66 mineral spirits (CAS# 64742-47-8) per five gallons and mix well. Apply at temperatures above 50 degrees. Cold temperatures will cause thickening of material. Should this occur a drum heater should be used 2-3 hours prior to allow for proper viscosity. Tough to seal woods from water soluble extractives may require 2 coats.

Clean-up Information:

Tools and over spray may be cleaned up mineral spirits.

Limitations:

Due to application technique, environmental conditions, construction flaws, etc. rust, cedar or redwood bleed cannot be guaranteed. Not intended for use on any surface subject to foot traffic.