



"Innovative Coatings for Your Environment"®

PRODUCT DATA

24-B601 WB GRAPHITE BLACK ZERO VOC DTM

Description:	An inhibitive acrylic water based lead and chrome free metal primer. This product is specifically designed for protection of ferrous, aluminum and galvanized metal surfaces.
Uses:	Use as a DTM for corrosion protection of various substrates, such as railcars, tanks and jackets.
Vehicle Type:	Waterborne
Color:	Black
Gloss:	Low
Viscosity:	65 – 75 KU
% Solids by Weight:	50.0 ± 2%
% Solids by Volume:	40 ± 2%
V.O.C.:	0.0 Lbs/Gal
Weight per Gallon:	10.05 ± 0.30 lbs./gal.
Recommended Film Thickness:	1 - 3 mil D.F.T., 4 – 7 mils wet
Theoretical Coverage:	Per Gallon @ 1 mil D.F.T. - 641 ft. ²
Drying Times @70°F/21°C:	To touch: 30 minutes To recoat: 60 minutes
Solvent:	Do not thin. If necessary, use fresh water.
Flash Point:	>200°F (Setaflash-closed cup)
Application:	Airless Spray, tip size 0.17-.0.21, pump pressure 2000-3000psi 16 mils wet film build

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Limitations:	Apply only in good weather. Do not apply unless air, surface, and material temperature is at least 50°F (10°C). Do not apply unless surface temperature is at least 5°F (3°C) above the Dew Point or when it is likely that moisture will contact surface of wet film. Do not use in immersion or high temperature service. DO NOT ALLOW TO FREEZE.
Surface Preparation:	Surface should be clean and dry. Remove as much mill scale, rust and surface contamination as possible. For direct-to-metal application a minimum SSPC-SP-10 "Commercial" sandblast is recommended. In order of effectiveness (least to best), the following procedures are acceptable: SSPC-SP-2 Hand Tool Cleaning, SSPC-SP-3 Power Tool Cleaning, SSPC-SP-7 Brush Off Blast Cleaning, SSPC-SP-6 Commercial Blast Cleaning, SSPC-SP-10 Near White Metal Sandblast.
Mixing:	Stir thoroughly prior to use.
Thinning:	Not required
Welding:	When welding or flame cutting through this material, do so in accordance with American National Standards Institute (ANSI) instructions in specification Z49.1 SAFETY IN WELDING AND CUTTING. All damaged areas should be reprepared and coated as specified.
Shelf Life:	Six months from the date of manufacture.
Safety:	This product and recommended thinners contain solvents and/or chemical ingredients. Please observe proper health and safety procedures during handling, storage, application and drying times. For optimum safety, user is directed to consult the current Material Safety Data Sheet for this product and other products being used coincidentally. When using in a confined area, consult the current OSHA or ANSI bulletins on safety requirements.
Notes:	Some discoloration or flash rusting is possible under highly humid conditions. However, a two coat system at 4 - 5 mils (102 -127 microns) will eliminate this. Use of forced drying at 120°F (49°C) is especially recommended when relative humidity is above 70% and when temperature is below 60°F (16°C).

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