

# X-TENDA COAT™

## Metal Primer

### Overview

X-Tenda Coat Metal Primer is a single-component acrylic primer that is stain resistant, permanently flexible, and very durable. It has excellent resistance over metal substrates and works very well over concrete, masonry, and wood substrates as well. X-Tenda Coat Metal Primer can be over-coated with X-Tenda Coat Acrylic Coatings or X-Tenda Coat XTRA Silicone Coatings. It dries/cures quickly and has weather resistant characteristics and extended open time for easy, high-quality applications. It is designed to provide resistance to corrosion and excellent adhesion to steel, aluminum, and galvanized metal substrates.

### Features and Benefits

- » Easily applied with airless spray equipment, roller, or brush
- » Water-based product meets most local, state, and federal VOC and environmental requirements
- » Equipment easily cleaned up with water
- » White color promotes quick drying and curing
- » Excellent adhesion over a wide variety of substrates
- » Does not become brittle with age
- » Effective in blocking bleed-through from residual rust

### Coverage Rate

X-Tenda Coat Metal Primer is typically applied at 0.3 to 0.5 gal/100 ft<sup>2</sup> (1.4 to 2 L/10m<sup>2</sup>). The application rate may vary depending on a variety of factors, such as roughness or porosity of the substrate. This primer should not be applied at rates over 1 gal/100 ft<sup>2</sup> (4 L/10m<sup>2</sup>).

### Installation

1. All surfaces to be primed must be clean, dry, sound, and free of unsound rust scale or other contaminants that could interfere with optimum adhesion. Some rust scale may need to be mechanically abraded and removed prior to application of the primer.
2. No thinning or reducing is necessary. Mix material in the container such that it is homogeneous and consistent before use.
3. X-Tenda Coat Metal Primer may be sprayed or applied with a brush or roller. Airless spray pump should be capable of a minimum 1,000 psi fluid pressure and 0.5 gallon (1.9 L) per minute output. Use a 0.17" to 0.25" orifice spray tip, depending on length of hose and spray pattern required. A minimum fan angle of 40° is recommended.
4. Ensure X-Tenda Coat Metal Primer is thoroughly dried/cured prior to application of coatings. Primer should be coated within 48 hours of application.
5. Clean up with water.

*Review Carlisle specifications and details for complete application information.*

### Precautions

- » X-Tenda Coat Metal Primer is water-based and may freeze and become unusable at temperatures below 32°F (0°C).
- » Do not apply X-Tenda Coat Metal Primer at temperatures below 50°F (10°C) or when there is a possibility of temperatures falling below 32°F (0°C) within 2 hours of application.
- » Do not apply over wet substrates or when inclement weather is imminent.
- » Shelf life is 18 months from date of manufacture in unopened containers, if stored in a dry area at 50°F to 90°F (10°C to 32°C). Storage outside this temperature range can shorten shelf life. Do not allow material to freeze.
- » See Safety Data Sheet (SDS) for complete safety information.

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### Typical Properties and Characteristics

Property	Test Method	X-Tenda Coat Metal Primer
Solids by Weight	ASTM D2369	45%
Solids by Volume	ASTM D2697	37%
Density	ASTM D1475	9.8 lbs./gal
VOC	Calculated	<100 g/L
Dry Time to Touch	ASTM D1640	20–40 minutes @ 75°F (25°C)
Full Cure Time		1–24 hours @ 75°F (25°C)
Application Temperature		50°F (10°C)–110°F (43°C)
Color		White

X-Tenda Coat Metal Primer can be coated as soon as it is thoroughly dried. Allow 24 hours when coating with a solvent-based material. It should normally be overcoated within 48 hours of application.

Typical properties and characteristics are based on samples tested and are not guaranteed for all samples of this product. This data and information is intended as a guide and does not reflect the specification range for any particular property of this product.

### Shipping Information

Container Size	Gross Weight	Class
5-gallon pail (18.9 L)	53 lbs. (24 Kg)	55
55-gallon drum (208 L)	580 lbs. (263 Kg)	55

D.O.T. Classification: Roof Coating, Non-Regulated  
Protect from freezing (32°F/0°C) during shipping and storage