

**PRODUCT MANUFACTURER:**

LINE-X LLC  
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**DESCRIPTION:**

LINE-X FCP is a high solids, two-component, urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanized substrates. It is specifically formulated to provide excellent anti-corrosive properties and accept fast-set and standard-set high build polyurethane topcoats.

Use LINE-X FCP as a primer for properly prepared steel, ductile iron and galvanized metals prior to the application of LINE-X spray-on products. Use as an intercoat primer to bond various topcoats to fastset, standard-set and/or aged polyurethane and polyurea elastomers.

**APPLICATION GUIDELINES:**

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

**Steel and Ductile Iron:**

Non-Immersion: Abrasive blast to a commercial blast in accordance with SSPC-SP 6 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.

Immersion: Abrasive blast to a near white blast in accordance with SSPC-SP 10 and obtain a 1.5-3 mil (38-70 μ) angular anchor pattern.

Galvanized (New): Scrub vigorously with a 1:1 mix of MEK/Toluene to remove the residual lubricant inherent to the galvanizing process.

Galvanized (Aged): Remove visible rust by sweep blasting or mechanical cleaning.

Other: Contact a LINE-X representative for specific recommendations.

	Normal	Minimum	Maximum
<b>Material</b>	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
<b>Surface</b>	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
<b>Ambient</b>	75-90°F (24-32°F)	45°F (7°C)	110°F (43°C)
<b>Humidity</b>	30-50%	0%	85%

**APPLICATION CONDITIONS**

Surface temperature must be 5°F (3°C) above the dew point.

**Mixing**

Shake Part A for 10 seconds and power mix Part B component of LINE-X FCP, then combine at a ratio of 1 “A” to 4 “B” by volume and power mix to a smooth consistency.

**Thinning**

Thinning not recommended. Contact LINE-X Technical Team as needed.

**Pot Life**

Material Temperature	Time
60°F (15°C)	1 ½-2 hours
75°F (24°C)	1 ½ hours
90°F (32°C)	45 minutes

**Drying/Cure Time**

These times are based on a 30-50% R.H. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

**Surface Temperatures**

	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
Surface Dry	2-4 hours	1-2 hours	0.5-1 hours
Hard Film	12-24 hours	6-10 hours	4-6 hours
Recoat (min)	3-5 hours	2-3 hours	2 hours
Recoat (max)	10 hours	10 hours	10 hours
Full Cure	5 days	4 days	3 days

If LINE-X FCP has exceeded its maximum recoat time or full cure time contact your LINE-X representative for recommended recoating procedures.



**TYPICAL PROPERTIES:**

Solids by Volume	50% ± 2
Volatile Organic Compounds	2.1 lb/gal (250 g/l)
Theoretical Coverage (DFT)	800 ft <sup>2</sup> /gal @ 1 mil (1.90 m <sup>2</sup> @ 1 mm)
Recommend WFT (Do not exceed 5 mils per coat)	2 – 3 mils (50-75 μ)
Number of Coats	1
Mix Ratio (by volume)	1”A” : 4”B”
Shelf Life @ 60-90°F (16-32°C)	Part A-6 mos. Part B-12 mos.
Color	Yellow
Adhesion to sandblasted steel	1053.00 psi
Salt Spray Test	ASTM B117
3,000 hrs. Rating 10 when used as prime coat for polyurethane and polyurea coatings.	

**CLEAN UP & SAFETY**

Use Xylene or MEK to wash brushes, rollers, spray guns & pumps and other painting tools.

Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information. Do not apply LINE-X FCP in enclosed areas without adequate air exchange and ventilation. All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods. Wear protective clothing, gloves and eye protection. Breathing fumes or contact with the skin may cause severe allergic reactions. This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces. This product is intended for industrial use by properly trained professional applicators only.

**MATERIAL STORAGE:**

LINE-X FCP needs to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C). Materials must be kept above 50°F (10°C).

**PRODUCT USER RESPONSIBILITIES:**

Users of LINE-X FCP product are responsible for reading the general guidelines, product data sheets, specifications and material safety data sheets (MSDS) before using this material. Printed technical data and instructions are subject to

change without notice. For additional information or for current technical data instructions, contact a LINE-X representative or visit [www.LINE-X.com](http://www.LINE-X.com).

**PRODUCT DISCLAIMER:**

All guidelines, recommendations, statements, and technical data contained herein are based on information and tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. It is the user’s responsibility to satisfy himself, by his own information and test to determine suitability of the product for his own intended use, application and job situation. User assumes all risk and liability resulting from his use of the product. We do not suggest or guarantee that any hazards listed herein are the only ones which may exist. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements, whether in writing or oral, other than those contained herein shall not be binding upon the manufacturer, unless in writing and signed by a corporate officer of the manufacturer. Technical and application information is provided for the purpose of establishing a general profile of the material and proper application procedures. Test performance results were obtained in a controlled environment and LINE-X makes no claim that these tests or any other tests accurately represent all environments.

