

PCA P15

Painting of Shop Primed Substrates

1. Scope

- 1.1 The purpose of this Standard is to establish procedures for the evaluation of shop primer applied by an entity other than the Painting Contractor.
- 1.2 This Standard identifies responsibilities of various entities involved when field coating of shop primed substrates is required.
- 1.3 This Standard defines criteria to determine if the shop primer is defective.
- 1.4 This document applies to shop primed materials including wood, hardboard, medium density fiberboard, metal, synthetics, cementitious materials, and other compositional substrates.

2. Significance and Use

- 2.1 The shop primer applied to various substrates should be in a condition ready to receive the finish coats specified.
- 2.2 This Standard applies when shop primer applied to various substrates is unsuitable for finish painting.
- 2.3 This Standard applies when remedial measures, such as sanding, stripping, and re-priming are required to be performed prior to the application of specified finish coats.

3. Definitions and Trade Terms

- 3.1 Definitions and Trade Terms see P9.

4. Reference Documents and Standards

- 4.1 Reference Documents and Standards see P9.

5. Standard Specification

- 5.1 Unless specified otherwise, the shop primer shall have the following characteristics:
 - 5.1.1 The shop primer shall be of the generic type that is recommended for the substrate material to which it will be applied.

- 5.1.2** The shop primer used shall possess the properties appropriate for the substrate material including stain blocking, alkali resistance, corrosion resistance, and hold out.
- 5.1.3** The shop primer applied shall be directly compatible with the finish coats specified without the need for a barrier coat or intermediate coat.
- 5.1.4** The shop primer shall be applied at a dry film thickness that is recommended by the manufacturer of the shop primer.
- 5.1.5** The shop primer shall have good adhesion to the substrate material to which it was applied.
- 5.2** Unless specified otherwise, conditions for the application, shipment, and storage of shop primed materials:

 - 5.2.1** Prior to the application of the shop primer, the applicator of the shop primer shall conduct testing to ensure that the moisture content of the substrate material is within the range specified by the manufacturer of the shop primer.
 - 5.2.2** The shop primer must be free of defects such as foreign material, lumps, skins, runs, sags, holidays, misses, insufficient coverage, drips, spatters, spills or overspray so that a properly painted surface as defined by PCA Standard P1 may be obtained when finish coats are applied.
 - 5.2.3** All butt ends and edges of members receiving shop primer shall be fully primed.
 - 5.2.4** The shop primer shall be properly and fully cured prior to shipment from the shop.
 - 5.2.5** Shop primed items shall be properly packaged so that the primer is not damaged during shipment.
 - 5.2.6** Shop primed items shall be stored at both the shop and the jobsite in a manner that prevents degradation and erosion of the primer.
 - 5.2.7** If damage or defects occur to the shop primer as a result of installation, then such damage and defects shall be corrected by an entity other than the Painting Contractor, unless specified otherwise.
- 5.3** Any shop primer that is not in full compliance with the conditions listed in paragraphs 5.1 and 5.2 shall be considered defective.



6. Comments

- 6.1 This Standard establishes criteria for shop priming various substrates.
- 6.2 This Standard clarifies areas of responsibility. Improved communication reduces misunderstandings.
- 6.3 This Standard is a nationally recognized consensus document for the painting and coating industry's work practices.

7. Disclaimer of Liability

- 7.1 PCA does not warrant or assume any legal liability or responsibility for the accuracy, completeness, or usefulness of any of the information contained herein.