



# Technical Bulletin

JOHNSON MANUFACTURING COMPANY  
Princeton, Iowa 52768-0096

## JOHNSON'S DEOXALUMINITE™ Weld-Through Primer, P/N 155-00 Series



### DESCRIPTION:

The "Original" high-aluminum content, organic, weld-through, or weldable primer system which meets existing specifications required for many certified applications. "Deox" for short, is also used in general practice to inhibit rust, corrosion, dirt and the additional clean-up that would otherwise be necessary at jobsites, or back in your shop, whenever parts must be stored for an intermediate period before final assembly and welding.

### PHYSICAL DATA:

Coverage	270 Sq. Ft. per Gallon @ 1 mil DFT
Appearance	Aluminum Pigmented Liquid
Odor	Pungent Solvents
Flash Point	80° F, Open Cup
% Solids	16.8 - by Volume
Viscosity	9 -15 Seconds @ 80° F (Ford #4 Cup)
VOC Rating	5.89

### PREPARATION:

Surfaces must be clean, dry and absent of flakes, moisture, scale and oil. Wheelabrator shot blasted surfaces provide an ideal profile to maximize consistent uniformity and adhesion. Aluminum oxide applied through a pressure blasting system, is also adequate, although the surface profile is spiked, so be sure to factor-in when calculating coverage requirements. Air blast or vacuum surfaces to remove residual abrasive particles.

### APPLICATION:

Thinning is not recommended, but if necessary use xylene, which raises VOC. Stir well and apply uniformly with a minimum dry film thickness of (DFT) of 0.75 to 2.0 maximum. Spray wet film thickness (WFT) should be between 2.0 to 2.5 max. Apply between the min/max with ambient and surface temperatures of 40°F to 100°F. Do not apply if relative humidity is more than 90%, or if surface temperature of the parts is within 5°F of the dew point.

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TO ORDER CALL (716) 881-3030, email [pat.oconnor@johnsonmfg.com](mailto:pat.oconnor@johnsonmfg.com), SUPPORT (563) 289-5123

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**EQUIPMENT:**

Extensive testing has shown that the most consistent and economical method of application is with a HVLP (high volume, low pressure) spray system. However, successful application is also possible when brushing, dipping or using standard spray equipment such as Binks 18, or equivalent, with fluid tip 66 and air nozzle 66SD, or Binks equivalent with fluid tip 78 and air nozzle 78S.

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**DRYING TIME:**

At 70°F To touch - 15 to 30 minutes. Recoat by spray or brush - 30 minutes. Hard cured - 24 hours.

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**CLEAN UP:**

With xylene

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**SAFETY:**

Please refer to Johnson's Safety Data Sheet (SDS), which is fully compliant with the Global Harmonized System (GHS) for safe usage, handling, storage and/or disposal considerations for this important product for industry.