



RUST TOUGH® 250 ACRYLIC ALKYD ENAMEL

Rust Tough® 250 Acrylic Alkyd Enamel is a rust inhibitive, acrylic modified alkyd, that can be used direct to metal without a primer. It is designed for interior and exterior surfaces in mild to moderate industrial environments. It has a high gloss finish and is fast drying. It performs like a traditional alkyd, but contains less Volatile Organic Content (VOC) than Rust Tough®. Acceptable for use in federally inspected meat and poultry plants for incidental food contact.

- ✓ Long lasting, durable protection
- ✓ Primers and topcoats are corrosion resistant
- ✓ Less than 250 g/L VOC
- ✓ Excellent hide, color and gloss retention
- ✓ Superior chip, crack and peel resistance
- ✓ Protects against mild chemical spills, fumes, oil and grease stains

INDUSTRIAL USE ONLY! AS OF 01/01/16 COMPLIES WITH:

- OTC
- EC
- SCAQMD
- CARB
- LADCO

krylonindustrial.com
1-800-247-3266

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RECOMMENDED USES

For interior and/or exterior industrial and commercial application on steel, aluminum, and wood to protect against atmospheric corrosion. This product can be used on structural steel, storage tank, conveyors, ladders, bar joists, fencing, handrails, machinery, piping, metal doors, pipe racks, shelving, safety markings, marine above the boot topping

RECOMMENDED SYSTEMS

Use full body for best results. Thinning is not normally required. However, if conditions require thinning, reduce up to 1 pint per gallon with mineral spirits or Oxsol-100. For best results and maximum corrosion protection use two topcoats @ 3.5 mils wet (2 dry mil/coat).

Spreading Rate (sq ft./gal):	Min.	Max.
Topcoat	481	963
Primer	481	963

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and cleanup. For more information, call the National Lead Information Center at 1-800-424-LEAD (in US) or contact your local health authority.

Surface must be dry and in sound condition. Remove oil, dirt, dust, loose rust, peeling paint and other contaminants to provide good adhesion.

Previously Painted Surfaces: Remove dirt, dust and oil by detergent wash and thorough rinse. Allow to dry. Remove all loose rust and paint by hand or power tool. Dull glossy surfaces by sanding or "sweep" abrasive blasting. For surfaces pitted from rust, use Rust Tough Primer for best results. New or clean metal surfaces do not require primer.

Iron & Steel: For maximum durability of coating system, commercial blast clean in accordance with SSPC-SP6. Minimum surface preparation is Hand Tool Cleaning SSPC-SP2 or Power Tool Cleaning SSPC-SP3. Apply first coat the same day as cleaning.

1 coat Rust Tough 250 Acrylic Alkyd Primer
2 coats Rust Tough 250 Acrylic Alkyd Enamel

Aluminum: Remove all oil, grease, dirt, oxide and other contaminants by Solvent Cleaning SSPC-SP1. Rust Tough® 250 is self-priming.
1-2 coats Rust Tough 250 Acrylic Alkyd Enamel

Wood: Surface must be clean, dry and sound. Knots and pitch streaks must be scraped, sanded and spot primed with Rust Tough® 250 Acrylic Alkyd Primer prior to application of topcoats. Two full coats are recommended.

CLEAN-UP

Use Mineral Spirits. Please follow supplier's safety instructions.

TECHNICAL DATA

Curing Mechanism: Oxidation

Fore Dry Schedule: ≤ 120°F, 75 minutes

Flash Point: 100°F (PMCC)

Number of Components: 1

Shelf Life: 36 months

VOC: Less than 250 g/L or 2.08 lbs/gal

PHYSICAL TEST DATA

Substrate	Steel	
System Tested	1 ct. Rust Tough 250 Primer @2dft	
	2 cts. Rust Tough 250 Alkyd @2dft	
Abrasion Resistance	ASTM-D4060; 500 g load	
Result	Top Coat	70 mg loss
	Primer	107 mg loss
Direct Impact Resistance	ASTM-G14	
Result	Top Coat	>160
	Primer	60
Reverse Impact Resistance	ASTM-G14	
Result	Top Coat	50
	Primer	10
Flexibility	ASTM-D522	
Result	Top Coat	1/8"
	Primer	7/16"
Pencil Hardness	ASTM-D3363	
Result	Top Coat	H
	Primer	H
Salt Fog Resistance	ASTM-B17	
Result	Top Coat	500
	Primer	500
Gloss/Sheen		
Result	Top Coat	80+ units @ 60° angle
	Primer	<10 units @ 60° angle
Drying Schedule	(3.5 mils wet)	
	Temp @ 77°F	
To touch	Top Coat	1-2 hours
	Primer	<1 hour
To handle	Top Coat	4-8 hours
	Primer	Same as top coat
To recoat	Top Coat	12-24 hours
	Primer	Same as top coat
Tack free	Top Coat	2-4 hours
	Primer	1-3 hours
Volume Solids	Top Coat	60
(+/- 2%)	Primer	60
Weight/Gallon	Top Coat	10.2
(+/- .15 lb/gal %)	Primer	12.1

APPLICATION

Mix thoroughly by mechanical shaker or stirring. For best results, brush prime all weld, sharp edges and crevices prior to application of full prime coat

Application Conditions

Temperature: (air, surface, material) 40° - 120°F (at least 5°F above dew point)
Relative Humidity: 90% maximum

Application Methods

Brush/Roll: No thinning suggested

Conventional Spray:

Gun: DeVilbiss JGA 502*, Atomization Pressure: 50 psi
Fluid Pressure: 20-25 psi, Air Cap: 704 cap
Fluid Nozzle: E Tip, *(or equivalent equipment)

HVLP Spray:

Gun: DeVilbiss JGHV*, Atomization Pressure: 70 psi
Fluid Pressure: 25 psi, Air Cap: 46 MP cap
Fluid Nozzle: .070 Tip & Needle, Fluid and Air Hose: 5/16" or larger *(or equivalent equipment)

Airless Spray:

Pressure: 2500 psi, Tip: .015" - .019", Filter: 100 mesh
Reducer: Mineral Spirits or Oxol-100

Reduction:

Brush/Roll: No thinning suggested
Conventional: Up to 1 pint/gal as required
HVLP: Up to 1 pint/gal as required
Airless: Not normally required, up to 1/2 pint per gallon if required

CAUTIONS

FOR INDUSTRIAL USE ONLY. Thoroughly review product label and SDS for safety and cautions prior to using this product. Please direct any questions or comments to your local Krylon Industrial Representative.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-247-3266.



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