



RUST TOUGH® ACRYLIC ALKYD ENAMEL

Rust Tough® Acrylic Alkyd Enamel is a rust-inhibitive, patented acrylic modified alkyd, that can be used direct-to-metal without a primer. It is fast drying and has a high-gloss finish. Available in a wide variety of the most popular packaged colors, as well as custom colors to meet your painting needs. Acceptable for use in federally inspected meat and poultry plants for incidental food contact.

- ✓ Interior and exterior
- ✓ Specifically designed to provide a long-lasting, corrosion resistant finish
- ✓ Rust undercutting resistant
- ✓ Excellent color and gloss retention
- ✓ VOC Compliant in National/EPA regulated states only

INDUSTRIAL USE ONLY! AS OF 01/01/2017 COMPLIES WITH:

- | | |
|---------------------------------|--------------------------------|
| <input type="checkbox"/> OTC | <input type="checkbox"/> CARB |
| <input type="checkbox"/> EC | <input type="checkbox"/> LADCO |
| <input type="checkbox"/> SCAQMD | <input type="checkbox"/> UTAH |

*VOC compliant in National/EPA-regulated states

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1-800-247-3266

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RECOMMENDED USES

Use this product on structural steel, conveyors, storage tanks, ladders, bar joists, fencing, handrails, machinery, piping, metal doors, pipe racks, shelving safety markings, marine-above boot topping.

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® 250 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.

Aluminum: Remove all oil, grease, dirt, oxide and other contaminants by Solvent Cleaning SSPC-SP1. Rust Tough is self-priming.

Wood: Surface must be clean, dry and sound. Knots and pitch streaks must be scraped, sanded and spot primed with Rust Tough 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

Resistance to fumes, splash and spillage non-immersion ASTM D3912

Aliphatic hydrocarbon solvents	Light
Alkalis	Light
Aliphatic hydrocarbon solvents	Severe
Chlorinated solvents	Severe
Fresh water & salt water	Light
Glycol ethers, alcohols, formaldehyde	Moderate
Inorganic acids	Moderate
Oils (cutting, vegetable, lubricating)	Light
Organic acids	Moderate
Oxygenated solvents	Moderate

PHYSICAL TEST DATA

Physical Properties:	
Abrasion Resistance	54 grams (ASTM-G14)
Direct Impact Resistance	80 lbs (ASTM-G14)
Reverse Impact Resistance	10 lbs (ASTM-G14)
Dry Heat Resistance	300°F* (ASTM-D2485)
Exterior Durability	Excellent
Flexibility	1/8" bend (ASTM-D522)
Pencil Hardness	2 - 4 H (ASTM-D3363)
Salt Fog Resistance	500 hrs (ASTM-B117)
Corrosion/Weathering Resistance	6 cyc.
Wet Heat Resistance	100°F (non-immersion)
* Paint film yellows but remains protective and intact.	
Gloss Level:	
Primer	<5 units @ 60° angle
Flats	<5 units @ 60° angle
Semi-Gloss	>30 and 50 units @ 60° angle
Gloss	80+ units @ 60° angle
Curing Mechanism:	Oxidation
Drying Schedule:	Temperature and humidity @ 77°F (25° C) and 50% relative humidity @ 4 mils wet
To touch:	1 - 2 hours
To handle:	4 - 8 hours
To recoat:	12 - 24 hours
Tack free:	2 - 4 hours
Force Dry Schedule	@ (not more) ≤175°F, 10 - 20 minutes
Flash Point	100°F (Pensky-Martens Closed Cup)
Number of Components	1
Recommended Spreading Rate	Theoretical, no loss
Primers:	372 sq ft/gallon @ 4.5 wet mils, 2 dry mils
Topcoats:	361-369 sq ft/gallon @ 4.5 wet mils, 2 dry mils
Spreading Rate:	Theoretical, no loss
Primers:	743 sq ft/gallon @ 1 dry mil
Topcoats:	722-738 sq ft/gallon @ 1 dry mil
Shelf Life:	36 months unopened @ 77°F
VOC Content:	Less than 420 gms/ltr or 3.5 lbs/gal
Volume Solids:	
Primers:	46% ± 2%
Topcoats:	46% ± 2%

PHYSICAL TEST DATA (CONTINUED)

Weight/Gallon:	
Primers:	10.7 ± 0.1 lb/gal
Topcoats:	7.9-9.9 ± 0.1 lb/gal
Shipping Weight:	
Primers:	11.5 lbs/gal avg.
Topcoats:	9.5 lbs/gal avg.

APPLICATION

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

Recommended System

Use full body for best results. Thinning is not normally required. However, if conditions require thinning, reduce up to 1 pt. per gallon with Rust Tough Thinner. For best results and maximum corrosion protection, use two topcoats @ 4.5 mils wet (2 dry mil/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

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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