

RUST TOUGH® PRIMER ALKYD RUST PREVENTIVE

Product Data Sheet

KRYLON
INDUSTRIAL
COATINGS™

DESCRIPTION

Rust Tough® Alkyd Primer is a patented acrylic modified alkyd designed to protect steel and iron in mild to moderate environments. Suitable for application in both field and shop, Rust Tough Primer is rust inhibitive, and formulated to be lead, chromate and barium-free. Rust Tough Primer is acceptable for use in federally inspected meat and poultry plants for incidental food contact.

Advantages:

- Corrosion Resistant
- Resists Rust Undercutting
- Interior and Exterior Use
- Patented Resin Technology
- Excellent Adhesion

Recommended Uses:

- Tanks and Cylinders
- Ornamental Iron
- Steel Fabricated Parts
- Equipment
- Machinery
- Metal Buildings
- Select Marine Structures
- Piping
- Handrails
- Metal Doors
- Bar Joists

SURFACE PREPARATION

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

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. For optimal adhesion, sand or abrade surface.

GALVANIZED METAL

New galvanized metal should be allowed to weather for six months prior to priming. Remove all oil and grease by steam cleaning or solvent cleaning per SSPC-SPI.

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

Steel (DTM):

1 ct. Rust Tough Primer @ 2.0 - 3.0 mils dft.
1 or 2 cts. Rust Tough Acrylic Enamel @ 2.0 - 3.0 mils dft.

Aluminum:

1 ct. Rust Tough Primer @ 2.0 - 3.0 mils dft.
1 or 2 cts. Rust Tough Acrylic Enamel @ 2.0 - 3.0 mils dft.

Galvanized Metal:

1 ct. Rust Tough Primer @ 2.0 - 3.0 mils dft.
1 or 2 cts. Rust Tough Acrylic Enamel @ 2.0 - 3.0 mils dft.

APPLICATION CONDITIONS

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

APPLICATION METHODS

- Brush/Roll: Full Body
- 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: UM&P Naptha/Mineral Spirits
- Reduction:
Brush/Roll: Full Body
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.
Clean-up: Mineral Spirits. Please follow supplier's safety instructions.

APPLICATION cont.

(Resistance to fumes, splash and spillage not immersion ASTM D3912)

• Aliphatic hydrocarbon solvents	Light
• Alkalis	Light
• Aromatic 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 PROPERTIES

• Abrasion Resistance (ASTM-D4060)	54 grams
• Direct Impact Resistance (ASTM-G14)	80 lbs
• Reverse Impact Resistance (ASTM-G14)	10 lbs
• Dry Heat Resistance (ASTM-D2485)	300°F*
• Exterior Durability	Excellent
• Flexibility (ASTM-D522)	1/8" bend
• Pencil Hardness (ASTM-D3363)	2 - 4 H
• Salt Fog Resistance (ASTM-B117)	500 hrs
• Corrosion / Weathering Resistance	6 cyc.
• Wet Heat Resistance (non-immersion)	100°F

* Paint film yellows but remains protective and intact.

CHARACTERISTICS

- Colors: Red Oxide and Gray
- Gloss Level: <5 units @ 60° angle
- Drying Schedule - temperature and humidity @ 77°F (25° C) and 50% relative humidity @ 4 mils wet:
 - Touch 45 min. - 1.5 hours
 - Handle 3 - 6 hours
 - Recoat 12 - 24 hours
- Force Dry Schedule @ (not more) ≤175°F: 10 - 20 minutes
- Flash Point: 100°F (Pensky-Martens Closed Cup)
- Number of Components: 1
- Packaging: 1 gallon and 5 gallon pails
55 gallon drums available upon request
- Recommended Spreading Rate:
Theoretical, no loss 370 sq ft/gallon @ 4.5 wet mils,
2.0 dry mils
- Shelf Life: 18 months unopened @ 77°F

CHARACTERISTICS cont.

- Volatile Organic Content (VOC):
Less than 420 gms/ltr or 3.5 lbs/gal
- Volume Solids: 46% ± 2%
- Weight/Gallon: 10.7 ± 0.1 lb/gal.
- Shipping Weight: 11.5 lbs/gal avg.

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

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 1-800-777-2966.