RUST TOUGH® ENAMEL
ALKYD RUST PREVENTIVE
Product Data Sheet

DESCRIPTION

Rust Tough® 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. Rust Tough is lead, chromate and barium-free. 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.

RECOMMENDED USES

For industrial and commercial applications on steel, aluminum, galvanized metal, and wood to protect against atmospheric corrosion.

- Interior and exterior
- Premium, high solids shopcoat primer
- Fast drying maintenance primer
- Specifically designed to provide a long-lasting, corrosion resistant finish

Applications:
- Structural Steel
- Conveyors
- Storage Tanks
- Ladders
- Bar Joists
- Fencing
- Handrails
- Machinery
- Piping
- Metal Doors
- Pipe Racks
- Shelving
- Safety Markings
- Marine-Above Boot Topping

PERFORMANCE INFORMATION

- Primers and topcoats are corrosion resistant
- Less than 420 grams/liter Volatile Organic Content (VOC)
- Corrosion and rust undercutting resistant
- Excellent color and gloss retention
- Low odor

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.

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. Dust 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.

SURFACE PREPARATION cont.

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.

Galvanized Metal

Use only with Krylon Industrial Coatings - Galvanized Metal Primer, (K00024000).

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.

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: Rust Tough Thinner/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.
CLEAN-UP: Mineral Spirits. Please follow supplier’s safety instructions.

CHARACTERISTICS
(Resistance to fumes, splash and spillage non-immersion ASTM D3912)
• Aliphatic hydrocarbon solvents Light
• Alkalis Light
• Aromatic hydrocarbon solvents Severe
• Chlorinated solvents Severe
• Fresh water & salt water Light
• Glycol ethers, alcohols, formaldhyde Moderate
• Inorganic acids Moderate
• Oils (cutting, vegetable, lubricating) Light
• Organic acids Moderate
• Oxygenated solvents Moderate

PHYSICAL PROPERTIES
• Abrasion Resistance 54 grams (ASTM-D4060)
• 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 (non-immersion) 100°F
• Paint film yellows but remains protective and intact.

COLORS:
Primer: Red Oxide and Gray
Flat: Black and White
Semi-Gloss: Black and White
Gloss: Black, White, OSHA, 3 Tint Bases, implement, and popular factory packaged colors

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

PACKAGING:
Aerosols: 20 oz. Can
Bulk: 1 gallon and 5 gallon pails
53 gallon drums available upon request

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: 18 months unopened @ 77°F

VOLUME ORGANIC CONTENT (VOC):
Less than 420 gms/ltr or 3.5 lbs/gal

VOLUME SOLIDS:
Primers: 46% ± 2%
Topcoats: 46% ± 2%

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.

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.