

PRODUCT DATA

FAST DRYING SHOP PRIMERS 6400

DESCRIPTION

RUST-OLEUM® Fast Drying Shop Primers 6400 are fast drying primers based on a soya oil alkyd. The products contain rust-inhibitive pigments and are lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM Shop Primers 6400 should be applied on cold-rolled, blasted, pickled or slightly rusted steel.
RUST-OLEUM Shop Primers 6400 are primarily intended for spray application and may also be applied by brush or roller for touch up or small areas only.
RUST-OLEUM Shop Primers 6400 can be recoated with the RUST-OLEUM Alkyd Primer/Intermediate and the Alkythane 7500System Topcoat assuring the appropriate protection at light industrial exposures.

TECHNICAL DATA

Appearance:	Flat
Colour:	6469 Red Brown, 6478 Black and 6487 Grey
Density:	1.25 ± 0.5 kg/ltr.
Solids Content:	In volume: 42.26% (6478), 43.3% (6469), 44.4% (6487)
Viscosity:	74 - 78 KU /Krebs Stormer Units at 20°C
Recommended film thickness:	Wet film: 85 µm wet Dry film: 35 µm
VOC-content:	463 g/l max.
Ready-to-use mixture:	499 g/l max.
Category:	A/i
EU Limit values:	600 g/l (2007) / 500 g/l (2010)

Drying times	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	1 hour	2 hours	½ hour
To handle:	2 hours	4 hours	1 hour
To recoat:	After 24 hours	After 36 hours	After 24 hours
Full hardness:	7 days	14 days	5 days

Heat resistance: 120°C (dry heat)

Coverage

Theoretical: 12 m²/l at 35 µm dry
Practical: Practical coverage depends on many factors such as porosity and roughness of the substrate and material losses during application.

SURFACE PREPARATION

Remove grease, oil and all other surface contaminations by alkaline or high pressure (steam) cleaning in combination with appropriate detergents. For optimum results remove rust, rust scale, mill scale by abrasive blasting to Sa 2½ (ISO 8501-1: 1988), blast profile max. 50 µm, or by pickling. Remove loose and deteriorated coatings by scraping and wire brushing or sweep blasting. The surface must be clean and dry during application.

DIRECTION FOR USE

To ensure homogeneity, coating materials should be thoroughly stirred prior to use.

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APPLICATION & THINNING

- Brush: Use natural bristles, long hair brushes.
- Roller: Use medium nap, perlon 8-12 mm. Rollers.
Roller application may require 2 coats to achieve recommended dry film thickness.
- Air-atomised spray: Up to 10 vol.%; RUST-OLEUM Thinner 150.
Gravity cup and pressure cup.
Tip size: 1.2 -1.8 mm / Atomizing pressure: 2 - 4 bar.
- Airless spray: If required up to 5 vol. % RUST-OLEUM Thinner 150.
Pneumatic and electric airless equipment.
Tip size: 0.013-0.015 inch / Fluid pressure: 130 - 200 bar.
- Cleanup: Use RUST-OLEUM Thinner 160 or aromatic hydrocarbons.

APPLICATION CONDITIONS

Temperature of air, substrate and coating material between 5 and 35°C and relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

REMARKS

Maximum dry film thickness per coat: 60 µm dry, equals 160 µm wet.

SAFETY

Consult Safety Data Sheet and Safety Information printed on the can.

SHELLIFE / STORAGE CONDITIONS

5 years from date of production in unopened cans, if stored in dry, well ventilated areas, not in direct sunlight at temperatures between 5° and 35°C.

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