

PRODUCT DATA

6400WB WATERBASED SHOPPRIMER

DESCRIPTION

RUST-OLEUM® 6400WB is a water dilutable acrylic primer with anti corrosive pigments.

MAIN PROPERTIES

Product can be used on a wide variety of substrates like bare or blasted steel, galvanized (zinc), aluminium, non ferro metals etc; in- and outside. It is intended as the first coat in shop coating applications and provides the required basic protection following metal fabrication and assembly operations. Lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM® 6400WB can be used on a wide variety of substrates like bare or blasted steel, galvanised steel, zinc, aluminium and steel protected by plastisol.

RUST-OLEUM® 6400WB is primarily intended for brush application and can also be applied by roller and spray.

TECHNICAL DATA

Appearance:	Matt
Colour:	Grey (RAL 7040) / Red brown
Density:	1.27 kg/l
Solids Content:	40,0% by volume ± 0.6
Viscosity:	90 - 94 KU /Krebs Stormer Units at 20°C
Recommended film thickness:	35 µm dry, equals 90 µm wet

VOC-content:	14 g/l max.
Ready-for-use mixture:	14 g/l max.
Category:	A/i
EU Limit values:	150 g/l (2007) / 100 g/l (2010)

Drying times	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	30 minutes	1 hour	15 minutes
To handle:	1 hour	2 hours	30 minutes
To recoat:	After 1 hour	After 6 hours	After 1 hour
Full hardness	3 days	5 days	2 days

Heat resistance: 80°C (dry heat)

Coverage

Theoretical:	11.5 m ² /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, alkali residues and all other deposits. Remove loose rust, rust-scale and deteriorated coatings by scraping and wire brushing. Remove zinc salts with SURFA-ETCH 108® Etching Solution. Rinse with clean water. Tight rust scale and mill scale are most effectively removed by abrasive blasting. The surface must be clean and dry during application. Degrease and sand intact coatings to roughen the surface slightly.

DIRECTION FOR USE

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

Rust-Oleum Netherlands B.V.
Braak 1, 4704 RJ
P.O. Box 138, 4700 AC
Roosendaal, The Netherlands
T +31 (0)165 593 636
F +31 (0)165 593 600
info@rust-oleum.eu
www.rust-oleum.eu

N.V. Martin Mathys S.A.
Kolenbergstraat 23
3545 Zelem
Halen, Belgium
T +32 (0)13 460 200
F +32 (0)13 460 201
info.be@ro-m.com
www.ro-m.com

Rust-Oleum France S.A.S
11, Rue Jules Verne, B.P. 60039
95322 St-Leu-la-Forêt Cedex
France
T +33 (0)1 30 40 00 44
F +33 (0)1 30 40 99 80
info.fr@ro-m.com
www.ro-m.com

Rust-Oleum UK Ltd.
Rotterdam House
116 Quayside
Newcastle
NE1 3DY
United Kingdom
T +44 (0)2476 717 329
F +44 (0)2476 718 930
info@rust-oleum.eu
www.rust-oleum.eu

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APPLICATION & THINNING

- Brush:** Sparingly, if required, with water.
Use brushes based on a mixture of synthetic/natural bristles.
- Roller:** Sparingly, if required, with water
Use medium nap, 8-12 mm, woven acrylic or polyester rollers.
Roller application may require 2 coats to achieve recommended dry film thickness.
- Air-atomised spray:** Sparingly, if required, with water.
Gravity cup and pressure cup.
Tip size: 1.2 -1.8 mm.
Atomising pressure: 2 - 4 bar.
- Airless spray:** Sparingly, if required, with water.
Pneumatic and electric airless equipment.
Tip size: 0.015-0.018 inch.
Fluid pressure: 150 - 225 bar.
Check wet film thickness, avoid excessive film thickness.
- Cleanup:** Immediately after use with water and soap.

APPLICATION CONDITIONS

Temperature of air, substrate and coating material between 10 and 35°C and relative humidity below 85%. The substrate temperature must be at least 5°C above dew point.

REMARKS

Maximum dry film thickness per coat: 60 µm dry, equals 150 µm wet.

SAFETY

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

SHELF LIFE / 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.

Keep from freezing.

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