

PRODUCT DATA

HEAVY-DUTY GREY METAL PRIMER 1080

DESCRIPTION

RUST-OLEUM® Heavy-Duty Grey Metal Primer 1080 is based on a fish oil containing alkyd resin. The product contains rust-inhibitive pigments and is lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM 1080 should be used on new, blasted steel surfaces or on surfaces primed with RUST-OLEUM Alkyd Primers.

RUST-OLEUM 1080 is primarily intended for brush application and can also be applied by roller and spray.

RUST-OLEUM 1080 assures appropriate protection under light industrial exposure conditions, if applied on a RUST-OLEUM Alkyd Primer followed by a RUST-OLEUM Alkythane 7500.

TECHNICAL DATA

Appearance: Flat
Colour: Grey
Density: 1.37 kg/ltr.
Solids Contents: 53.5% by volume
Viscosity: 100 - 105 KU /Krebs Stormer Units at 20°C
Recommended film thickness: 60 µm dry, equals 105 µm wet

VOC-content: 367 g/l max.
Ready-to-use mixture: 449 g/l max.
Category: A/i
EU Limit values: 600 g/l (2007) / 500 g/l (2010)

Drying times	20°C/50% r.v.	10°C/60% r.v.	30°C/50% r.v.
To touch:	4 hours	16 hours	3 hours
To handle:	8 hours	24 hours	6 hours
To recoat:	After 24 hours	After 36 hours	After 24 hours
Full hardness	8 days	14 days	6 days

Heat resistance: 120°C (dry heat)

Coverage

Theoretical: 60 µm dry, equals 105 µm wet
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 and deteriorated coatings by abrasive blasting to Sa 2½ (ISO 8501-1 : 1988), blast profile max. 50 µm. Sand previous coatings which are in good condition to roughen the surface slightly. The surface must be clean and dry during application.

DIRECTION FOR USE

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

APPLICATION & THINNING

Brush: Up to 10 vol. %; RUST-OLEUM Thinner 633.
Use natural bristles, longhair brushes.

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- Roller: Up to 10 vol. %; RUST-OLEUM Thinner 633.
Use medium nap, polyamide (perlon 8 -14 mm) rollers.
Roller application may require 2 coats to achieve recommended dry film thickness.
- Air-atomised spray: 10-20 vol.%; RUST-OLEUM Thinner 641.
Gravity cup and pressure cup.
Tip size: 1.4 -2.2 mm.
Atomizing pressure: 2 - 4 bar.
- Airless spray: Up to 20 vol.%; RUST-OLEUM Thinner 641.
Pneumatic and electric airless equipment.
Tip size: 0.013-0.015 inch Fluid pressure: 130 - 200 bar.
Check wet film thickness, avoid excessive film thickness.
- Cleanup: Use RUST-OLEUM Thinner 160 or mineral spirits.

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: 100 µm dry, equals 200 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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