

PRODUCT DATA HEAT-RESISTANT SYSTEM ORANGE PRIMER 4268

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DESCRIPTION

RUST-OLEUM® Heat-Resistant System Orange Primer 4268 is based on a silicone modified alkyd resin. The product contains rust-inhibitive pigments and is lead- and chromate free.

RECOMMENDED USES

RUST-OLEUM 4268 should be used on new, bare steel or blasted steel surfaces. RUST-OLEUM 4268 is intended for brush and roller application and can also be applied by spray. RUST-OLEUM 4268 provides heat resistance up to 425°C dry heat in sheltered or interior environments, if recoated with RUST-OLEUM Heat-Resistant System Aluminium Topcoat 4215. On blasted steel two coats of RUST-OLEUM Primer 4268 should be applied prior to the application of RUST-OLEUM Aluminium Topcoat 4215.

TECHNICAL DATA

Appearance:	Flat
Colour:	Orange
Density:	1.38 kg/l
Solids Content:	34.4% by volume
Viscosity:	86 - 90 KU /Krebs Stormer Units at 20°C
Recommended film thickness:	35 µm dry, equals 100 µm wet
VOC-content:	598 g/l max.
Ready-to-use mixture:	642 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:	30 minutes	45 minutes	15 minutes
To handle:	2 hours	3 hours	2 hours
To recoat:	After 24 hours	After 48 hours	After 24 hours
Full hardness	24 hours after minimum service temperature is reached. Heat up the coating slowly (max. 50°C/hr) until 150°C.		

Heat resistance: 425°C (dry heat)

Coverage

Theoretical: 9.8 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 and deteriorated coatings by abrasive blasting to Sa 2½ (ISO 8501-1 : 1988), blast profile max. 50 µm. 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 150.
Use natural bristles, longhair brushes.

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- Roller: Up to 10 vol. %; RUST-OLEUM Thinner 150
Use medium nap, polyamide (perlon 8 -12 mm) rollers
Roller application may require 2 coats to achieve recommended dry film thickness.
- Air-atomised spray: 10-20 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.
Check wet film thickness, avoid excessive film thickness.
- Cleanup: Use RUST-OLEUM Thinner 150/160 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 175 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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