

## PRODUCT DATA

### WATER-BASED EPOXY SYSTEM PRIMER 5980

#### DESCRIPTION

RUST-OLEUM Water-Based Epoxy System Primer 5980 is based on two-component, low odour, water-based epoxy resins. The product contains rust-inhibitive pigments and is lead- and chromate free.

#### RECOMMENDED USES

RUST-OLEUM Water-Based Epoxy System Primer 5980 should be used on thoroughly cleaned steel and galvanized substrates.

RUST-OLEUM 5980 Primer can be applied by brush, roller and spray.

RUST-OLEUM 5980 Primer can be recoated with RUST-OLEUM 5900 Topcoats, RUST-OLEUM 5090 Anti Condensation Coating or with RUST-OLEUM 5500 Solvent Free Epoxy Coatings, assuring the appropriate protection; e.g. at heavy industrial exposures a three coat system, two 5980 Primers and one 5900 Topcoat on steel and a two coat system, one Primer and one Topcoat on galvanized steel.

RUST-OLEUM 5980 Primer is classified Class 1 Surface Spread of Flame according BS 476; part 7: 1987.

#### TECHNICAL DATA

Appearance: Flat  
Colour: Grey  
Density: 1.31 kg/l (mixed product) 5980 Grey  
Solids Content: 36.2 % by volume (mixed product) 5980 Grey  
Viscosity: 120-130 KU/Krebs Stormer Units at 20°C (mixed)  
Recommended film thickness: 50 µm dry, equals 140 µm wet

VOC-content max.: 139 g/l  
Ready-to-use mixture: 139 g/l  
Category: A/j  
EU Limit values: 140 g/l (2007) / 140 g/l (2010)

Drying times	20°C/50% r.h.	10°C/60% r.h.	30°C/50% r.h.
To touch:	4 hours	12 hours	2 hours
To handle:	6 hours	24 hours	4 hours
To recoat:	After 6 hours	After 24 hours	After 4 hours
Full hardness	7 days	14 days	5 days

Heat resistance: 150°C (dry heat); at elevated temperatures discoloration may occur.

#### Coverage

Theoretical: 6.8 / 7.2 m<sup>2</sup>/l at 50 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 with RUST-OLEUM FK 111 Fungicidal Cleaning Solution or by alkaline or high pressure (steam) cleaning.

For optimum results remove rust, rust scale, mill scale and deteriorated coatings by abrasive blasting to Sa 2½ (ISO 8501-01 : 1988), blast profile max. 50 µm.

If blasting is not possible remove loose rust and loose coatings by scraping and/or wire brushing to St 3 (ISO 8501-1 : 1988).

Salts, "white rust" (on galvanized steel), etc. should be removed by washing with RUST-OLEUM Surfa-Etch 108 Etching Solution or by brush-off blasting.

Sand previous coatings, which are in good condition to remove gloss and to roughen the surface slightly. The surface must be clean and dry during application.

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#### DIRECTION FOR USE

Stir individual components thoroughly before mixing them together. Use the boxing method or a low speed mixer.

Mixing ratio: Activator (5901) : base = 1 : 1 by volume  
Induction time: 30 minutes of a 5 ltr. mix at 20°C  
Pot-life: 5 hours of a 5 ltr. mix at 20 °C., after 5 hours the material should  
Not be used anymore

#### APPLICATION & THINNING

Brush/Roller: If required, up to 5 vol. % water.  
Use brushes based on a mixture of synthetic/natural bristles or medium nap (12 mm), woven acrylic or polyester rollers. Roller application may require 2 coats to achieve recommended d.f.t.

Air-atomised spray: Up to 5 vol. % water.  
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. % water.  
Pneumatic and electric airless equipment.  
Tip size: 0.018-0.024 inch.  
Fluid pressure: 150 - 225 bar.

Cleanup: Immediately after application with (hot) water and soap. If the coating  
Spray equipment should be flushed every 2 hours with (hot) water to  
Preferably use disposable brushes and/or rollers.

#### APPLICATION CONDITIONS

Temperature of air and substrate between 5 and 35°C and relative humidity below 70%. The substrate temperature must be at least 5°C above dew point.

#### REMARKS

Maximum dry film thickness per coat: 100 µm dry, equals 280 µm wet. If the relative humidity is high during drying, curing might be retarded.

#### SAFETY

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

#### SHELLIFE / STORAGE CONDITIONS

2 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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