

## RUST-ONE

RUST-ONE, is surface tolerance type modified epoxy and special curing agent pigmented with aluminium. Self-priming and suitable for application over existing coatings, and tightly adherent to rust.

RUST-ONE is also designed for non ferrous substrate Aluminium, Galvanized steel, Stainless steel.

It has excellent properties such as adhesion, toughness, impact, abrasion resistance and water resistance.

Rust -ONE has Vocs compliant to current LEED <250 g/l.

### TECHNICAL DATA

Type	: High-solid modified Epoxy Polyamide				
Recommended Use	: As surface tolerant primer of epoxy paint system.				
Mixing Ratio	: Base : Hardener = 74 : 26 (by volume) ; 83 : 17 (by weight)				
Colour	: Silver				
Flash Point	: Base = 25°C	Hardener = 27°C			
VOC	: 232 [g/litre]	EPA Method 24			
Solid by Volume	: 77.0 ± 2%				
Coverage (Theoretical)	: 0.13 - 0.19 l/m <sup>2</sup>	:	: 7.70 - 5.13 m <sup>2</sup> /l		
Wet Film Thickness	: 5.19 - 7.79 mils	:	: 130 - 195 microns		
Dry Film Thickness	: 4.00 - 6.00 mils	:	: 100 - 150 microns		
Drying Time	: Temperature	10°C	20°C	30°C	40°C
(at D.F.T. 150 microns)	: Surface Dry	7 hrs.	3.5 hrs.	1.5 hrs.	45 mins.
	: Hard Dry	28 hrs.	12 hrs.	6 hrs.	5 hrs.
Painting Interval	: Minimum	28 hrs.	12 hrs.	6 hrs.	5 hrs.
(at D.F.T. 150 microns)	: Maximum*	-	-	-	-
Pot Life	:	5 hrs.	3 hrs.	1.5 hrs.	1 hr.
Thinner	: CMP-31				
Method of Application	: Airless spray , Roller , Brush				
Conditions of Application	: Temperature	Minimum 5°C			
	: Humidity	Maximum 85% RH			
	For Airless spray :				
	: Tip No.	GRACO 517, 721			
	: Paint output pressure	14.7 - 17.7 MPa.			
	: Thinning	0 - 15 % by volume			
Recommended Surface-preparation	: Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminant For old paint film : Lightly sand to roughen surface and degloss the surface.				
Preceding coats	: Self Priming.				
Subsequent coats	: Wide range of any coating such as Epoxy, Polyurethane, Evamarine, etc.				
Packaging	: Two pack product per set ; 3.785 Litres / Gallon , 18.925 Litres / Drum.				
Shelf life at 25°C	: Base 24 months , Hardener 24 months , In unopened container				

Don't exceed 8 mils (200 microns) in a single coat. Excessive film thickness over will increase drying and curing time.

As nature of epoxy coatings RUST-ONE can not avoid chalking yellowing and fading on sunlight exposure

Maximum recoat time is limited. The surface must have a clean, dry surface free of chalk, etc.

Safety period should be coated within 30 days interval.

Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Cut"