RUST-OLEUM® HIGH PERFORMANCE®

3100 SYSTEM
SPEEDY-DRY DTM ACRYLIC ENAMEL PRIMER

DESCRIPTION AND USES

A low-VOC, water-based, fast-dry, acrylic primer designed for mild to moderate industrial conditions.

PRODUCTS

1-Gallon	5-Gallon	Description
3169402	3169300*	Red Primer
3181402	3181300	Gray Primer

*Made to Order only. Contact Rust-Oleum Customer Service for details.

COMPANION PRODUCTS

RECOMMENDED TOPCOATS

Designed for use with Rust-Oleum 3100 System Speedy-Dry DTM Acrylic Enamels.

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength® Cleaner/Degreaser item #3599402, commercial detergent or other suitable cleaner. Mold and mildew must be cleaned with a chlorinated cleaner or bleach solution. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE 3) with a 1-2 mil (25-50µ) surface profile is recommended for optimal performance. Abrasive blast cleaned steel requires two coats of primer.

APPLICATION

Mix thoroughly. Apply only when air and surface temperatures are between 50-100°F (10-38°C), the relative humidity is not greater than 85%, and surface is at least 5°F (3°C) above dew point. Abrasive blast clean steel requires two coats of primer. Dry times may be effected by extremely high or low relative humidity.

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable)

BRUSH: Use a good quality synthetic bristle brush.

ROLLER: Use a good quality natural or synthetic cover.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomizing Pressure
Pressure	0.055-0.070	12-16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP (var.)	0.043-0.070	8-10 oz./min.	10 psi (at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1,600-2,400 psi	0.013-0.017	100

THINNING

BRUSH: Normally not required. When necessary, thin with fresh water. (Touch-up only)

AIR ATOMIZED SPRAY: Water up to 1 pint per gallon.

AIRLESS SPRAY: Water up to ½ pint per gallon.

CLEAN-UP

BRUSH: Use soap and water immediately after use.

SPRAY: **Immediately** flush spray lines with water, followed by Rust-Oleum® Thinner #160402 or Pure Strength® Cleaner/Degreaser.

PERFORMAMCE CHARACTERISTICS

PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: F

CONICAL FLEXIBILITY

Rating 1-10, 10=best

METHOD: ASTM D5894, 2 cycles, 672 hours

RESULT: 10 per ASTM D714 for blistering

IMPACT RESISTANCE (direct)

METHOD: ASTM D2794

RESULT: >160 / >160

TABER ABRASION

METHOD: ASTM D4060, CS-17 wheels, 500 g load, 1000 cycles

RESULT: 52 mg loss

For chemical and corrosion resistance see page 4 of the Rust-Oleum Industrial Brands Catalog Form # 206275.

RUST-OLEUM HIGH PERFORMANCE

TECHNICAL DATA

3100 SYSTEM SPEEDY-DRY DTM ACRYLIC ENAMEL PRIMER

PHYSICAL PROPERTIES

		ACRYLIC PRIMERS
Resin Type		Acrylic dispersion
Pigment Type		Water, Zinc phosphate, calcium carbonate, red iron oxide
Solvents		Water, propylene glycol
Weight	**Per Gallon**	9.8-10.4 lbs.
	Per Liter	1.2 kg
Solids	**By Weight**	51.0-52.5%
	By Volume	40.0-41.5%
Volatile Organic Compounds		<250 g/l (2.08 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5µ)
Wet Film to Achieve DFT (unthinned material)		4.0-6.5 mils (100-162.5µ)
Theoretical Coverage at 1 mil DFT (25µ)		640-665 sq. ft./gal. (15.7-16.4 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		220-380 sq. ft./gal. (5.4-9.3 m^2/l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	**Tack-free**	40-60 minutes
	Handle	1.0-1.5 hours
	Recoat	1.0-1.5 hours
Dry Heat Resistance		200°F (93°C)
Shelf Life		5 years
Safety Information		**PROTECT FROM FREEZING. MAY CAUSE EYE AND SKIN IRRITATION. MAY BE HARMFUL IF SWALLOWED. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. SEE THE PRODUCT MATERIAL SAFETY DATA SHEET (MSDS) AND LABEL WARNINGS FOR ADDITIONAL SAFETY INFORMATION.**

Calculated values are shown and may vary slightly from the actual manufactured material.

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.

RUST-OLEUM INDUSTRIAL BRANDS

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