

## DESCRIPTION AND USES

A low VOC, fast-dry, direct-to-metal (DTM), water-based acrylic high gloss enamel.

Designed for application to properly prepared steel surfaces and previously coated and primed substrates in mild to moderate industrial environments. Ideal for use on equipment, machinery, and any other areas where fast dry and minimal downtime is required.

The 3100 System Enamels comply with USDA FSIS regulatory sanitation performance standards for food establishment facilities. This coating is impervious to moisture and easily cleaned and sanitized.

## PRODUCTS

### READY MIXED HIGH GLOSS FINISHES

1-Gallon	5-Gallon	DESCRIPTION
3115402	----	Alumi-Non® (semi-gloss)
3125402	----	Safety Blue
3144402	3144300	Safety Yellow
3165402	----	Red
3171402	3171300*	Dunes Tan
3179402	3179300	Black
3192402	3192300	White

### TINT BASES

1-Gallon	5-Gallon	DESCRIPTION
3107411	3107391*	Masstone Tint Base
3108418	3108394*	Deep Tint Base
3109417	3109397	Light Tint Base

## COMPANION PRODUCTS

### COMPATIBLE PRIMERS

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

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

## PRODUCT APPLICATION

### SURFACE PREPARATION

**ALL SURFACES:** Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® Original Cleaner Degreaser, 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 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.

**CONCRETE AND MASONRY:** Hand or power tool clean to remove all loose or unsound concrete, masonry, or previous coating. Very dense, non-porous concrete should be acid etched or abrasive blasted to remove the laitance layer and create a surface profile. Allow new concrete to cure for 30 days before coating.

**PREVIOUSLY COATED:** Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding to create a surface profile. The Rust-Oleum Industrial Speedy-Dry DTM Acrylic Enamel is compatible with most coatings, but a test patch is suggested.

### APPLICATION

Apply only when the air and surface temperatures are between 50-100°F (10-38°C) and the surface temperature is at least 5°F (3°C) above the dew point. The relative humidity should not be greater than 85%. Extremely high or low relative humidity can effect dry times and the final gloss of the coating. For optimum protection on abrasive-blasted steel, two coats of Rust-Oleum Industrial Speedy-Dry DTM Acrylic Red or Gray Primer plus one coat of Rust-Oleum Industrial Speedy-Dry DTM Acrylic Enamel are required.

**RUST-OLEUM®**  
**HIGH PERFORMANCE**  
 INDUSTRIAL COATINGS

# RUST-OLEUM® 3100 SYSTEM

## SPEEDY DRY DTM ACRYLIC ENAMEL

### PRODUCT APPLICATION (cont.)

#### EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable)

BRUSH: Use a good quality synthetic bristle brush.

#### AIR-ATOMIZED SPRAY

Method	Fluid Tip	Fluid Delivery	Atomized Pressure
Pressure	0.055-0.070	8-16 oz./min.	60-75 psi
Siphon	0.055-0.070	--	30-60 psi

#### AIRLESS SPRAY

Pump Ratio	Fluid Pressure	Fluid Tip†	Filter Mesh
30:1	2,500-3,000 psi	0.013-0.017	100

†3115 Aluminum should be applied with a 411 tip for best spray.

#### THINNING

BRUSH: Thinning normally not required.

AIR-ATOMIZED SPRAY: 5-10% by volume (approximately ½ pint/gallon) with fresh clean water if needed.

AIRLESS SPRAY: Thinning normally not required.

#### CLEAN-UP

Soap and water.

### PERFORMANCE CHARACTERISTICS

#### PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: H

#### CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >33%

#### GLOSS (60°)

METHOD: ASTM D4587

RESULT: 97 (color-black)

#### CYCLIC PROHESION

Rating 1-10, 10=best

METHOD: ASTM D5894, 2 cycles, 672 hours

RESULT: 10 per ASTM D714 or blistering

RESULT: 9 per ASTM D1654 or corrosion

#### IMPACT RESISTANCE (direct/reverse)

METHOD: ASTM D2794

RESULT: >160/>160

#### ACCELERATED WEATHERING (% gloss retention)

METHOD: ASTM D4587, QUV type A bulb, 450 hours

RESULT: 87% retention (color-black)

#### TABER ABRASION

METHOD: ASTM D4060 CS-17 wheels, 500 g. load, 1,000 cycles

RESULT: 64 mg loss

For chemical and corrosion resistance see page 4 of the Rust-Oleum Industrial Brands Catalog Form # 275585.

<b>ACRYLIC</b>	<b>TECHNICAL DATA</b>	<b>RO-31</b>
<b>RUST-OLEUM® HIGH PERFORMANCE INDUSTRIAL COATINGS</b>	<b>RUST-OLEUM® 3100 SYSTEM SPEEDY DRY DTM ACRYLIC ENAMEL</b>	

### PHYSICAL PROPERTIES

		READY MIX FINISHES	TINT BASES
<b>Resin Type</b>		Water-based acrylic polymer	Water-based acrylic polymer
<b>Pigment Type</b>		Varies with color	Varies with color
<b>Solvents</b>		Water	Water
<b>Weight</b>	<b>Per Gallon</b>	8.7-10.1 lbs.	8.7-10.3 lbs.
	<b>Per Liter</b>	1.0-1.2 kg	1.0-1.2 kg
<b>Solids</b>	<b>By Weight</b>	39-50%	40.0-51.3%
	<b>By Volume</b>	36-39%	37.0-39.5%
<b>Volatile Organic Compounds</b>		<250 g/l (2.08 lbs./gal.)	<250 g/l (2.08 lbs./gal.)
<b>Recommended Dry Film Thickness (DFT) Per Coat</b>		1.5-2.5 mils (37.5-62.5µ)	1.5-2.5 mils (37.5-62.5µ)
<b>Wet Film to Achieve DFT (unthinned material)</b>		4-7 mils (100-175µ)	4-7 mils (100-175µ)
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		200-350 sq. ft./gal. (4.9-8.6 m <sup>2</sup> /l)	200-350 sq. ft./gal. (4.9-8.6 m <sup>2</sup> /l)
<b>Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity</b>	<b>Tack-free</b>	15-60 minutes	15-60 minutes
	<b>Handle</b>	1.0-1.5 hours	1.0-1.5 hours
	<b>Recoat</b>	1.5-2.0 hours	1.5-2.0 hours
<b>Dry Heat Resistance</b>		200°F (93°C)	200°F (93°C)
<b>Moisture Resistance</b>		16 hours	16 hours
<b>Force Cure</b>		5 minutes flash off; 10-20 minutes at 140-160°F (dry to handle after cooling). Dry times are based on 50% relative humidity and 70°F (21°C). Temperatures lower than this and higher humidity will extend dry time. High humidity, moisture or rain can cause blistering if subjected to these conditions before 16 hours at 70°F (21°C) and 50% relative humidity.	
<b>Shelf Life</b>		5 years (protect from freezing)	5 years (protect from freezing)
<b>Safety Information</b>		<b>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.</b>	

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

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