

RUST-OLEUM®
HIGH PERFORMANCE
 INDUSTRIAL COATINGS

HIGH PERFORMANCE
ROC PRIME

DESCRIPTION AND USES

ROC Prime is a one-part low-VOC, universal water-based epoxy hybrid primer designed to deliver two-component performance for indoor or outdoor applications in mild to moderate environments. ROC Prime is a universal primer that can be top-coated with any Rust-Oleum topcoat and used on almost any substrate. It has excellent adhesion to steel, stainless steel, concrete, bare aluminum, hot dipped galvanized steel, wood, glass, previously coated metals and more. A test patch is recommended for, Kynar®, fiberglass, plastics and copper.

PRODUCTS

DESCRIPTION (Flat)	1 Gallon	5 Gallons
Gray Primer	358063	358062

RECOMMENDED TOPCOATS

Sierra Performance MetalMax® DTM Acrylic Enamel
 Sierra Performance Beyond™ Acrylic Enamel
 3700 System DTM Acrylic Enamel
 3800 System DTM Acrylic Enamel
 5200 System DTM Acrylic

COMPATIBLE TOPCOATS

3300 System Aliphatic Urethane
 7400 System 450 VOC DTM Alkyd Enamel
 V7400 System 350 VOC DTM Alkyd Enamel
 CV740 System 100 VOC DTM Alkyd Enamel
 9100 System DTM Epoxy Mastic
 9800 System DTM Urethane Mastic
 Sierra Performance S60 Epoxy Maintenance Coating
 Modern Masters® Colorfast

NOTE: ROC Prime may be used with any Rust-Oleum Roof Coating including silicone topcoats.

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 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.

PRODUCT APPLICATION (cont.)

SURFACE PREPARATION (cont.)

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. ROC Prime is compatible with most coatings, but a test patch is suggested.

GALVANIZED METAL: Remove oil, dirt, grease and other chemical deposits with Krud Kutter Original Cleaner Degreaser or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

CONCRETE OR MASONRY: New concrete or masonry must cure 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas. Remove all loose, unsound concrete.

APPLICATION

Mix thoroughly to re-disperse any settled pigment. Apply only when air and surface temperatures are between 40-100°F (4-38°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 affected by extremely high or low relative humidity.

EQUIPMENT RECOMMENDATIONS

BRUSH/ROLLER: Use a good synthetic bristle brush or short nap roller cover (1/4-1/2 inch).

AIR-ATOMIZED SPRAY

Method	Fluid Tip	Fluid Delivery	Atomized Pressure
Pressure	0.055-0.070	10-16 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
1,800-3,100 psi	0.013-0.017	100

THINNING

BRUSH/ROLLER: Normally not required. When necessary, thin with fresh water.

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

AIRLESS SPRAY: Water up to 1 pint per gallon.

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PRODUCT APPLICATION (cont.)

CLEAN UP

BRUSH/ROLLER: Use soap and water immediately after use.

SPRAY: Immediately flush spray lines with water, followed by Rust-Oleum #160402 Epoxy Thinner or Krud Kutter Original Cleaner/Degreaser.

PERFORMANCE CHARACTERISTICS

PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: 5B

CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >33%

CORROSION RESISTANCE

METHOD: ASTM B117, 1000 hours with 3800 White Topcoat
 Mils DFT- 3.0-3.5

RESULT: ASTM D7087 for creepage – 3 mm

IMPACT RESISTANCE (direct/reverse)

METHOD: ASTM D2794

RESULT: 144/40 in. lbs.

TABER ABRASION

METHOD: ASTM D4060, CS10 wheels, 500 gram load,
 1,000 cycles

RESULT: 116 mg loss

TENSILE STRENGTH

METHOD: ASTM D2370

RESULT: 476 psi

ELONGATION

METHOD: ASTM D2370

RESULT: 75%

ADHESION BY TAPE TEST

METHOD: ASTM D3359B

SUBSTRATE and RESULT:

Bonderite coated steel (dry)-5B

Bonderite coated steel (wet)-5B

Cold rolled steel (dry)-4B

Birch plywood (dry)-4B

Birch plywood (wet)-5B

Aluminum (dry)-4B

Concrete (wet)-5B

Stainless Steel (dry)-5B

Glass (dry)-4B

Glass (wet)-5B

PRIMER	TECHNICAL DATA	RO-162
RUST-OLEUM[®] HIGH PERFORMANCE INDUSTRIAL COATINGS	HIGH PERFORMANCE ROC PRIME	

PHYSICAL PROPERTIES

		ROC PRIME
Resin Type		Water-based Epoxy Amine Adduct
Pigment Type		TiO ₂ , Nepheline Syenite, Magnesium Silicate, Zinc Phosphate, Zinc Oxide
Solvents		Water, Texanol
Weight	Per Gallon	10.62 lbs.
	Per Liter	1.27 kg
Solids	By Weight	54.2-54.4%
	By Volume	41.6-41.8%
Volatile Organic Compounds		<50 g/l (0.42 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)		4.0-7.0 mils (100-175μ)
Practical Coverage at Recommended DFT (assumes 15% material loss)		225-380 sq.ft./gal. (5.5-9.3 m ² /l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	Touch	1-2 hours
	Handle	2-4 hours
	Recoat	2 hours-6 months
Dry Heat Resistance		200°F (93°C)
Shelf Life		3 years
Warning!		PROTECT FROM FREEZING
Safety Information		For additional information, see SDS

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Rust-Oleum Corporation
11 Hawthorn Parkway
Vernon Hills, Illinois 60061

Phone: 877-385-8155
www.rustoleum.com/industrial

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