TECHNICAL SPECIFICATIONS GUIDELINE

ANTICORROSION TOPCOATS ALKYTHANE 7500

Anticorrosion alkyd-urethane paint for protection of metal surfaces..

CHARACTERISTICS

- Long lasting protection
- High film thickness per coat, without sagging
- Excellent opacity and smooth finish
- Application at low temperature
- Flexible and solid film, resists thermal shocks
- Tintable to any color, available in gloss and satin
- Associated tintable anticorrosion primers

ACCEPTABLE SUBSTRATES

STEEL

Surface condition

Steel substrates must be properly supported to avoid warping, which could cause the coating to work and lead to cleavage.
A: Steel substrate extensively covered with adhered mill scale but with few or no rust at all.
B: Steel substrate that has started to rust and whose mill scale has started to delaminate.
C: Steel substrate from which mill scale has disappeared under action of rust, or that can be removed by scrapping, but showing some rust cankers visible by naked eye.
D: Steel substrate from which mill scale has disappeared under action of rust, or that can be removed by scrapping, but showing a lot of rust cankers visible by naked eye.

NON-FERROUS METALS

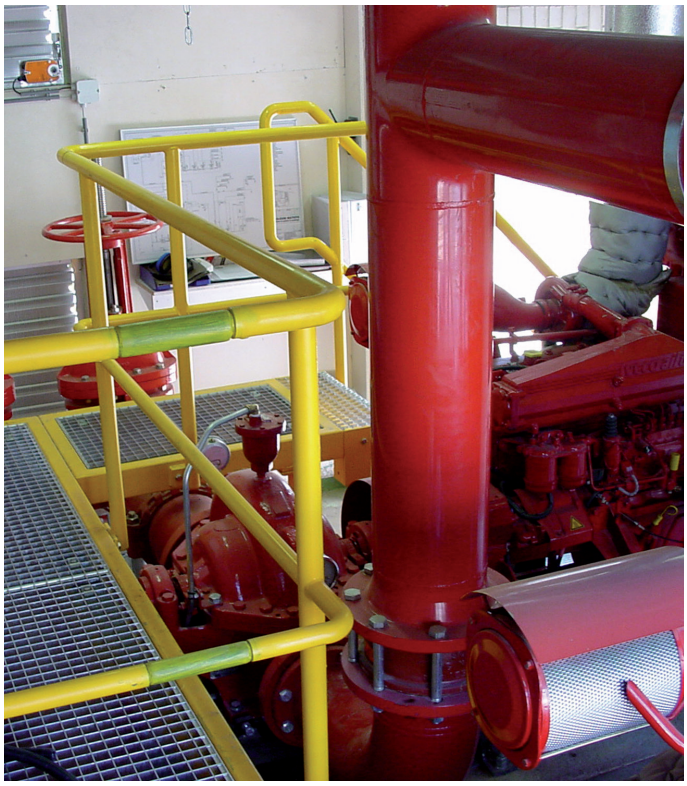
Surface condition

Surfaces must be made up of solid and non-deformable structures.

OLD COATINGS

Surface condition

Old paints and coatings should be perfectly adherent and compatible with a solvent-based alkyd system. In case of doubt, carry out a test on a small control-surface. Compatibles glossy coatings will be sanded mechanically.



KNOW-HOW TO PROTECT™

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SURFACE PREPARATION

GENERAL

Remove any dust, debris etc ; degrease and eliminate any contamination by alkaline cleaning with Cleaner-Degreaser RUST-OLEUM ND14 or high pressure cleaning combines with appropriate detergent, followed by thorough rinsing and full drying.

STEEL

See General.

Remove rust, rust scales, mill scale and old paints in bad condition, either manually or mechanically, according to the surface* :

Grades A and B : abrasive blasting SA 2 ½ (ISO 8501-01), max. rugosity 50 µm.

Grades C and D : pitting, grinding or scrapping-wire brushing to degree of care St 2/3 (ISO 8501-01), abrasive blasting SA 2 ½ (ISO 8501-01), max. rugosity 50 µm.

** Large surfaces will be preferably treated by abrasive blasting.*

GALVANIZED STEEL

See General.

New galvanized steel will be degreased and etched with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

Zinc oxides, « white rust » will be eliminated with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

NON-FERROUS METALS

See General.

New aluminum will be degreased and etched with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

Salts and oxides will be eliminated with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

RECOMMENDED WORKING PROCEDURES

DESIGN (STEEL)

The risk of corrosion can be limited and efficiency of protection dramatically improved when the object design is taken into account.

Preparation :

Shard edges will be rounded bt grinding to an angle of at list 3 mm ; weldings and their spillages will be grinded; cut-outs will be deburred.

Avoid non-accessible gaps and discontinuous weldings. Bolts, nuts, rivets etc will be coated with a primer. The latter will be first applied as a touch-up by brush, then as a general coat, ensuring this way a double thickness on most exposed spots.

PRECAUTIONS

During application and first phase of drying (± 8 hours), a high humidity and/or condensation can cause a lower quality of the film, together with premature corrosion growth, if not recoated in time.

PRIMERS

New or slighty rusted steels will receive Primer 569/580 or 1060/1080 following corrosivity class.

Rusted steels manually prepared (St 2/3) will received Anti-humid rust Primer 769.

Blasted steels will receive Heavy Duty primers 1060/1080.

Galvanized steels and non-ferrous metals will receive adhesion Undercoat Galvinoleum 3202.

APPLICATION CONDITIONS

Temperature of air, substrate and product should be between 5 and 35°C, and relative humidity below 85%. Le température du support sera de 3°C supérieure au point de rosée.

Product mixing: mix the paint vigorously by hand (small packs 1L) or by slow speed electric mixing machine, maximum 300 rounds/minutes (packs 5L and more), until homogeneous result is obtained.

Consult technical data sheets for details on drying times, induction times, pot-life, dilution and recommended application methods. Consult safety data sheets for any information related to safety during use of products.

BACK TO SERVICE (FLOORS)

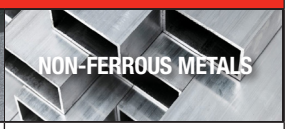
Depending on temperature, most of urethane-alkyd coatings will be hard after 24h. However the coating remains vulnerable to the action of humidity, detergents and chemicals, until full hardness is reached. It is therefore necessary to take precautions on the coating system as a consequence for one week. During application and drying, solvent-based coatings require good ventilation ; in closed spaces, a forced ventilation is required to avoid solvent retention in the paint film. Best results are obtained when product is applied at an average temperature of 20°C (air, substrate), and when relative humidity can be maintained below 70%. To the extent that hardening of product is a chemical reaction between its two components, temperature plays an important role ; full hardness is reached after about 7 days et 20°C.

SURFACE MAINTENANCE

A RUST-OLEUM 7500 ALKYTHANE system can be maintained by cleaning with a neutral detergent or alkaline detergent diluted with water. A worn coat can be easily restored by adequate surface preparation and application of a new coat of product. On metal, in case of rust reformation, it is advised to not postpone repair, to prevent any growth.

SYSTEMS OVERVIEW

ANTICORROSION SYSTEMS

SUBSTRATES	 STEEL		 PAINTED STEEL		 GALVANIZED STEEL		 NON-FERROUS METALS	
Low to moderately agressive exposure	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :
Primer (1)	569/1060 (1)	35-60 µm	7500[2]	50 µm	3202	10 µm	3202	10 µm
1st coat	7500	50 µm	7500	50 µm	7500	50 µm	7500	50 µm
2nd coat	-		-		-		-	
Total film thickness		85-110 µm		100 µm		60 µm		60 µm
A gressive exposure	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :
Primer (1)	569/769 (1)	35 µm	569	35 µm	3202	10 µm	3202	10 µm
1st coat	1060	60 µm	7500	50 µm	7500	50 µm	7500	50 µm
2nd coat	7500	50 µm	7500	50 µm	7500	50 µm	7500	50 µm
Total film thickness		145 µm		135 µm		110 µm		110 µm

Remarks :

(1) Rusted steels prepared by Scraping-wire brushing ST2 will be treated with Anti-humid rust Primer 769. Steels prepared by abrasive blasting SA 2 to 2,5 will be treated with Reinforced rust primers 1060/1080.

(2) Rusted areas will be treated with Anti-humid rust Primer 769 or Reinforced rust primers 1060/1080

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Available colours and pack sizes: See the relevant product page at www.rust-oleum.eu for actual available colours and pack sizes.

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