

FEATURES

: Rust-shield is a one component modified epoxy primer paint.

A fast drying epoxy ester primer and anti-corrosive pigment zinc-phosphate for anticorrosive primer on ferrous metal.

: As a primer offers excellent protection against corrosion in exposure. Exhibits very good adhesion to steel structure, galvanized steel, aluminium.

It is suitable for application structural steel, machinery, piping and excellent for use high quality shop primer.

TECHNICAL INFORMATION

Type	: Modified epoxy primer
Color	: Grey, Orange, Brown
Film appearance	: Matt
Specific gravity	: 1.25 ± 0.02
Solid by volume	: 31 ± 2 %
Flash point	: 25 °C

	Minimum	Maximum	Recommended
Dry film thickness (Microns)	40	50	50
Wet film thickness (Microns)	129	161	161
Theoretical coverage. m ² / Liter	7.8	6.2	6.2
m ² / Gallon	29.3	23.5	23.5
Practical coverage. m ² / Liter	7.0	5.6	5.6
m ² / Gallon	26.4	21.0	21.0

Remark : Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique.

	25 °C	30 °C	35 °C
Touch dry	Surface dry 20 mins	15 mins	10 mins
Recoat dry	Hard dry 2 hrs.	1.50 hrs.	1 hr.
Full cure	Minimum 2 hrs.	1.50 hrs.	1 hr.
	Maximum -	-	-

Remark : Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly.

APPLICATION

Mixing Ratio	Part A	Part B	
By Volume	1	-	
By Weight	1	-	
Application Method	Airless Spray	Air Spray	Brush / Roller
Diluted by	5-10	15-20	15-20
TOA Thinner 39			
Applicator	Graco 419	Coventional Spray (Iwata)	Short Hair Stiff Nylon Roller (Stanley)
	Graco 421		Stiff Nylon Brush
Pressure	120-180 kg/cm ²	3-4 kg/cm ²	-

Mix Part A and Part B, strictly follow mix ratio recommendations before dilute by Thinner mixing and stir for 2-3 minutes until the mixture is homogeneous after leave 5 minutes before application.

APPLICATION INFORMATION

Surface Preparation

For Structure Coating

: Remover all oil, grease, dirt, oxide and other foreign material by cleaning per SSPC-SP1, Solvent Cleaning before coating.

: To prevent the formation of rust or oxide, coat as soon as possible after cleaning. For maximum protection, the coating must have direct contact with the metal surface.

contaminants with a suitable solvent. Metal should be blast cleaned in accordance with NACE No.2 / SSPC-SP10,

ISO 8501:1, SIS Sa 2.5 to a near-white finish using a suitable abrasive or hand tool cleaning in accordance with

SIS St 2 or SSPC-SP2 .

: Surface repair (cracks, pores, holes) done with TOA Epoxy putty and polishing of surface with moltoprene disk.

Coating System

Protective Coating

: Primer	Rustshield Primer	50 x 1 micron
: Topcoat	Topguard	60 x 2 microns

Recommendation

: The proper relative humidity in the work shall not exceed 85% RH.

: The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate for prevent moisture and water drop on substrate effective adhesion and drying time.

HANDLING AND STORAGE

Storage condition

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

: 24 months at 30-35 °C

: The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Package

Packaging size	1 Gallon	1/4 Gallon
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HEALTH AND SAFETY

: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

: For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.

DISCLAIMER

: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.