RUST-OLEUM® HIGH PERFORMANCE®

ROC PRIME 100

DESCRIPTION AND USES

ROC Prime 100 is a low-VOC, universal water-based epoxy amine-adduct primer designed for indoor or outdoor applications in mild to moderate industrial environments.

MPI #107 Certified*

PRODUCTS

1-Gallon	5-Gallon	Description
263500	266039	Red Primer
263501	266041	Gray Primer

RECOMMENDED TOPCOAT

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

COMPATIBLE TOPCOAT

7400 System 450 VOC DTM Alkyd Enamel
V7400 System 350 VOC DTM Alkyd Enamel
2500 System 250 VOC DTM Alkyd Enamel
CV740 System 100 VOC DTM Alkyd Enamel

ROC Prime 100 may be used with any Rust-Oleum High Performance topcoat.

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.

APPLICATION

Mix thoroughly to re-disperse any settled pigment. 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 affected by extremely high or low relative humidity.

* Refer to the MPI website for the most current listing of MPI certified products.

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

BRUSH/ROLLER: Use a good quality synthetic brush or short nap roller cover (¼-½ inch).

AIR-ATOMIZED SPRAY:

Method	Tip Fluid	Fluid Delivery	Atomizing 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
1,800-3,000 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.

CLEAN UP

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

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

PERFORMANCE CHARACTERISTICS

PENCIL HARDNESS

METHOD: ASTM D3363
RESULT: 4B

CONICAL FLEXIBILITY

METHOD: ASTM D522
RESULT: >33%

CYCLIC PROHESION

Rating 1-10, 10=best
METHOD: ASTM D5894, 4 cycles, 1344 hours
RESULT: ASTM D714 for blistering – 10 rating
ASTM D610 for corrosion – 10 rating
ASTM D7087 for creepage – 2 mm

IMPACT RESISTANCE (direct/reverse)

METHOD: ASTM D2794
RESULT: >200/>8 in. lbs.

TABER ABRASION

METHOD: ASTM D4060, CS10 wheels, 500 gram load, 1,000 cycles
RESULT: 55 mg. loss

RUST-OLEUM® HIGH PERFORMANCE

TECHNICAL DATA

ROC PRIME 100

PHYSICAL PROPERTIES

		ROC PRIME 100
Resin Type		Water-based Epoxy Amine Adduct
Pigment Type		Varies with color
Solvents		Water
Weight	**Per Gallon**	10.45-10.47 lbs.
	Per Liter	1.25 kg
Solids	**By Weight**	52.2-52.4%
	By Volume	39.9-40.2%
Volatile Organic Compounds		<100 g/l (0.83 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)
Theoretical Coverage at 1 mil DFT (25µ)		650 sq.ft./gal. (16 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		225-375 sq.ft./gal. (5.5-9.2 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	1-3 hours
Dry Heat Resistance		200°F (93°C)
Shelf Life		2 years
Warning!		**PROTECT FROM FREEZING**
Safety Information		For additional information, see SDS