RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

DESCRIPTION AND USES

ROCEpoxy Direct-To-Metal Epoxy Mastic 9100 is a two-component, high solids epoxy coating that provides a durable, abrasion and chemical resistant protective surface suitable for most all industrial environments. As Rust-Oleum's most versatile industrial product, it can be applied directly to sound rusted steel, galvanized metal, clean steel, concrete, and even slightly damp surfaces. This product was developed with the end user in mind. It has a convenient 1:1 mix ratio, a pot life of a minimum of two hours, and has multiple activator options, including: Fast Cure, Low Temp, Immersion, Satin Finish as well as the Standard activator. Can also be used as a primer under Rust-Oleum **ROC**Thane high performance topcoats. **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 is available in two VOC levels, 340 VOC and 250 VOC, depending on the activator you choose. (Note: Not use for immersion service in potable water tanks).

This coating complies with USDA FSIS regulatory sanitation performance standards for food establishment facilities. This coating is impervious to moisture and easily cleaned and sanitized.

Note: The Immersion Activator and the Fast-Cure Activator produce a semi-gloss finish. Also, using the Fast-Cure Activator may result with a slight color shift when compared with products using the Standard Activator.

This **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 can be used indoors or out. Epoxy coatings will yellow with age. This is most noticeable with interior applications of white or light colors which are not subjected to bleaching from sunlight. Exterior exposure over time will cause fading and chalking with all epoxy type coatings. These changes are cosmetic in nature only and film integrity and performance will not be adversely affected.

MPI #98 Certified. Refer to the MPI website for the most current listing of MPI certified products.

PRODUCT FEATURES AND BENEFITS

- Extremely Versatile, Easy to Use, Durable, Solvent-Based Epoxy
- Direct-To-Metal and Self-Priming on a Variety of Substrates, including concrete floors and walls
- Ultra-Smooth Finish with High Build Capability on Edges and Welds
- Superior Resistance to Solvents, Chemical, Abrasion and Impact
- Fast Cure Activator can be recoated in as little as 4 hours to minimize downtime
- Low Temperature Activator cures at temperatures as low as 40°F
- Five Year Rust-Proof Guarantee*

PRODUCTS

BASE COMPONENT

1 Gallon	5 Gallons	DESCRIPTION
9115402[2]	-----	Aluminum (Semi-Gloss)
9122402	-----	Marlin Blue

[2] The 9115 Aluminum is not recommended to be used in water immersion, as a floor finish, or as a prime coat for any finish other than itself.

PRODUCTS (cont.)

BASE COMPONENT (cont.)

9171402	9171300	Dunes Tan
9179402	-----	Black
9182402	9182300	Silver Gray
9186402	9186300	Navy Gray
9192402	9192300	White
9125402	-----	Safety Blue
9133402	-----	Safety Green
9144402	-----	Safety Yellow
204005	297081	Safety Orange
204006	-----	Safety Red

NOTE: Agriculture Canada accepted: 9101, 9115, 9145, 9165, 9171, 9179, 9186, and 9192.

TINT BASES

1 Gallon	5 Gallons	DESCRIPTION
9105405	-----	Red
9106405	-----	Yellow
9107405	-----	Masstone
9108421	9108381	Deep
9109408	-----	Light

TINTING

The 9100 System tint bases can be tinted with 844 Colorants. Tint should not be added to Activators.

TINT BASE MAXIMUM COLORANT PER 2 GALLON KIT

QUANTITY	TINT BASE DESCRIPTION
32 Oz.	Red
32 Oz.	Yellow
32 Oz.	Masstone
24 Oz.	Deep
16 Oz.	Light

ACTIVATOR

1 Gallon	5 Gallons	DESCRIPTION (340 VOC g/l)
9101402	9101300	Standard Gloss
9102402[3]	9102300[3]	Immersion Semi-Gloss
9104402[3]	A910008300[3]	Fast Cure Semi-Gloss

[3] Not for use with tint bases.

RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

PRODUCTS (cont.)

ACTIVATOR (cont.)

1 Gallon	5 Gallons	DESCRIPTION (250 VOC g/l)
205015	206232	Standard Gloss
214430[3]	-----	Immersion Semi-Gloss
9103402	-----	Low Temp Gloss
214432[3]	-----	Fast Cure Semi-Gloss
331254	-----	Standard Satin

[3] Not for use with tint bases.

COMPATIBLE PRODUCTS

RECOMMENDED PRIMER

ROCEpoxy Direct-to-Metal Epoxy Mastic 9100 is self-priming and can be used direct to metal or sound rust without a primer in mild to moderate environmental conditions. In severe environmental conditions, we recommend abrasive blasting per SSPC-SP6 and priming with **ROC**Epoxy High Solids Epoxy Primer HS9300 for additional corrosion protection.

NOTE: **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 may be used as a primer for Rust-Oleum High Performance topcoats. For best results, use the 331254 Satin Activator.

COMPATIBLE TOPCOATS[4]

ROCAcrylic Direct-to-Metal Acrylic Enamel 3800
ROCThane Fine Finish Urethane 9400
ROCThane Direct-To-Metal Urethane Mastic 9800

[4] Do not use any topcoat over 9115402 Aluminum. The 9115 Aluminum should only be topcoated with itself.

RUST PROOF GUARANTEE*

*Submitting the Five-Year Rust-Proof Guarantee form located on the **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 web page completely filled out, signed and with proof of purchase attached, no later than 30 days after project completion for projects using up to 50 gallons is required to qualify for the rust-proof guarantee. For projects larger than 50 gallons, please contact Rust-Oleum Technical Service Department at: Rust-Oleum Technical Service Department, 11 Hawthorn Pkwy, Vernon Hills, IL 60061, or email to: technicalservice@rustoleum.com

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt, and chemical contaminants by washing the surface with Krud Kutter® PRO Cleaner Degreaser. Mold and mildew must be cleaned with Krud Kutter PRO One Step Cleaner & Disinfectant. 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, scale, and deteriorated previous coatings to obtain a sound rusted surface. For optimum corrosion resistance, abrasive blast to commercial grade SSPCSP-6, with a blast profile of 1-2 mils (25-50 µ).

STEEL (IMMERSION): Abrasive blast clean to a minimum SSPC-SP-10 Near-White Grade (NACE 2) and achieve a surface profile of 1.5-3 mils. All weld spatter must be removed along weld seams, rough welds should be ground smooth, and all sharp edges should be ground to a smooth radius.

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. The **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 is compatible with most coatings, but a test patch is suggested.

WARNING! If you scrape, sand, or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a NIOSH-Approved respirator to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead.

GALVANIZED METAL: Remove oil, dirt, grease, and other chemical deposits with Krud Kutter PRO 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.

ALUMINUM: Power tool cleaning (SSPC-SP-11) to produce bare metal surface and achieve a minimum of 1.0 mil surface profile. 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.

CONCRETE FLOORS: Remove laitance and create a surface profile by either acid etching with Rust-Oleum 108402 Cleaning and Etch Solution, or by grinding. If etching, consult with 108 Clean & Etch Solution Technical Data Sheet for complete application instructions. Rinse thoroughly and allow to dry. The concrete must be fully dry prior to coating application. After etching, the concrete should have a texture, which resembles fine grit sandpaper. Repeat the process if necessary. Surface sealers and curing agents must be removed by grinding. Vacuum to remove fine dust and debris. The floor should be dry and dust free prior to application. Previously coated floors need to be in good condition with proper adhesion to the concrete substrate.

MIXING

Both the base and activator components are highly pigmented. Mix each component thoroughly to ensure any settled pigment is re-dispersed before combining the components together. Combine at a 1:1 ratio by volume in a container large enough to hold the total volume. Mix thoroughly for 2-3 minutes. Power mixing is preferred. Do not mix more material than you plan to use within the listed pot life.

APPLICATION

Airless spray is the preferred method of application. However, brush, roller, or air-atomized spray may also be used. Refer to table for thinning recommendations. For proper performance, a dry film thickness of 5-8 mils per coat is required. Excessive brushing or rolling may reduce film thickness. Apply a second coat if necessary to achieve the recommended film thickness.

RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

PRODUCT APPLICATION (cont.)

APPLICATION (cont.)

Use the **Standard Activator or Fast Cure Activator** at air temperatures between **50-120°F (10-49°C)** and when the surface temperature is at least 5°F (3°C) above the dew point and less than 120ºF (49ºC). Low curing temperatures and/or condensation on the film while curing can affect appearance in the form of an amine blush. This can generally be removed with soap and water; however, in a case of extreme blushing, the performance of the coating may be slightly affected.

NOTE: The Fast Cure Activator may also be used in water immersion. Allow 7 days for full cure prior to beginning immersion service.

Use the **Low Temperature Activator**. when application temperatures are between **40-60°F (5-15°C)** and when the surface temperature is at least 5°F (3°C) above the dew point, do not apply the material if the temperature is expected to fall below 40°F in the first 24 hours of cure. At 40°F, full cure will be achieved in 7 days.

Use the **Immersion Activator** for water immersion service at air and surface temperatures between **60-100°F (15- 38°C).** Apply when the surface temperature is at least 5°F (3°C) above the dew point, and when relative humidity is below 85%. Do not use the Immersion Activator with tint bases. This system may be used for both salt and fresh water; do not use for the inside of potable water tanks. Apply two coats alternating color between coats to ensure complete hide. Allow 7 days cure after application of the second coat before immersion.

NOTE: Do not use tinted colors in water immersion.

POOLS: When used with Immersion Activator, **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 premix bases can be used as a pool coating over existing epoxy pool coatings, new bare concrete, plaster, Gunite, and fiberglass. The pool must be completely empty and dry before coating. After pool is emptied, this typically requires 7-10 days depending on temperature and humidity. To test the dryness of concrete, Gunite or plaster pool surfaces, securely tape a 2 ft. by 2 ft. piece of clear plastic onto a horizontal and vertical surface at the deep end of the pool. Check after 24 hours. If water condensation is visible under the plastic, this is an indication that the surface is not completely dry, and NOT suitable for coating.

Allow additional dry time and retest. Follow surface preparation, mixing and application instructions. Avoid painting in midday sun. Application is recommended early in the day or late in the afternoon when at least 2 hours of sunlight remain after completion of the job.

Allow minimum of 5-7 sunny days cure before filling pool. Early contact with water can cause premature fading, chalking, and blistering. Super chlorinated water can cause a bleached-out appearance. Sunlight and UV will cause chalking and fading. **Do not** use over: 1) chlorinated rubber, 2) synthetic rubber, 3) vinyl, 4) acrylic.

NOTE: In swimming pool service, early chalking may occur if the water pH is outside the range of 7.2-7.6 and/or if the water temperature exceeds 100°F (38°C). Not recommended for use in hot tubs.

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable.)
BRUSH: Use a good quality natural or synthetic bristle brush.
ROLLER: Use a good quality roller cover (3/8- 1/2"nap).

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	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

CAUTION: Protect surrounding surfaces from over spray. Over spray can be wet or dry depending on height of work, weather, environmental conditions, and application equipment. Wet over spray can adhere to unwanted surfaces. Dry over spray may be removed by wiping or washing. Always clean dry over spray from hot surfaces before fusing occurs as surface temperatures can be higher than the air temperature.

THINNING

Thinning is normally not required, except for air-atomized spray. For air-atomized spray application, thin only up to 10% by volume with 160402 Thinner after the components have been mixed. If the coating is going to be used in immersion service, 9102 or 9104 activator, then, use up to 10% 165402 Thinner for air-atomized spray and up to 5% of 165402 Thinner for airless spray.

NOTE: Addition of more than 10% of 160402 or 165402 Thinner will cause VOC to exceed 340 g/l. In this case, 333402 VOC exempt thinner can be used if needed.

NOTE: When using the Satin Activator, thin only with 333402 Thinner to maintain the VOC <250 g/l.

CLEAN-UP

Use 160402 or 165402 Thinner.

SHELF LIFE

Base components: 3 years[5], Activators: 3 years Standard, Fast Cure and Immersion Activators, 2 years Low Temp and Satin Finish Activators[5]

[5] Unopened containers. Some settling may occur requiring mechanical mixing to redisperse pigment.

CAUTION: Exposure of the **ROC**Epoxy Direct-To-Metal Epoxy Mastic 9100 during the curing stage of the coating to the by-products of propane combustion may cause discoloration to occur. During application and curing, propane fueled fork-lifts and other vehicles, or propane fueled heaters should not be used in the area until the coating is fully cured. At least 72 hours.

RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

PERFORMANCE CHARACTERISTICS

SYSTEM TESTED
ROCEpoxy Direct-To-Metal Epoxy Mastic 9100 with 9101 Standard Activator

PENCIL HARDNESS
METHOD: ASTM D3363
RESULT: B (7 days), 4H (30 days)

CONICAL FLEXIBILITY
METHOD: ASTM D522
RESULT: >32%

CYCLIC PROHESION
Rating 1-10, 10=best
METHOD: ASTM D5894, 2300 hours
RESULT: 10 ASTM D714 for blistering
RESULT: 10 ASTM D1654 for corrosion

IMPACT RESISTANCE (direct)
METHOD: ASTM D2794
RESULT:160 in. lbs.

ALKALI RESISTANCE
METHOD: ASTM D1308
RESULT: No effect

ADHESION BY TAPE TEST
METHOD: ASTM D3359B
SUBSTRATE and RESULT: Cold rolled steel (dry)-5B

TABER ABRASION
METHOD: ASTM D4060, CS-17 wheels, 500 gram load, 1000 cycles
RESULT: 125 mg loss

GLOSS
METHOD: ASTM D4587
RESULT: 80%

RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

PHYSICAL PROPERTIES

		9101 Standard Activator		9102 Immersion Activator		9103 Low Temp. Activator	9104 Fast-Cure Activator.	
Resin Type		Aliphatic Amine Converted Epoxy		Polyamide Converted Epoxy		Aliphatic Amine Converted Epoxy	Polyamide/modified Amine Converted Epoxy	
Inhibitive Pigment		Calcium Borosilicate		Calcium Borosilicate		Calcium Borosilicate	Calcium Borosilicate	
Solvents		Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol		Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol		Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol	Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol	
Weight[6]	**Per Gallon**	11.4-12.6 lbs.		11.4-12.6 lbs.		9.3-10.4 lbs.	12.0-13.0 lbs.	
	Per Liter	1.4-1.5 kg		1.4-1.5 kg		1.1-1.2 kg	1.4-1.6 kg	
Solids[6]	**By Weight**	86-89%		79-82%		78-81%	81-83%	
	By Volume	78-81%		65-68%		72-75%	67-69%	
Volatile Organic Compounds[6]		<340 g/l (2.84 lbs./gal.)		<340 g/l (2.84 lbs./gal.)		<250 g/l (2.08 lbs./gal.)	<340 g/l (2.84 lbs./gal.)	
Mixing Ratio		1:1 Base:Act.(by vol.)		1:1 Base:Act.(by vol.)		1:1 Base:Act.(by vol.)	1:1 Base:Act.(by vol.)	
Recommended Dry Film Thickness (DFT) Per Coat		5-8 mils (125-200µ)		5-8 mils (125-200µ)		5-8 mils (125-200µ)	5-8 mils (125-200µ)	
Wet Film to Achieve DFT (unthinned material)		6.5-10.5 mils (162.5-262.5µ)		7.5-12.0 mils (187.5-300µ)		7.0-11.0 mils (175-275µ)	7.5-12.0 mils (187.5-300.0µ)	
Theoretical Coverage at 1 mil DFT (25µ)		1,250-1,300 sq.ft./gal. (30.8-32.0 m^2/l)		1,045-1,090 sq.ft./gal. (25.7-26.8 m^2/l)		1,155-1,200 sq.ft./gal. (28.4-29.5 m^2/l)	1,075-1,100 sq.ft./gal. (26.4-27.3 m^2/l)	
Practical Coverage at Recommended DFT (assumes 15% material loss)		125-225 sq.ft./gal. (3.1-5.5 m^2/l)		100-175 sq.ft./gal. (2.5-4.3 m^2/l)		125-200 sq.ft./gal. (3.1-5.0 m^2/l)	115-190 sq.ft./gal. (2.8-4.7 m^2/l)	
Induction Period		None required		30 minutes (60 min. < 65°F)		None required	15 minutes	
Pot Life[7]	**2 gallons**	2-4 hours at 70°F (21°C),	1-2 hours at 90°F (32°C)	2-4 hours at 70°F (21°C)	3-5 hours at 60°F (15°C)	2-4 hours at 60°F (15°C)	2-4 hours at 70°F (21°C)	1-2 hours at 90°F (32°C)
	10 gallons	2 hours at 70°F (21°C)	<1 hour at 90°F (32°C)	2 hours at 70°F (21°C)	3 hours at 60°F (15°C)	2 hours at 60°F (15°C)	2 hours at 70°F (21°C)	<1 hour at 90°F (32°C)
Dry Times at 50% Relative Humidity	**Tack-free**	6-8 hours at 70°F (21°C)	12-24 hours at 50°F (10°C)	6-8 hours at 70°F (21°C)		16-20 hours at 40°F (5°C)	4 hours at 70°F (21°C)	8 hours at 50°F (10°C)
	Handle	6-12 hours at 70°F (21°C)	48-72 hours at 50°F (10°C)	8-14 hours at 70°F (21°C)		22-26 hours at 40°F (5°C)	5 hours at 70°F (21°C)	10 hours at 50°F (10°C)
	Recoat	16 hours to 1 year[8] 70°F (21°C)	72 hours to 1 year[8] 50°F (10°C)	16 hours to 1 year[8] 70°F (21°C)		24 hours to 1 year[8]	4 hours to 1 year[8] 70°F (21°C)	8 hours to 1 year[8] 50°F (10°C)
Dry Heat Resistance		300°F (149°C), Color may shift above 150°F (66°C)		300°F (149°C), Color may shift above 150°F (66°C)		300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)	
Maximum Immersion Temperature		NA		120°F (49°C)		NA	NA	
Shelf Life		Unopened containers; Base components: 3 years, Activator components: 3 years Standard, Fast Cure and Immersion Activators, 2 years Low Temp and Satin Finish Activators						
Safety Information		See SDS						

[6] Activated material.

[7] Pot life is affected by air temperature, amount of material activated and quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour). Final gloss may be slightly higher for coating applied near the end of the pot life.

[8] If recoat time is extended, be sure the surface is clean and free of all contamination prior to coating. Actual environmental conditions may affect results, so a trial is suggested to ensure acceptable results.

RUST-OLEUM® HIGH PERFORMANCE

ROCEPOXY DIRECT TO METAL EPOXY MASTIC 9100

PHYSICAL PROPERTIES

		205015 Standard Activator	214430 Immersion Activator	214432 Fast-Cure Activator	331254 Satin Finish Activator
Resin Type		Aliphatic Amine converted Epoxy	Polyamide converted Epoxy	Polyamide/modified Amine converted Epoxy	Polyamide/modified Amine converted Epoxy
Inhibitive Pigment		Calcium Borosilicate	Calcium Borosilicate	Calcium Borosilicate	Calcium Borosilicate
Solvents		Aromatic Hydrocarbons, Ketones and Alcohols	Aromatic Hydrocarbons, Ketones and Alcohols	Aromatic Hydrocarbons, Ketones and Alcohols	Aromatic Hydrocarbons, Ketones and Alcohols
Weight[6]	**Per Gallon**	11.4-12.4 lbs.	11.4-12.6 lbs.	12.1-13.2 lbs.	10.54-11.66 lbs.
	Per Liter	1.4-1.5 kg	1.4-1.5 kg	1.4-1.5 kg	1.27-.1.40 kg
Solids[6]	**By Weight**	86.4-88.4%	79.3-81.8%	81.3-83.5%	80.64-83.70%
	By Volume	77.8-80.4%	67.0-68.5%	68.3-69.8%	71.32-74.49%
Volatile Organic Compounds[6]		<250 g/l (2.08 lbs./gal.)	<250 g/l (2.08 lbs./gal.)	<250 g/l (2.08 lbs./gal.)	<250 g/l (2.08 lbs./gal.)
Mixing Ratio		1:1 Base:Act. (by vol.)	1:1 Base:Act. (by vol.)	1:1 Base:Act. (by vol.)	1:1 Base:Act. (by vol.)
Recommended Dry Film Thickness (DFT) Per Coat		5-8 mils (125-200µ)	5-8 mils (125-200µ)	5-8 mils (125-200µ)	5-8 mils (125-200µ)
Wet Film to Achieve DFT (unthinned material)		6.5-10.0 mils (162.5-250µ)	7.5-12.0mils (187.5-300µ)	7.5-12.0 mils (187.5-300µ)	7-11 mils (175-275µ)
Theoretical Coverage at 1 mil DFT (25µ)		1,250-1,290 sq.ft./gal. (30.7-31.7 m^2/l)	1,075-1,100 sq.ft./gal. (26.4-27.0 m^2/l)	1,095-1,120 sq.ft./gal. (26.9-27.6 m^2/l)	1,145-1,195 sq.ft./gal. (28.2-29.4 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		130-220 sq.ft./gal. (3.2-5.4 m^2/l)	115-190 sq.ft./gal. (2.8-4.6 m^2/l)	115-190 sq.ft./gal. (2.8-4.6 m^2/l)	120-200 sq.ft./gal. (3.0-4.9 m^2/l)
Induction Period		None required	30 minutes (60 min. < 65°F)	15 minutes	None required
Pot Life[7]	**2 gallons**	2.5-3 hours at 75°F (24°C)	2-4 hours at 70°F (21°C) / 3-5 hours at 60°F (15°C)	2-4 hours at 70°F (15°C) / 1-2 hours at 90°F (32°C)	2-4 hours at 70°F (21°C)
	10 gallons	2-3 hours at 75°F (24°C)	2 hours at 75°F (24°C) / 3 hours at 60°F (15°C)	2 hours at 70°F (21°C) / <1 hour at 90°F (32°C)	2-3 hours at 75°F (24°C)
Dry Times at 50% Relative Humidity	**Tack-free**	6-8 hours at 70°F (21°C)	6-8 hours at 70°F (21°C) / 8 hours at 50°F (10°C)	4 hours at 70°F (21°C)	6-8 hours at 70°F (21°C)
	Handle	6-12 hours at 70°F (21°C)	8-14 hours at 70°F (21°C) / 10 hours at 50°F (10°C)	5 hours at 70°F (21°C)	6-12 hours at 70°F (21°C)
	Recoat	16 hours to 30 days[8] at 70°F (21°C)	16-72 hours[8] at 70°F (21°C) / 24-72 hours[8] at 50°F (10°C)	4 hours to 30 days[8] at 70°F (21°C)	16-72 hours[8] at 70°F (21°C)
Dry Heat Resistance		300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)
Maximum Immersion Temperature		NA	120°F (49°C)	NA	NA
Safety Information		See SDS			

[6] Activated material.

[7] Pot life is affected by air temperature, amount of material activated and quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour). Final gloss may be slightly higher for coating applied near the end of the pot life.

[8] If recoat time is extended, be sure the surface is clean and free of all contamination prior to coating. Actual environmental conditions may affect results, so a trial is suggested to ensure acceptable results.