

RUST-OLEUM®

HIGH PERFORMANCE

**ROCPRIME® WATER-BASED
HYBRID 1K EPOXY PRIMER****DESCRIPTION AND USES**

ROCPRIME® Water-Based Hybrid 1K Epoxy Primer is a high-performance, universal primer for interior or exterior applications in mild to moderate environments. **ROCPRIME** accepts all Rust-Oleum High Performance topcoats, and is designed to deliver two-component performance in a single component. This product provides excellent adhesion to almost any substrate including steel, stainless steel, galvanized steel, aluminum, concrete, wood, glass, previously coated, and more. A test patch is recommended for, Kynar®, fiberglass, plastics, and copper.

PRODUCT FEATURES AND BENEFITS

- Single Component, Water-Based Formula
- Universal Primer for All Rust-Oleum High Performance Topcoats
- Excellent Adhesion on Multiple Substrates
- Excellent Adhesion ensures strong protection
- Can be applied in temperatures as low as 40°F
- Low Odor and Low VOC
- Two-Year Rust-Proof Guarantee*

PRODUCTS

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

RECOMMENDED TOPCOATS

ROCAcrylic Direct-to-Metal Acrylic Enamel 3800
ROAlkyd Direct-To-Metal Alkyd Enamel 7400 & V7400
ROEpoxy Direct-To-Metal Epoxy Mastic 9100
ROCThane Direct-To-Metal Urethane Mastic 9800
 Modern Masters® Colorfast EX
 Sierra Performance MetalMax® DTM Acrylic Enamel
 Sierra Performance Beyond™ Acrylic Enamel
 Sierra Performance S60 Epoxy Maintenance Coating
 CV740 System 100 VOC DTM Alkyd Enamel

NOTE: **ROCPRIME** may be used with any Rust-Oleum Roof Coating, including silicone topcoats.

RUST PROOF GUARANTEE*

*Submitting the Two-Year Rust-Proof Guarantee form located on the **ROCPRIME** Water-Based Hybrid 1K Epoxy Primer 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 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.

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. **ROCPRIME** Water-Based Hybrid 1K Epoxy Primer 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. 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.

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PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

BRUSH/ROLLER: Use a good quality 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

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

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 Professional Solutions Xylene Solvent Blend or Krud Kutter PRO 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 **ROC**Acrylic DTM

Acrylic Enamel 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-210
		ROCPRIME® WATER-BASED HYBRID 1K EPOXY PRIMER

PHYSICAL PROPERTIES

		ROCPRIME WATER BASED HYBRID 1K EPOXY PRIMER
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

Calculated values are shown and may vary slightly from the actual manufactured material.

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.



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