

**RUST-OLEUM®**  
— INDUSTRIAL —



## 6400 SHOPPRIMER



# Metal protection for storage, transportation and more

- Excellent adhesion to metal
- Ideal for spray application
- Recoatable with CombiColor® and many other coating systems
- Masks construction deficiencies
- Not toxic

**KNOW-HOW TO PROTECT™**

**WWW.RUST-OLEUM.EU**

# 6400 SHOPPRIMER

## DESCRIPTION

Fast Drying Shop Primers 6400 are fast drying primers based on a soya oil alkyd. The products contain rust-inhibitive pigments and are lead- and chromate free.

## RECOMMENDED USE

RUST-OLEUM Shop Primers 6400 should be applied on cold-rolled, blasted, pickled or slightly rusted steel. RUST-OLEUM Shop Primers 6400 are primarily intended for spray application and may also be applied by brush or roller for touch up or small areas only. RUST-OLEUM Shop Primers 6400 can be recoated with the RUST-OLEUM Alkyd Primer/Intermediate and the Alkythane 7500 System Topcoat assuring the appropriate protection at light industrial exposures.

## TECHNICAL DATA

Density: 1,25 ± 0.5  
Gloss Level: Matt  
Solids content in volume: 42 - 44%  
Heat Resistance: 120°C (dry heat)

## DRYING TIMES AT 20°C/RH 50%

Touch dry: 1 hour (20°C), 2 hours (10°C), ½ hour (30°C)  
Dry to handle: 2 hours (20°C), 4 hours (10°C), 1 hour (30°C)  
Dry to recoat: 24 hours (20°C), 36 hours (10°C), 24 hours (30°C)  
Fully cured: 7 days (20°C), 14 days (10°C), 5 days (30°C)

## RECOMMENDED WET FILM THICKNESS

85 µm

## RECOMMENDED DRY FILM THICKNESS

35 µm

## THEORETICAL CONSUMPTION

12 m<sup>2</sup>/l at 35 µm dry

## PRACTICAL CONSUMPTION

Practical coverage depends on many factors such as porosity and roughness of the substrate and material losses during application.

## SURFACE PREPARATION

Remove grease, oil and all other surface contaminations by alkaline or high pressure (steam) cleaning in combination with appropriate detergents. For optimum results remove rust, rust scale, mill scale by abrasive blasting to Sa 2½ (ISO 8501-1: 1988), blast profile max. 50 µm, or by pickling. Remove loose and deteriorated coatings by scraping and wire brushing or sweep blasting. The surface must be clean and dry during application.

## DIRECTIONS FOR USE

To ensure homogeneity, coating materials should be thoroughly stirred prior to use.

## APPLICATION CONDITIONS

Temperature of air, substrate and coating material between 5 and 35°C and relative humidity below 85%. The substrate temperature must be at least 3°C above dew point.

## APPLICATION & THINNING: BRUSH

Use natural bristles, long hair brushes.

## APPLICATION & THINNING: ROLLER

Use medium nap, 8-12 mm. Rollers. Roller application may require 2 coats to achieve recommended dry film thickness.

## APPLICATION & THINNING: AIRLESS SPRAY

If required up to 5% volume RUST-OLEUM Thinner 150. Pneumatic and electric airless equipment. Tip size: 0.013-0.015 inch / Fluid pressure: 130 - 200 bar.

## APPLICATION & THINNING: AIR-ATOMISED SPRAY

Up to 10% volume RUST-OLEUM Thinner 150. Gravity cup and pressure cup. Tip size: 1.2 - 1.8 mm / Atomizing pressure: 2 - 4 bar.

## CLEANING OF EQUIPMENT / SPILLS

Use RUST-OLEUM Thinner 160 or aromatic hydrocarbons.

## REMARKS

Maximum dry film thickness per coat: 60 µm dry, equals 160 µm wet.

## SAFETY DATA

VOC level: 463 g/l  
VOC ready mix: 499 g/l  
VOC category: A/i  
VOC limit: 500 g/l  
Grenelle: A+  
Remarks regarding safety: Consult Safety Data Sheet and Safety Information printed on the can.

## SHELF LIFE

5 years from date of production in unopened cans, if stored in dry, well ventilated areas, not in direct sunlight at temperatures between 5° and 35°C.

Date issued: 05/12/2018

**Available colours & pack sizes :** Please refer to the respective product page on [www.rust-oleum.eu](http://www.rust-oleum.eu) for an overview of actual available colours and pack sizes.

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