

**RUST-OLEUM®****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 Pure Strength® Cleaner/Degreaser item #3599402, 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 Pure Strength 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



**PHYSICAL PROPERTIES**

		<b>ROC PRIME 100</b>
<b>Resin Type</b>		Water-based Epoxy Amine Adduct
<b>Pigment Type</b>		Varies with color
<b>Solvents</b>		Water
<b>Weight</b>	<b>Per Gallon</b>	10.45-10.47 lbs.
	<b>Per Liter</b>	1.25 kg
<b>Solids</b>	<b>By Weight</b>	52.2-52.4%
	<b>By Volume</b>	39.9-40.2%
<b>Volatile Organic Compounds</b>		<100 g/l (0.83 lbs./gal.)
<b>Recommended Dry Film Thickness (DFT) per Coat</b>		1.5-2.5 mils (37.5-62.5µ)
<b>Wet Film to Achieve DFT (unthinned material)</b>		4.0-7.0 mils (100-175µ)
<b>Theoretical Coverage at 1 mil DFT (25µ)</b>		650 sq.ft./gal. (16 m <sup>2</sup> /l)
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		225-375 sq.ft./gal. (5.5-9.2 m <sup>2</sup> /l)
<b>Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity</b>	<b>Touch</b>	1-2 hours
	<b>Handle</b>	2-4 hours
	<b>Recoat</b>	1-3 hours
<b>Dry Heat Resistance</b>		200°F (93°C)
<b>Shelf Life</b>		2 years
<b>Warning!</b>		<b>PROTECT FROM FREEZING</b>
<b>Safety Information</b>		For additional information, see SDS

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