



**6400 SYSTEM
450 VOC ALKYD ENAMEL**

DESCRIPTION AND USES

A multi-purpose oil modified alkyd enamel designed for indoor and outdoor applications. Use on properly primed surfaces where a high gloss finish is desired. Excellent resistance to general weathering, salt air, mild chemical fumes and light abrasion.

PRODUCTS

HIGH GLOSS FINISHES

1-Gallon	5-Gallon	Description
206283	206284	Glossy Black
206285	206286	Glossy White
206287	—	Banner Red
206288	—	Machine Green
206301	—	Safety Blue
206303	—	Safety Yellow
206304	—	Safety Red
206300	—	Universal Gray
206302	—	Aluminum
207834	—	Dove Gray
207835	—	Hunter Green
207836	—	Safety Orange
207837	—	True Blue
207838	—	Ultra-Flat Black
207839	—	Beige
207840	—	John Deere Green
207841	—	New Caterpillar Yellow
207842	—	Old Caterpillar Yellow
208120	—	Forest Green
208118	—	Silver Gray

TINT BASES

1-Gallon	5-Gallon	Description
206169	212691	Masstone
206280	212692	Deep Base
206281	212693	Light Base

COMPANION PRODUCT

206282	Gray Primer
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PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: If excessive time has elapsed since the primer was applied, 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: Apply to a properly primed or previously painted surface. See primer labels and technical data sheet for correct surface preparation and application procedures.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding to create a surface profile. The Industrial Choice Alkyd Enamel Finish is compatible with most coatings, but a test patch is suggested. Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause adverse effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH-approved) and proper containment and cleanup. For additional information, contact the U.S.EPA/Lead Information Hotline at 1-800-424-LEAD.

APPLICATION

Apply to properly primed or previously painted surfaces. See primer labels and Technical Data Sheet for correct surface preparation and application procedures. Apply only when air and surface temperatures are between 32°-100°F (0°-38°C) and surface temperature is at least 5°F (3°C) above the dew point.

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

BRUSH: Use a good quality natural or synthetic bristle brush.

ROLLER: Use a good quality natural or synthetic cover. Use a short nap roller for smooth surfaces, and a medium nap roller for rough surfaces.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atom. Pressure
Pressure	0.055-.070	16 oz./min.	25-60 psi
Siphon	0.055-.070	—	25-60 psi
HVLP (var.)	0.043-.070	8-14 oz./min.	60-90 psi**

** (10 psi maximum at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1600-2400 psi	0.013-.017	100

THINNING

BRUSH/ROLLER: Normally not required.

AIR-ATOMIZED SPRAY: 333402 Thinner—Use up to 15% by volume.

AIRLESS SPRAY: 333402 Thinner normally not required. If needed, use up to 5% by volume.

CLEAN-UP

633402 Thinner or mineral spirits.

PERFORMANCE CHARACTERISTICS

CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >33% GLOSS At 60°F

METHOD: ASTM D523

RESULT: 86 (color-white)

ACCELERATED WEATHERING (% gloss retention)

METHOD: ASTM D4587, QUV Type A bulb, 450 Hours

RESULT: 81% retention (color-white)

TABER ABRASION

METHOD: ASTM D4060 500 g. load 1000 cycles

RESULT: 84 mg. loss

CYCLIC PROHESION

Rating 1-10, 10=best

METHOD: ASTM D5894, 3 cycles, 1008 hours

RESULT: Rating 10 per ASTM D714 for blistering

RESULT: Rating 9 per ASTM D610 for rusting

For chemical and corrosion resistance see page 4 of the Rust-Oleum Industrial Brands Catalog Form #206275.

PHYSICAL PROPERTIES

		ALKYD ENAMELS
Resin Type		Oil modified alkyd
Pigment Type		Varies with color, Calcium Carbonate
Solvents		Aliphatic Hydrocarbons
Weight*	Per Gallon	7.6-9.3 lbs.
	Per Liter	0.9-1.1 kg.
Solids*	By Weight	51-60%
	By Volume	42-43%
Volatile Organic Compounds*		< 450 g/l (3.75 lbs./gal.) for all colors except Aluminum • < 500 g/l (4.20 lbs./gal.) for Aluminum
Recommended Dry Film Thickness (DFT) Per Coat		1.0-2.0 mils (25.0-50.0 μ)
Wet Film to Achieve DFT (unthinned material)		2.5-4.5 mils (62.5-112.5 μ)
Theoretical Coverage at 1 mil DFT (25μ)		670-690 sq. ft./gal. (16.5-17.0 m ² /l.)
Practical Coverage at Recommended DFT (assumes 15% material loss)		285-585 sq. ft./gal. (7.0-14.4 m ² /l.)
Dry Times at 70°-80°F (21°-27°C) and 50% rel. humidity	Tack-free	2-4 hours
	Handle	5-9 hours
	Recoat	24-48 hours
Dry Heat Resistance		212°F (100°C)
Shelf Life		5 years
Specifications and Performance Alternatives		Can be used in USDA-regulated facilities based on FSIS Directive 11,000.4 (Rev.4), November 24, 1995
Safety Information	Flash Point	104°F (40°C)
	Contains	Lead-free
	Warning!	COMBUSTIBLE LIQUID AND VAPOR. HARMFUL IF INHALED. MAY AFFECT BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. CAUSES RESPIRATORY TRACT, EYE AND SKIN IRRITATION. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN. SEE THE PRODUCT MATERIAL SAFETY DATA SHEET (MSDS) AND LABEL WARNINGS FOR ADDITIONAL SAFETY INFORMATION.

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

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