

**INDUSTRIAL  
— CHOICE —**

BY RUST-OLEUM®

## 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**

		<b>ALKYD ENAMELS</b>
<b>Resin Type</b>		Oil modified alkyd
<b>Pigment Type</b>		Varies with color, Calcium Carbonate
<b>Solvents</b>		Aliphatic Hydrocarbons
<b>Weight*</b>	<b>Per Gallon</b>	7.6-9.3 lbs.
	<b>Per Liter</b>	0.9-1.1 kg.
<b>Solids*</b>	<b>By Weight</b>	51-60%
	<b>By Volume</b>	42-43%
<b>Volatile Organic Compounds*</b>		< 450 g/l (3.75 lbs./gal.) for all colors except Aluminum • < 500 g/l (4.20 lbs./gal.) for Aluminum
<b>Recommended Dry Film Thickness (DFT) Per Coat</b>		1.0-2.0 mils (25.0-50.0 $\mu$ )
<b>Wet Film to Achieve DFT (unthinned material)</b>		2.5-4.5 mils (62.5-112.5 $\mu$ )
<b>Theoretical Coverage at 1 mil DFT (25<math>\mu</math>)</b>		670-690 sq. ft./gal. (16.5-17.0 m <sup>2</sup> /l.)
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		285-585 sq. ft./gal. (7.0-14.4 m <sup>2</sup> /l.)
<b>Dry Times at 70°-80°F (21°-27°C) and 50% rel. humidity</b>	<b>Tack-free</b>	2-4 hours
	<b>Handle</b>	5-9 hours
	<b>Recoat</b>	24-48 hours
<b>Dry Heat Resistance</b>		212°F (100°C)
<b>Shelf Life</b>		5 years
<b>Specifications and Performance Alternatives</b>		Can be used in USDA-regulated facilities based on FSIS Directive 11,000.4 (Rev.4), November 24,1995
<b>Safety Information</b>	<b>Flash Point</b>	104°F (40°C)
	<b>Contains</b>	Lead-free
	<b>Warning!</b>	<b>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.</b>

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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