

**RUST-OLEUM®**  
INDUSTRIAL



## 9180 EPOXY METAL PRIMER

# High build anti-corrosion primer for metal

- High build primer for optimal opacity with topcoat 9100
- Touch dry after just 1 hour
- Contains a high amount of rust inhibitors
- Easy to apply by brush, roller or spray
- Easy 1:1 mixing ratio



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# 9180 EPOXY METAL PRIMER

## DESCRIPTION

High build metal primer based on two-component epoxy resins offer extra protection against corrosion on bare or blasted metal.

## RECOMMENDED USE

Red Primer 9170 and Grey Primer 9180 should be used on bare steel, on blasted steel and properly prepared galvanized substrates or as an intermediate coat. 9170/80 Primers can be recoated with 9100 Topcoats assuring the appropriate protection against corrosion, strong chemicals, acids, alkalis and solvents; frequent product spillage and frequent chemical cleaning; high humidity and moist conditions.

If good U.V. resistance is required Rust-O-Thane® Polyurethane Topcoat 9600 should be applied.

## TECHNICAL DATA

Density (g/cm <sup>3</sup> ):	1,5
Gloss Level:	Matt
Corrosion Class:	C4 high protection
Solids content in volume:	52%
Heat Resistance:	150°C (dry heat)
Mixing Ratio:	1 : 1 by volume

## DRY TIMES BY 20° C/RH 50%

Touch dry:	1 hour
Dry to handle:	2 hours
Dry to recoat:	After 16 hours
Fully cured:	8 days
Pot Life:	8 hours for a 5 ltr. mix at 20°C
Induction Time:	30 minutes

## RECOMMENDED WET FILM THICKNESS

150 µm

## RECOMMENDED DRY FILM THICKNESS

75 µm

## THEORETICAL CONSUMPTION

7 m<sup>2</sup>/l

## 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 and deteriorated coatings by abrasive blasting to Sa 2½ (ISO 8501-01 : 1988), blast profile max. 50 µm. Salts, "white rust" (on galvanised steel), etc. should be removed by washing with Surf-a-Etch 108 Etching Solution or by sweep blasting. Sand previous coatings, which are in good condition to remove gloss and to roughen the surface slightly, check compatibility. From surfaces to be submerged all previous coatings should be removed by abrasive blasting to Sa 3 (ISO 8501-1 : 1988), blast profile max. 50µm. New concrete should cure and dry for at least 30 days prior to application of the coating. The surface must be clean and dry during application.

## DIRECTIONS FOR USE

Stir individual components thoroughly before mixing them together. Use the boxing method or a low speed mixer. Stir individual components, 9170/9180 Base and 9103 Activator, thoroughly. Add 9103 Activator to base-material. Mix well; scrape material from sides and bottom of the can, until material assumes a uniform appearance. Pour mixture back into base material can and repeat previous action. In case of manual mixing use the boxing method.

## APPLICATION CONDITIONS

Temperature of air and substrate 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

Dilute up to 10% volume RUST-OLEUM Thinner 160.

Use natural bristles, long hair brushes. Touch-up or small areas only. Preferably use disposable brushes.

## APPLICATION & THINNING: ROLLER

Dilute up to 10% volume RUST-OLEUM Thinner 160.

Use short/medium nap polyamide 8 mm rollers. Preferably use disposable rollers.

Roller application may require 2 coats to achieve recommended d.f.t.

## APPLICATION & THINNING: AIRLESS SPRAY

5-15% volume RUST-OLEUM Thinner 160.

Pneumatic and electric airless equipment. Tip size: 0.013-0.018 inch. Fluid pressure: 150 - 250 bar.

## APPLICATION & THINNING: AIR-ATOMISED SPRAY

Up to 20% volume RUST-OLEUM Thinner 160.

Spray: Gravity cup and pressure cup. Tip size: 1.2 -2.2 mm. Atomising pressure: 2 - 4 bar.

## CLEANING OF EQUIPMENT / SPILLS

Use RUST-OLEUM Thinner 160.

## REMARKS

Maximum dry film thickness per coat: 125 µm dry, equals 250 µm wet.

## SAFETY DATA

VOC level:	421 g/l
VOC readymix:	499 g/l
VOC category:	A/j
VOC limit:	500 g/l
Remarks regarding safety:	Consult Safety Data Sheet and Safety Information printed on the can.

## SHELF LIFE

Minimum of 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: 20/03/2025

**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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