



Rustlok 6980
Rust Repair and Prevention

TECHNICAL BULLETIN 440 5/06

- Dries rapidly allowing multiple coats in one day.
- Wets, seals and adheres to firmly attached rust.
- May be applied at temperatures down to 10°F.
- Exceptional adhesion to all ferrous metals also including steel, cast iron, galvanized and stainless steel.



Pettit 6980 Rustlok is a one package moisture cured polyurethane coating designed for application over any steel or cast iron surface, including galvanized and stainless steel. Rustlok Steel Primer contains aluminum flake pigment which forms a dense, water impervious barrier. The result is excellent corrosion protection. In addition, Rustloks polyurethane chemistry offers tremendous adhesive strength and wetting ability. It is this combination that allows Rustlok to perform well even when applied over rusted surfaces. Rustlok is recommended anytime an easy to apply, effective anti-corrosive barrier coat is desired.

Physical Data	Application Data	Associated Products
VEHICLE TYPE.... Moisture Cured Polyurethane FINISH.....Matte COLOR.....Aluminum Metallic COMPONENTS.....One CURING MECHNISM..... Chemical Cure SOLIDS (theoretical) By weight.....56.4 ± 2% By volume.....43.3 ± 2% COVERAGE.....approx. 350 sq. ft/gal. VOC.....470 g/l (5.78 lb/gal)	METHOD.....Brush, Roller or Spray. NUMBER OF COATS.....Three min. DRY FILM THICKNESS PER COAT.....2 mils APPLICATION TEMP....10°F Min 90°F Max DRY TIME (Estimated) Temperature To Recoat 10°F 3 hrs. 30°F 2½ hrs. 50°F 2 hrs. 70°F 1½ hrs. 90°F ½ hrs. THINNER.....120 Brushing Thinner	120 Brushing Thinner Pettit Protect 4700/4701 Pettit EZ Prime Pettit, Z*Spar, Shipendec Enamels Pettit Antifouling Paint



APPLICATION INFORMATION

Rustlok Steel Primer may be applied by brush, roller or spray. A minimum of three coats of Rustlok is recommended to achieve good, long-term corrosion protection. Four or more coats of Rustlok will yield excellent long-term results. Rustlok reacts with ambient moisture. To avoid gelation of the paint, keep containers tightly sealed when not in use. Thinning is not normally required and is not recommended. Follow the recommended dry time and recoat guidelines carefully. Once fully cured, Rustlok forms an extremely hard surface which is very difficult for other coatings to adhere to. If the dry to recoat time is exceeded, heavy sanding with 80 grit sandpaper is mandatory to achieve proper adhesion of subsequent coats of paint. To eliminate the labor of sanding, plan your work carefully so that each coat of Rustlok and the first application of topcoat (antifouling or topside enamel) will be done before the previous coat dries hard.

Surface Preparation: Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Inadequate preparation of surfaces will virtually assure inadequate coating performance.

SYSTEMS

New Steel: Disc sand with 80 grit sandpaper or sandblast to clean bright metal. Wipe clean with Pettit 120 Brushing Thinner and immediately apply at least three coats of Rustlok following the recoat instructions carefully. Finish with antifouling bottom paint or topside system.

Rusted Steel: Clean the surface by wire brushing, wire wheeling, or light sandblasting. All loose rust must be removed. Firmly attached rust does not have to be removed. Wipe the surface clean with Pettit 120 Brushing Thinner and apply a minimum of three coats of Rustlok. Finish with epoxy primer, an appropriate antifouling bottom paint or topside system.

Galvanized Steel: Galvanized steel must be clean and free of oil or grease before it is painted. Thoroughly clean the surface with Pettit 120 Brushing Thinner and plenty of clean rags to ensure complete removal of contaminants. Then apply a minimum of three coats of Rustlok. Finish with antifouling bottom paint or topside system.

Stainless Steel: Follow the "New Steel" system above.

TOPCOATS

Antifouling Bottom Paint: All Pettit antifouling bottom paints may be applied directly over Rustlok. Adhesion is always best when Rustlok is topcoated when it is still slightly tacky. If Rustlok is allowed to dry hard, thorough sanding with 80 - 100 grit sandpaper is recommended to ensure adequate adhesion of subsequent coats of paint.

Topside Finishes: All Pettit, Z*Spar or Shipendec topside finishes are compatible with Rustlok. If the surface is sufficiently smooth, Pettit, Z*Spar or Shipendec enamels may be applied directly over Rustlok. If the surface needs additional smoothing, use an 6149 EZ Prime as a base over the Rustlok followed by the topside product of your choice. Remember to start the finish coats or primers before the Rustlok dries hard. If the Rustlok dries hard, thorough sanding with 80 - 100 grit sandpaper is mandatory before topcoating.