



Rust Bullet® DuraGrade™ COLOR APPLICATION GUIDELINES

Rust Bullet® DuraGrade™ COLOR provides superior corrosion control and protection while being compliant with VOC regulations in all 50 states. To ensure you achieve the best possible results, it is important that these Application Guidelines are read thoroughly before use. Please refer to the most current Application Guidelines available at www.RustBullet.com or by calling Rust Bullet Customer Support at 800-245-1600.

SURFACE PREPARATION

The proper surface preparation prior to applying Rust Bullet DuraGrade COLOR will ensure optimum performance. The surface must be completely dry and free of loose rust or paint, surface contaminants such as dirt, oily substances, salts, etc. Remove by scraping, sanding or wire brushing. Use Rust Bullet Metal Blast for metal surface cleaning and conditioning prior to application when necessary. Do not use any other chemical for surface prep prior to application without consulting Rust Bullet Technical Support. DuraGrade works best when in direct contact with the substrate. Surfaces with tight existing paint should, at a minimum, be roughed up with 100-150 grit sandpaper. Please note: If an existing paint or coating is not completely removed prior to applying DuraGrade, the existing paint or coating may fail and the surface will require the reapplication of DuraGrade. No additional surface preparation should be necessary.

PRODUCT PREPARATION

IMPORTANT: FAILURE TO FOLLOW STIRRING PROCEDURE BELOW MAY RESULT IN POOR COATING PERFORMANCE

Do not open and stir DuraGrade when the coating's temperature is below 32°F (0°C). DuraGrade must be stirred thoroughly until completely uniform and homogeneous. Do not shake or use electric or mechanical mixing devices that may whip air into the product. Use Rust Bullet Solvent for thinning if necessary (ratio of 3% - 5% by volume).

APPLICATION

DuraGrade may be applied by brush, roller, or spray equipment. Refer to Application Methods at www.RustBullet.com for application equipment details. Theoretical coverage is approximately 300-350 ft² per gallon/per coat depending on the method of application and the surface to be coated. It is critical that DuraGrade be applied to achieve at least an 8 mil / 200 micron dry film thickness (DFT), in a 2 to 3 coat application. A 12 mil DFT is recommended for industrial, commercial and marine applications. Apply in even coats; the first coat must be generous enough to soak through the rust to the steel or iron beneath with additional coats of DuraGrade applied to completely seal the first coat; this cannot be done with any other coating material. Average drying time between coats is 2 to 6 hours. It requires less time to dry on a humid day and more on a dry day. The previous coat should be dry to the touch. As soon as there is no transfer of coating to a gloved finger, you are ready for an additional coat. Ideally, apply the next coat as soon as the previous coat is ready. Do not exceed 24 hours between coats. If 24 or more hours have elapsed, lightly scuff with 150 grit (just enough to roughen the finish) before applying additional coats. Full cure at about 72 hours. Note: These drying times are meant to be a guide only; actual drying times can vary significantly based on film thickness, air circulation, temperature, relative humidity, and other factors. DuraGrade comes in several standard colors and does not require a top coat. Ideal application temperature is between 50°F (10°C) and 80°F (27°C) with humidity below 90%. Never apply DuraGrade while raining or under threat of rain. Do not apply to surfaces when existing temperature of the surface exceeds 190°F (90°C) or is below 32°F (0°C). After fully cured, DuraGrade has a maximum service temperature of 314°F (157°C) continuous.

CLEAN-UP, PRODUCT STORAGE, AND HANDLING

Avoid getting on skin, clothes, or any surface not intended to coat as Rust Bullet DuraGrade is permanent and after curing cannot be removed without abrasive action. Use Rust Bullet Solvent for cleanup. If Rust Bullet Solvent is unavailable, xylene, toluene or acetone may be substituted. DuraGrade residue will harden, destroying equipment if not cleaned immediately. Partially used containers may be resealed using [Bloxygen](#) to prevent curing for up to six months. Limit the time the container is opened. Immediately wipe clean any coating from the rim of the container before resealing. Never pour DuraGrade that has been exposed to air, moisture, or contaminants back into the container. If a skin has formed in a new unopened container or a sealed container, remove by cutting edge of skin at the skin/container surface. Discard of the skin properly. Stir until uniform, filter if necessary and apply. Rust Bullet coatings are packaged in unlined paint cans. If the coating is transferred to another container, a clean unlined paint can (or similar unlined metal container) must be used. Unopened cans have a shelf life of approximately two (2) years. The shelf life of opened cans not re-sealed using [Bloxygen](#) is approximately one month.

SAFETY CONSIDERATIONS

Use with adequate ventilation, and if necessary, use only respiratory protection authorized in the U.S. Federal OSHA Respiratory Protection Standard (29 CFR 1910.134), equivalent U.S. State standards, Canadian CSA Standard Z94.4-93, the European Standard EN149, or EU member states. IMPORTANT: Protective clothing, gloves, and eye protection are recommended during set-up, application, and cleanup; it is extremely difficult to remove Rust Bullet coatings from skin after about 10 minutes. Avoid open flames, pilot lights, sparks, heating elements, cigarettes, or any and all possible sources of ignition. **For more complete coverage of safety issues refer to the GHS SDS at www.RustBullet.com.**

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