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PRODUCT DATA SHEET

TUFF-BOY 5-53 & 5-54 QUICK DRY LOW VOC RUST-STOP PRIMERS

PRODUCT PROFILE

DESCRIPTION

Tuff-Boy Quick Dry Low VOC Rust Stop Primers are durable products formulated with modified alkyd resins and rust inhibitive pigments to give outstanding corrosion protection on ferrous metal surfaces. These fast drying products have unique surface wetting properties that make it possible to prime ferrous metal surfaces where thorough cleaning and sandblasting are not possible. The tough, durable film will provide sufficient resistance to weathering for a period of up to 6 months before enclosure or topcoating. These primers contain no lead or chromate pigments.

TYPICAL USE

These products are recommended for use on properly prepared ferrous metal surfaces. Tuff-Boy Quick Dry Low VOC Rust Stop Primers are the product of choice for priming structural steel, machinery, safety equipment and fences. These products are not recommended for galvanized and aluminum surfaces, or as a primer for high performance coatings such as two package epoxies and polyurethanes. These primers are not intended or recommended for residential use and are classified as "Industrial Use Only" products.

SURFACE PREPARATION

The surface to be painted should be dry and free of any dirt, chalk, loose or peeling paint, grease, mildew, oil, rust, or other foreign contaminants. Minimum surface preparation for iron and steel surfaces is Hand Tool Cleaning per SSPC-SP2. Glossy alkyd enamel surfaces should be sanded and dusted prior to application of these primers. High performance coatings should be sandblasted or hand tool cleaned prior to application of these primers. If you have any questions about proper surface preparation consult your Farrell-Calhoun representative.

COLOR

#5-53 Red or #5-54 Gray

FINISH

Flat @ 60° 1.2 – 2.2

SOLIDS

#5-53: 67.0% by weight / 45.3% by volume
#5-54: 68.5% by weight / 48.3% by volume

**THEORETICAL
APPLICATION RATE**

#5-53: 724 square feet per gallon at 1.0 mil dry film thickness.
#5-54: 775 square feet per gallon at 1.0 mil dry film thickness.
Coverage figures do not include loss of material while mixing, porosity or irregularity of the surface to be painted, or application methods.

**RECOMMENDED
SPREAD RATE**

Apply at 300-400 square feet per gallon to achieve a WFT of 5.3 mils and a DFT of 2.4 mils per coat.

VOC

#5-53 413 grams per liter, #5-54 390 grams per liter

DRY TIME

At 77°F and 50% relative humidity: Thirty minutes to dust, dirt and bug free, one hour to tack free, and two to four hours to recoat.

**APPLICATION
PRECAUTIONS**

Do not paint if the atmospheric temperature or the substrate temperature is below 45°F or above 90°F. Do not paint late in the day when dew or condensation is likely to form or when rain is threatening.

If topcoating with a finish coat that contains strong solvents such as Xylene, it is best to topcoat within three (3) hours or wait 4 - 5 days until the primer has cured, and test for lifting before spraying a large area.

**APPLICATION
EQUIPMENT**

Conventional or airless spray, bristle brush or lambskin roller cover.

THINNING

Thinning is not recommended.

CLEAN-UP

Mineral Spirits or V M & P Naphtha

SHIPPING & STORAGE

PACKAGING

5 Gallon Pails and 55 gallon drums.

WEIGHT/GALLON

#5-53: 10.9 +/- 0.1 Pounds #5-54: 11.3 +/- 0.1 Pounds

**STORAGE
TEMPERATURE**

Minimum 35°F. Maximum 90°F.

SHELF LIFE

12 months at recommended storage temperature when stored in tightly sealed containers.

The technical data contained in this data sheet is accurate to the best of our knowledge. No warranty is expressed or implied since the method of application and its intended use is beyond our control.