



DESCRIPTION: APOC® 291 RUST INHIBITING PRIMER is a high performance, acrylic primer designed to stop corrosion damage of ferrous metals. APOC 291 Rust Inhibiting Primer stops rust, adheres to difficult substrates and gives a corrosion resistant seal to protect against future damage. APOC 291 dries to a red finish and is an ideal base coat for any APOC paint or coating. APOC 291 is great for use over metal roofing, window frames, sidewalls, rail cars, pipes and equipment, tanks exteriors and structural steel. Existing rust is permanently sealed to prevent moisture infiltration and weathering from sun, water, salt and additional oxidation. Apply topcoat directly to primed surface.

PREPARATION: Surfaces must be clean, dry, and sound; contaminants such as dirt, dust, grease, wax, oils, soap film, mold & mildew, bond breakers, curing compounds, and loose, peeling paint must be removed before priming or painting. Sand surfaces to remove / scrape away as much existing rust as possible. Remove all mildew by scrubbing with a solution of 16 oz bleach to one gallon water. Rinse thoroughly and allow to dry 24 hours before painting. Repair holes & cracks with appropriate patching material.

APPLICATION: For exterior use only. Protective clothing, gloves, and eyewear should be used during application of this product. Always apply on a clear, warm sunny day. Apply in morning hours to allow maximum cure time. Application should be completed a minimum of 4 hours prior to sunset. Temperatures must be above 55 °F (for 24 hours) and rising, but not above 110 °F. Apply with brush, 3/4" nap exterior paint roller or professional airless sprayer. First, apply a smooth and continuous coat over all areas containing rust, extending primer a minimum of 2" past rust in all directions. Dries for recoat in 4 hours and fully cures in 24 - 36 hours at 70 °F & 50% relative humidity. Higher humidity, thicker films, poor air flow and lower temperatures will increase dry times. Coverage rate is 1/2 to 1 gallon per square, depending on substrate. Do not Heat or thin.

SPRAY INFO: 2000 PSI, .017 - .030 Tip Size, 1-3 GPM.

CLEAN-UP: Clean tools with soap and water.

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Gardner-Gibson, Inc.
P.O. Box 5449, Tampa, FL 33675

See SDS for more info

TYPICAL PHYSICAL & PERFORMANCE CHARACTERISTICS:

Weight Per Gallon	10.52 lbs.
Solids by Weight	53.0%
Solids by Volume	40.0%
Gloss Reading at 60 °	N/A
Viscosity (ASTM D2697)	75.0 KU
Film Dry Thickness	1.8 mil
Combustible Solvents	Glycol Ether
Consistency	Brush, spray or roller
Suggested Coverage (varies per substrate)	300 SFPG
Cure Time (50% Relative Humidity, 70 °F)	30 min.
Full Cure (50% Relative Humidity, 70 °F)	1 hour.
Application Temperatures	50 °F - 110 °F
Clean-up Tools	Soap & Water

Approx. Shipping Weights: (Note: All approx. weights include container)

1 gallon (3.8L)	11 lbs.
(4) 1 gallon containers/case	44 lbs.
5 gallons (18.9L)	55 lbs.
55 gallon drum (208.2L)	605 lbs.

VOC: <50 g/L (regulatory)

HANDLING PRECAUTIONS: Product safety information required for safe use is not included. Before handling, read product safety data sheets and container labels for safe use and for physical and health hazard information. Safety Data Sheets are available on the APOC website at www.apoc.com. You can also obtain a copy from your local APOC Distributor or APOC sales representative.

LIMITED WARRANTY AND DISCLAIMER: To the best of our knowledge, the technical data contained herein is true and accurate at the date of issuance and is subject to change without prior notice. User must contact APOC to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Liability, if any, is limited to replacement of product unless installed by an approved contractor in accordance with APOC warranty procedures and program.

For limited warranty and disclaimer information, visit our website at: www.apoc.com/productwarrantyinfo.