RUST-OLEUM® HIGH PERFORMANCE®

2500 SYSTEM
DTM 250 VOC ALKYD ENAMEL

DESCRIPTION AND USES

2500 System DTM 250 VOC Alkyd Enamel is designed for interior and exterior surfaces in mild to moderate industrial environments. Not for use on galvanized steel.

If desired, the 2500 System DTM 250 VOC Alkyd Enamels can be applied direct-to-metal (DTM), however optimal corrosion protection is achieved when the finish coat is used in conjunction with one of the recommended primers.

The 2500 System complies with USDA FSIS regulatory sanitation performance standards for food establishment facilities. This coating is impervious to moisture and easily cleaned and sanitized.

PRODUCTS

1-Gallon	5-Gallon	Description
215758	—	White
215954	—	Forest Green
215759	—	Black
215955	—	Dunes Tan
215950	—	Safety Yellow
215956	—	Safety Orange
215951	—	Safety Red
215957	—	Safety Blue
215952	—	Navy Gray
215958	—	Rusty Metal Primer
215959	—	Gray Primer
215960	—	Masstone Base
215961	—	Deep Base
215962	—	Light Base
215958	—	Rust Inhibitive Red Primer
215959	—	Rust Inhibitive Gray Primer

PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength® Cleaner/Degreaser, item #3599402, commercial detergent or other suitable cleaner. Rinse thoroughly with fresh water and allow to fully dry. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. If abrasive blasting cleaning is used, then two coats of recommended primer are required.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding to create a surface profile. The 2500 System Enamels are compatible with most coatings, but a test patch is suggested.

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable)

BRUSH: Use a good quality synthetic bristle brush.

ROLLER: Use a good quality natural or synthetic cover.

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atomization Pressure
Pressure	0.055-0.070	12-16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP (var.)	0.043-0.070	8-10 oz./min.	10 psi (at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1,600-2,400 psi	0.013-0.017	100

THINNING

BRUSH/ROLLER: #333402 Thinner: Normally not required.

AIR ATOMIZED SPRAY: #333402 Thinner: Use up to 15% as needed.

AIRLESS SPRAY: #333402 Thinner: Normally not required. Use 5-10% (approximately ½-2 pints per gallon, if needed).

CLEAN-UP

#333402 Thinner or Acetone.

Form: GDH-1041
Rev.: 020816

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TECHNICAL DATA

2500 SYSTEM DTM 250 VOC ALKYD ENAMEL

PHYSICAL PROPERTIES

		FINISHES	TINT BASES	PRIMERS
Resin Type		Modified Alkyd	Modified Alkyd	Modified Alkyd
Pigment Type		Varies with color	Varies with color	Varies with color
Solvents		Mineral Spirits, Acetone	Mineral Spirits, Acetone	Mineral Spirits, Acetone
Weight	**Per Gallon**	7.8-9.7 lbs.	7.9-9.2 lbs.	12.1 lbs.
	Per Liter	0.94-1.16 kg	0.95-1.1 kg	1.4 kg
Solids	**By Weight**	69.8-79.3%	73.5-75.2%	79.2%
	By Volume	61.4-63.8%	66.6-69.4%	61.4%
Volatile Organic Compounds		< 250 g/l (2.08 lbs./gal.)	< 250 g/l (2.08 lbs./gal.)	< 250 g/l (2.08 lbs./gal.)
Recommended Dry Film Thickness (DFT) Per Coat		1.5-2.5 mils (37.5-62.5µ)*	1.5-2.5 mils (37.5-62.5µ)*	1-2 mils (25-50µ)
Wet Film to Achieve DFT		2.5-4.0 mils (62.5-100µ)	2.0-3.5 mils (50.0-87.5µ)	1.5-3.0 mils (37.5-75µ)
Theoretical Coverage at 1 mil DFT (25µ)		985-1,023 sq.ft./gal. (24.2-25.2 m^2/l)	1,068-1,113 sq.ft./gal. (26.3-27.4 m^2/l)	985 sq.ft./gal. (24.2 m^2/l)
Practical Coverage at Recommended DFT (assumes 15% material loss)		335-580 sq.ft./gal. (8.2-14.3 m^2/l)	360-630 sq.ft./gal. (8.9-15.5 m^2/l)	420-870 sq.ft./gal. (10.3-21.4 m^2/l)
Dry Times at 70-80°F (21-27°C) and 50% Relative Humidity	**Tack-free**	5-7 hours	5-7 hours	3-5 hours
	Handle	8-12 hours	10-14 hours	5-10 hours
	Recoat	24 hours	24 hours	24-48 hours
Dry Heat Resistance		212°F (100°C)	212°F (100°C)	212°F (100°C)
Shelf Life		5 years	5 years	5 years
Safety Information		For additional information, see SDS		

Calculated values are shown and may vary slightly from the actual manufactured material.
*If applied over a primer or previously coated steel, a dry film thickness of 1-2 mils (25-50µ) is acceptable; 2-4 (50-100µ) wet film thickness.

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