



Product Data Sheet (PDS):

GacoFlex™ Acrylic Metal Rust Primer Acrylic Roof Coating

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GACOFLEX ACRYLIC METAL RUST PRIMER ACRYLIC ROOF COATING

A. DESCRIPTION:

GacoFlex Acrylic Metal Rust Primer is a modified acrylic waterborne primer serving multiple purposes. It is used as a primer. Light Gray in color, air dry, great adhesion, and excellent corrosion resistance. It shows superior re-coat ability and exterior durability.

B. RECOMMENDED USE:

May be applied over marginally prepared metal surfaces such as structural steel, galvanized sheet metal, steel decking and aluminum. Apply at 0.5 gallon (1.89 liters) per 100 square feet (3 dry mils.). Heavily rusted surfaces may require additional prep and additional passes of GacoFlex Acrylic Metal Rust Primer.

C. LIMITATIONS:

- Substrate must be clean, smooth, and free of dirt, rust, and/or moisture. Power washing of substrate is recommended.
- GacoFlex Acrylic Metal Rust Primer must not be applied during inclement weather and should not proceed if any precipitation is imminent.
- Application of materials with power spray equipment will require some masking and possible erection of wind screens to prevent overspray damage to surrounding structures, building surfaces, vehicles or other property or persons.

D. PACKAGED PRODUCT DATA:

PROPERTY	DESCRIPTION
COLOR***	LIGHT GRAY
ADHESION	Excellent adhesion to galvanized, galvalume, aged Kynar™, or similarly coated metals. Do not apply GacoFlex Acrylic Metal Rust Primer over existing silicone coatings.
THEORETICAL COVERAGE	200 ft² / gal / mil (9.3 m² / 3.78 L / 2.7-2.9 mil DFT)
SOLIDS	Weight: 40-42 % ASTM D1644 Volume: 34-36 % ASTM D2697
STORAGE STABILITY	8 months when stored between 50 °F – 85 °F (10 °C – 30 °C). Do not allow product to freeze. Some separation may occur after extended storage. Mix thoroughly before use.
TOXICITY	Not for use in contact with edible substances or potable water.
V.O.C.	66 g / L EPA Method 24
FLASH POINT	> 200 °F (> 93 °C) ASTM D1310
VISCOSITY	5000 cps
DENSITY	9.10 lbs / gal (4.1 kg / 3.8 L)

E. PHYSICAL PROPERTIES

	ASTM TEST	RESULT
ELONGATION AT 75°F (23.9°C)	D2370	>100%

F. APPLICATION

STEP	INSTRUCTIONS
THINNING	Thinning is not recommended under normal conditions.
MIXING	Mix until homogeneous with a mechanical mixer before application to ensure uniform color and consistency.
SURFACE PREPARATION	<p>Ferrous substrates must be prepared properly for maximum corrosion protection and long service life. All loose rust must be removed by power washing, wire brushing or sand blasting. Adhesion testing is recommended prior to application.</p> <p>When necessary, use GacoWash at 1-part concentrate to 9-parts water to clean roof before application. Rinse well and allow substrate to dry thoroughly.</p> <p>After GacoFlex Acrylic Metal Rust Primer has been applied detail all fasteners, seams, laps and flashings and penetrations in existing metal substrates. A combination of sealants may be required. These would include GacoFlex HER, UF90 GacoMastic, GacoSeal 7120, GacoFlex 133 prior to applying finish coat.</p>
APPLICATION	<p>Do not apply GacoFlex Acrylic Metal Rust Primer to wet surfaces. Make sure roof surface is completely dry, clean, and free of dirt, grease, biological soiling, loose granules, and paint residue before coating.</p> <p>Do not apply GacoFlex Acrylic Metal Rust Primer below 40°F (4.45°C) or in weather conditions where the temperature will fall below 40°F (4.45°C) during the cure cycle. The substrate temperature range for application is 40°F (4.45°C) – 120°F (48.9°C).</p> <p>Application rates vary based on substrate type, refer to Application Specifications available at Gaco.com for further details. Additional coats may be required to achieve required minimum Dry Film Thickness (DFT). GacoFlex Acrylic Metal Rust Primer may be applied with a 3/8 in (10 mm) nap roller, brush, or airless sprayer.</p> <p>FOR USE OF AIRLESS SPRAYERS: Airless spray equipment should be capable of 1 gallon per minute capacity at 3000 psi. GacoFlex Acrylic Metal Rust Primer is designated a "medium elastomeric coating" with medium viscosity for pump purposes. 1/2" high pressure hoses perform well. The airless spray gun should be equipped with a ball-bearing swivel for ease of handling. Recommended orifice size is .025" to .035" diameter, wide-angle fan pattern. A reverse-a-clean nozzle is recommended. Exact orifice size will vary with temperature of the material and weather conditions.</p> <p>NOTE: <u>DO NOT EXCEED 1.0 GAL / 100 FT² (3.8 L / 9.3 M²) PER COAT</u></p>

DRY TIME	Dry time: 1-2 hours to recoat at 75 °F (24 °C) and 50% RH per coat of GacoFlex Acrylic Metal Rust Primer. Low temperatures or high humidity conditions will extend cure times. Do not apply GacoFlex Acrylic Metal Rust Primer when precipitation or heavy dew is expected within 4 hours (6–8 hours in high humidity conditions). Allow to cure a minimum of 4-6 hours at 75 °F (24 °C) and 50% RH before applying topcoat.
CLEAN UP	Clean up tools and equipment with soap and water immediately after application. Follow spray equipment manufacturer's guidelines on clean up and maintenance of spray equipment.

** For specific Health and Safety information, please refer to Safety Data Sheet (SDS)*