



PRODUCT DATA

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INHIBO RUST INDUSTRIAL ENAMEL "SOLVENT BASE"

PRODUCT CODE: **101 – 0XX**

PRODUCT DESCRIPTION: Inhibo Rust Industrial Finish is a premium synthetic alkyd finish designed to provide maximum protection for the substrate, while maintaining a protective and decorative value for the Farm, Industrial Shop/Equipment and Structural Steel Environment. Formulated to dry with an exceptional gloss finish, Inhibo Rust produces a desirable durable finish that has excellent mar and abrasion resistance suitable for a wide range of substrates where physical and chemical performance is necessary.

PRODUCT USE: Inhibo Rust finishes are formulated for use as a maintenance finish over **Interior and Exterior Wood, Concrete, and Masonry Substrates**. Used in combination with Inhibo Rust Industrial Primers, Inhibo Rust Finishes produce an excellent Rust Inhibitive System for a variety of **Industrial Metal Surfaces** such as **Shop Equipment, Door Frames, Window Frames, Wrought Iron Fixtures, Lawn Furniture, Storage Tanks** and various types of **Structural Steel**.

Inhibo Rust Finishes are available in 19 ready mixed Gloss Colors, 11 of these colors meet the O.S.H.A. Safety Color Spectrum for marking physical hazards.

O.S.H.A. SAFETY COLOR SPECTRUM

101 – 011 Gloss White	101 – 012 Visibility Yellow	101 – 018 Equipment Orange	101 – 020 Toluidine Red
101 – 021 Safety Blue	101 – 022 Warning Blue	101 – 023 Light Green	101 – 024 John Deere Green
101 – 027 Gloss Black	101 – 030 Light Yellow	101 – 044 Purple	

RECOMMENDED PRIMERS

WOOD SURFACES

INTERIOR SURFACES: Simpson Coatings E-S-Primers #118-03X.
EXTERIOR SURFACES: Simpson Coatings E-S-Primers #118-03X.

MASONRY SURFACES: Simpson Coatings Latex Block Filler #118-03X.
Simpson Coatings P.V.A. Sealer #108-011.
Simpson Coatings Water Base, Epoxy Surface Conditioner #104-052C.

LIMITED WARRANTY: The statements on this bulletin product label, or by any of our agents concerning these materials are given for information only. They are believed to be true and accurate and intended to provide a guide to approved construction practices and materials. As workmanship, weather, construction equipment, quality of other materials and other variables affecting results are all beyond our control. The Simpson Coatings Group does not make nor does it authorize any agent or representative to make any warranty of MERCHANTABILITY OR Fitness for any purpose or any other warranty, guarantee or representation, expressed or implied, concerning this material except that it conforms to Simpson Coatings quality control standards. Any liability whatsoever of Simpson Coatings Group to the buyer or user of this product is limited to the purchaser's cost of the product itself.

101 – OXX Inhibo Rust Enamel continued

RECOMMENDED PRIMER continued

METAL SURFACES:	Simpson Coatings Red Oxide Primer #101-031. Simpson Coatings Gray Primer #101-032. Simpson Coatings Inhibo Rust Zinc Chromate Primer #101-034. (Yellow). Simpson Coatings Inhibo Rust Zinc Chromate Primer #101-035. (Green). Simpson Coatings Pretreatment Vinyl Wash Primer #101-055C DOD-P-15328. Simpson Coatings Rust Buster Rust Converting Primer #101-572.
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SURFACE PREPARATION

WARNING!

If you scrape, sand, or remove **Old Paint**, you may release **Lead Dust**. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a NIOSH-Approved Respirator to control **Lead Exposure**. Clean up carefully with a **HEPA Vacuum and Wet Mop**. Before you start, find out how to protect yourself and your family by contacting **The National Lead Information Hotline at 1-800-424-LEAD** or log on to www.epa.gov/lead.

ALL SURFACES: Must be clean, dry and free of dust, dirt, oil, grease, wax or any contamination that would adversely affect the adhesion or performance of this coating. Remove all oil, dirt, and other contaminants by cleaning with a V.O.C. compliant commercial cleaner/degreaser. Rinse thoroughly and allow to dry.

ALL MILDEWED SURFACES: Existing mildew should be removed by washing the affected areas with a 3:1 solution of water and chlorine bleach or reliable commercial mildewcide. Keep applying until all discoloration is removed. Rinse thoroughly and allow surface to dry before recoating.

NEW SURFACES

NEW WOOD SURFACES: Where appropriate sand smooth with sandpaper. If mildew is present, remove as described above. All new wood surfaces should be primed. Exterior wood should be primed with one coat of Simpson Coatings E-S-Primer #118-03X, interior wood should be primed with one coat of Simpson Coatings E-S-Primer #118-03X. Allow a 16 to 24 hour dry time before recoating with the finish coat.

NEW MASONRY, CONCRETE, TILT UP, OR UNCOATED MASONRY SURFACES: For uncoated masonry, concrete, and tilt up surfaces, fill with Simpson Coatings Latex Block Filler #118-031. Allow 16 to 24 hours dry time, followed by a seal coat of Simpson Coatings Water Base Epoxy Surface Conditioner #104-052C. Allow 16 to 24 hours to dry before recoating with finish product. **(Must be recoated within 14 days) NOTE: All new substrates should cure for a minimum of 30 days before coating. Very dense, non porous, or chemically treated concrete may require over all etching, abrasive blasting or sanding to achieve proper coating adhesion.**

NEW METAL SURFACES: Prepare new metal surfaces as directed with all surfaces. Clean the surface with a V.O.C. compliant commercial cleaner/degreaser. Apply one coat of Inhibo Rust Red Oxide Primer #101-031 or Inhibo Rust Gray Primer #101-032 at 275 square feet per gallon allowing 4 to 6 hours dry time to recoat with the finish coat.

FERROUS, GALVANIZED SURFACES: Galvanized steel surfaces can be variable substrates due to the changing process of the Galvanizing Industry and/or the age of the galvanizing. Etch all galvanized and ferrous metal surfaces with Simpson Coatings #111-055C DOD-P-15328 Pretreatment Vinyl Wash Primer, a two component system composed of 4 parts #111-055A and one part #111-055B, applied at .25 to .5 mils dry, **allowing 30 minutes to 1 hour dry time** to recoat with 1 coat of Simpson Coatings Inhibo Rust Zinc Chromate Primer #101-034 (Yellow) or #101-035 (Green). Allow 16 to 24 hours dry time before recoating with Inhibo Rust Industrial Enamel.

101 – 0XX Inhibo Rust Enamel continued

NEW SURFACES continued

NOTE:

Pretreatment Vinyl Wash Primer is intended to be used as surface treatment to increase maximum adhesion to the primer system. To insure best results the Pretreatment should be recoated with Inhibo Rust Zinc Chromate Primer as soon as the material is sufficiently dry as directed. (Must be recoated within 4 hours).

PREVIOUSLY COATED SURFACES

ALL PREVIOUSLY
COATED SURFACES:

Clean thoroughly as directed for all surfaces. Remove all loose peeling paint and chalk oxidation by sanding or pressure washing. Glossy surfaces should be dulled by sanding for maximum adhesion. Sandblasting or high-pressure water jet is recommended for the more severe deteriorated surfaces.

PREVIOUSLY COATED
WOOD SURFACES:

Clean thoroughly as directed above for all previously coated surfaces. Apply one coat of Simpson Coatings E-S-Primer #118-03X (exterior surfaces) or Simpson Coatings E-S-Primer #118-03X (interior surfaces) on areas of the surface that have been sanded to bare wood. Allow a minimum of 16 to 24 hours dry time before recoating with the finish coat.

PREVIOUSLY COATED
MASONRY, CONCRETE
TILT UP SURFACES:

Scrape, wire brush, mechanical sanding or sandblast to remove loose, unsound concrete or any efflorescence, laitance (white powder or dust) from the surface. This should be followed by compressed air removal. Surfaces with mold or mildew should be cleaned with a commercial mildew remover and rinse thoroughly with water. Remove any mold release oil with Simpson Coatings Xylol #301-011. **EXCEPT AS RESTRICTED BY YOUR LOCAL AIR QUALITY MANAGEMENT DISTRICT.** Fill with Simpson Coatings Latex Block Filler #108-031 if required. Allow 16 to 24 hours dry time before recoating with finish coat.

PREVIOUSLY COATED
METAL SURFACES:

Remove loose rust, mill scale and deteriorated previous coating by wire brushing or coarse sand paper. If rust is underneath the paint film, remove the Paint Finish until a ring of bright metal is exposed around the edges of the rusted areas. Sandblasting or mechanical sanding is recommended for the heavily contaminated surfaces. Clean the surface with a V.O.C. compliant commercial cleaner/degreaser. Prime coat with Simpson Coatings Rust Buster #101-572, allowing 16 to 24 hours for the product to Rust-Convert/Dry followed by one coat of Inhibo Rust Red Oxide Primer #101-031 or Inhibo Rust Gray Primer #101-032 at 275 square feet per gallon. Allow 4 to 6 hours dry time before recoating with the finish coat.

APPLICATION INFORMATION

Estimation of practical coverage of this product can be variable and is completely dependent on application technique i.e., (determine amount of wet film thickness application to achieve dry film thickness) and the porosity of the substrate.

Drying time and curing time can be adversely affected by extreme high/low substrate and atmospheric temperature variances, along with extreme high/low humidity. Apply when **air, product and surface temperatures** are between **60 °F – 90 °F**, the relative humidity is no greater than **85%**, and surface is at least **5 °F** above the dew point.

101 – 0XX Inhibo Rust Enamel continued

APPLICATION INFORMATION continued

WOOD SURFACES: Apply two coats of Inhibo Rust Industrial Finish at 2.2 to 2.5 mils dry, allowing a minimum of 36 hours dry time in between each coat. For unpainted, porous, or heavily grained soft wood, a third coat may be desired. A 36 to 48 hour dry time should be allowed for light foot traffic. For heavy traffic or areas where equipment will be used, allow a full 7 to 10 day cure time.

MASONRY, CONCRETE AND TILT UP SURFACES: Apply two coats of Inhibo Rust Industrial finish at a 2.2 to 2.5 mils dry letting the first coat dry for a minimum of 36 hours. A 36 to 48 hour dry time must be allowed for light foot traffic, full 7 to 10 day cure time is required for heavy equipment and traffic areas.

ALL METAL SURFACES: Apply two coats at 2.2 to 2.5 mils dry, allowing 36 hours dry time in between each coat. 36 to 48 hours dry time must be allowed for light foot traffic. For areas such as metal handrails, stairs, steps, or where heavy equipment is used, allow a full 7 to 10 day cure time.

THINNING/CLEAN – UP

BRUSH/ROLLER: **DO NOT THIN.**

AIR ATOMIZED/AIRLESS OR HVLP SPRAY:

DO NOT THIN THESE PRODUCTS. These products are ready-to-apply as packaged. Thinning these products can adversely affect film building properties, dry/cure times, and volatile organic compound (V.O.C.) emissions. Please review the U.S. E.P.A. National Rule and your Local Air Quality Management Districts Rules and Regulations regarding V.O.C. emissions and Clean Up Products Regulations for Architectural and Industrial Maintenance Coatings. If it is necessary to thin these products, Do Not Exceed Two Ounces of Simpson Coatings Inhibo Rust Spray Thinner #309–027 per gallon of Inhibo Rust Finishes #101–0XX.

CLEAN – UP: Use Simpson Coatings Acetone #304–013 for cleaning Application Tools and Spray Equipment only! **EXCEPT AS RESTRICTED BY YOUR LOCAL AIR QUALITY MANAGEMENT DISTRICT.**

EQUIPMENT RECOMMENDATIONS

BRUSH/ROLLER: Use a high quality natural pure bristle brush or a mohair blend roller cover 1/4" or less for smooth finishes, 1/2" to 1/4" 50/50 blend roller cover for masonry with heavily textured finishes.

SPRAY: Inhibo Rust Industrial Finishes can be applied by Professional Airless, Conventional or HVLP Spray Technology.

101-0XX Inhibo Rust Industrial Enamel "Solvent Base" Technical Data/Physical Properties

Resin Type: Alkyd
 Solvents: Aromatic and Aliphatic Hydrocarbons
 Coatings V.O.C. < 420 G/L

PRODUCT	ANALYSIS						PRODUCT COVERAGE			
	Pigment % by weight	% Solids by weight	% Solids by volume	Gloss	Viscosity	Wt. Per Gallon	Recommended Dry Film Thickness	Recommended Wet Film Thickness	Practical Coverage (assume 15% material loss)	Theoretical Coverage @ 1 mil D.F.T.
101-011 Gloss White	22.1-22.7%	61.2-63.2%	45.5-47.5%	80+	70-77KU	8.9-9.5	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-012 Visibility Yellow	15.2-15.8%	58.5-60.5%	47.7-49.7%	80+	70-77KU	7.9-8.5	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-018 Equipment Orange	21.1-21.7%	61.0-63.0%	44.8-46.8%	80+	70-77KU	9.0-9.6	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-020 Tolidine Red	13.6-14.2%	57.5-59.5%	44.7-46.7%	80+	70-77KU	8.2-8.8	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-021 Safety Blue	12.3-12.9%	57.0-59.0%	45.4-47.4%	80+	70-77KU	8.1-8.7	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-022 Warning Blue	12.2-12.8%	56.6-58.6%	45.3-47.3%	80+	70-77KU	8.0-8.5	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-023 Light Green	14.8-15.5%	58.3-60.3%	45.2-47.2%	80+	70-77KU	8.3-8.9	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-024 John Deere Green	12.7-13.3%	57.8-59.8%	45.3-47.3%	80+	70-77KU	8.2-8.8	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.

Dry times @ 77° F and 50% R.H.

Tack Free: 4-6 Hours

Handle: 6-12 Hours

Sand/Recoat: 24-36 Hours

Full Dry/Cure: 7-10 Days

Special instructions:

WARNING: THIS PRODUCTS CONTAINS CHEMICALS KNOWN TO THE STATE OF CALIFORNIA TO CAUSE CANCER AND BIRTH DEFECTS OR OTHER REPRODUCTIVE HARM.

Proposition 65 Warning

TECHNICAL SERVICE: Technical Services are available through Simpson Coatings Technical Service Support at 1-800-877-5997

LIMITED WARRANTY: The statements on this bulletin product label, or by any of our agents concerning these materials are given for information only. They are believed to be true and accurate and intended to provide a guide to approved construction practices and materials. As workmanship, weather, construction equipment, quality of other materials and other variables affecting results are all beyond our control. The Simpson Coatings Group does not make nor does it authorize any agent or representative to make any warranty of MERCHANTABILITY OR FITNESS FOR ANY PURPOSE or any other warranty, guarantee or limitation, expressed or implied, concerning this material except that it conforms to Simpson Coatings' internal standards. Any liability whatsoever of Simpson Coatings Group

101-0XX Inhibo Rust Industrial Enamel "Solvent Base" Technical Data/Physical Properties

Resin Type: Alkyd
Solvents: Aromatic and Aliphatic Hydrocarbons
Coatings V.O.C. < 420 G/L

PRODUCT	ANALYSIS					PRODUCT COVERAGE				
	Pigment % by weight	% Solids by weight	% Solids by volume	Gloss	Viscosity	Wt. Per Gallon	Recommended Dry Film Thickness	Recommended Wet Film Thickness	Practical Coverage (assume 15% material loss)	Theoretical Coverage @ 1 mil D.F.T.
101-027 Gloss Black	4.2-4.8%	54.3-56.3%	45.2-47.2%	80+	70-77 KU	7.6-8.2	2.0-3.0 mils	4.0-6.0 mils	250-350sq. ft.	300-400 sq. ft.
101-030 Light Yellow	15.3-15.9%	57.7-59.7%	47.8-49.8%	80+	70-77 KU	7.8-8.4	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.
101-044 Purple	2.6-3.2%	53.9-55.9%	44.9-46.9%	80+	70-77 KU	7.5-8.1	2.0-3.0 mils	4.0-6.0 mils	250-350 sq. ft.	300-400 sq. ft.

Dry times @ 77° F and 50% R.H.

Tack Free: 4-6 Hours

Handle: 6-12 Hours

Sand/Recoat: 24-36 Hours

Full Dry/Cure: 7-10 Days

Special Instructions :

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