
**PRODUCT
INFORMATION****NOX-RUST® R-491-115****Description**

NOX-RUST® R-491-115 is a metallo-organic, polar type rust proofing compound specifically designed to protect enclosed automotive body section. This rust proofing compound has a thin gel, but low viscosity

that allows for film build on vertical surfaces and for seam penetration into areas with metal to metal overlap. The resulting film is amber in color and will repel water, self heal itself, and remain flexible.

Physical Properties**Typical Values**

Odor:	Mild Petroleum Solvent
Appearance:	Tan, Thixotropic, free-flowing liquid
Specific Gravity:	0.90
Non-Volatile Content:	60% by weight 54% by volume
Viscosity 25°C, Brookfield RV Spindle #4	
Fresh	800 cps @ 20 rpm
72 Hours Aged	850 cps @ 20 rpm
#4 Ford Cup	105 Seconds
Flash Point:	105°F (Min.)
Solvent:	Rule 66 Mineral Spirits
VOC:	2.8 lbs. VOC per gallon
Storage Stability:	Minimum 1 year
(Stirring the product may be required after long term storage.)	

Performance Properties

The following tests were performed on cold rolled and ELPO primed steel panels at a film thickness of 4 mils dry.

1. Primary Run - Wet film at 50°C, in enclosed box - less than 10 mm sag.
2. Permeability - Greater than 95 mm of creep between panels.
3. Cold Bend -20°C, 3 Hours / No cracking or loss of adhesion.
4. Salt Spray Protection
1000 Hrs. - Cold Rolled Steel
Scribed - less than 1/8 inch undercut
Face - less than 1% face rust
5. High Temperature Flow Resistance / No Sag at 150° C for 1/2 hour.

NOX-RUST® R-491-115 will not stain automotive body paints. The dried film can be removed by using a mineral spirits or a kerosene soaked rag.

Surface Preparation

The maximum performance of NOX-RUST® R-491-115 can be achieved only when the metal surfaces to be protected are clean, dry and free of rust, oil and mill scale. Daubert Chemical Company recommends that the metal substrate temperature be 50-95°F (10-35°C) at the time of product application.

Application

NOX-RUST® R-491-115 is applied with low pressure airless spray equipment with accessory spray wands capable of coating critical areas through existing openings or drilled 1/2 access holes. Contact a Daubert Sales Representative for recommendation on equipment. The recommended film thickness is 6 mils wet (4 mils dry). When sprayed at this thickness NOX-RUST® R-491-115 will dry to touch in 4 hours and tack free overnight.

Removal

NOX-RUST® R-491-115 can be removed with a solvent borne thinner, vapor degreasing, hot alkaline wash, or low-pressure steam. NOX-RUST® R-491-115 can be removed from fabrics by normal dry cleaning procedures. Avoid the use of chlorinated or highly aromatic solvents

when removing from painted surfaces, as these solvents may adversely affect paint.

Storage

Store NOX-RUST® R-491-115 at temperatures between 50-95°F (10-35°C). Mild agitation is recommended prior to use.

Caution

Adequate ventilation is required for cure and to ensure against formation of a combustible liquid. THE PARTIALLY CURED FILM SHOULD NOT BE EXPOSED TO IGNITION SOURCES SUCH AS FLARES, FLAMES, SPARKS, EXCESSIVE HEAT, OR TORCHES. Refer to Daubert's Material Safety Data Sheet for additional handling and first aid information.

Note:

The addition of any product over or under this coating is not recommended. The use of additional coatings could result in chemical incompatibility, thus adversely affecting the performance of this coating as stated in the lab data section. If a product other than Daubert Chemical Company's recommended product is required, written authorization must be obtained from Daubert Chemical Company.

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REFER TO MATERIAL SAFETY DATA SHEET FOR HEALTH AND SAFETY INFORMATION.

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