



## Rustilo™ Aqua 614

Aqueous Corrosion Preventive

### Description

Castrol Rustilo™ Aqua 614 (previously called Aquasafe™ 614) is a unique, water-based, wax emulsion which is used as a dual purpose dry film lubricant and corrosion preventive.

### Application

Rustilo Aqua 614 is recommended for use on artillery shell casings, small arms ammunition clips, and other weatherproofing military applications. Its excellent dry film and corrosion preventive characteristics make Rustilo Aqua 614 also ideal for use as a lubricant for steel strapping and it is a good piano stringing lubricant.

Rustilo Aqua 614 can also be used as a torque reduction and corrosion resistant lubricant on various fasteners and as a dry film lubricant in the installation of various rivets.

Further, the product is recommended for use as a corrosion preventive and decorative coating on cast iron and over treated surfaces such as phosphated, bonderized, and anodized surfaces.

Rustilo Aqua 614 provides additional protection over all types of plating, including cadmium and zinc. The dry film lubricating and release characteristics of this product make it an ideal mold release for gold leaf and a good joint lubricant for umbrella-type television antennas.

In addition, Rustilo Aqua 614 can be used as a dressing on rubber, plastic and leather, or to provide surface protection and enhance the appearance of interior wood paneling.

### Advantages

- Excellent corrosion control and coverage
- Superior dry film lubrication
- Enhances appearance of most surfaces
- Effective on a wide variety of substrates
- Enhances appearance of most surfaces by providing medium gloss dry film (buffable)
- Easy to apply and remove
- Easily diluted and mixed

### Typical Characteristics

Description	Test Method	Unit	Rustilo Aqua 614
Appearance of Concentrate	Visual	-	Opaque brownish fluid
pH of Concentrate	CN-TM-069	-	8.4 - 9.4
Specific Gravity @ 15°C	CN-TM-086	g/cm <sup>3</sup>	0.995
Solids Content	CT-TP-4.16	%	20 - 20.4

## User Advice

- To achieve effective adhesion, apply Rustilo Aqua 614 to surfaces that are completely free of oils, greases, acids, soaps and other foreign materials. The presence of water, unless excessive, will not interfere with adhesion or film forming characteristics. Parts must be dried before stacking.
- Rustilo Aqua 614 dries tack-free under ambient conditions in approximately 20 minutes. Drying can be accelerated by application of heated air and increased air velocity. Drying time can also be accelerated by heating parts prior to application of coating.
- Rustilo Aqua 614 is a low viscosity liquid and is applied by any method or technique to the particular operation—flow coat, roll coater, mechanical wipe, immersion, or spray.
- Whenever a spray technique is selected for application of Rustilo Aqua 614, a well-atomized spray is recommended. Application should consist of repeated strokes over the spray pattern to ensure a thin, even coat.
- Care must be taken to avoid spraying a dry or partially dry pattern, since a dry spray will dull the final gloss. Internal and external air mix spray techniques are satisfactory for Rustilo Aqua 614 application as is airless spray. In all cases, the atomization air pressure should be kept high, from 65 - 75 pounds. Avoid inhalation of product in spray application.
- Working dilutions of Rustilo Aqua 614 should be determined by the end user. Rustilo Aqua 614 can be diluted with tap water; however, if the local water is very hard, dilute with deionized water. For maximum protection and durability, use full strength.

## Additional Information

### Test Data for ASTM D2247-68

Humidity Cabinet, 100%-100°F (38°C):

Concentration	Cold Roll Steel / Hrs	Iron Phosphate / Hrs	Zinc Phosphate / Hrs
100%	48	80	80
80%	40	72	72
67%	32	48	48

### Test Data for ASTM B117-73

Salt Fog - 5% salt, 100%-100°F (38°C):

Concentration	Cold Roll Steel / Hrs	Iron Phosphate / Hrs	Zinc Phosphate / Hrs
100%	2	4	15
80%	1	2	5
67%	-	2	5

**This product was previously called Aquasafe 614. The name was changed in 2015.**

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