MeCaCorr 850

APPLICATION INSTRUCTIONS

MeCaTeC®

SURFACE PREPARATION

Ensure that surface is clean, dry and uncontaminated. Precleaning of the surface is necessary to remove oil, wax or other foreign contaminant which may contaminant the abrasive media and impregnate itself into the blast profile. Always check for ionic salt contamination (chlorides and sulfates) and neutralize the surface as required.

Proceed only if the substrate temperature is 5°F (3°C) above the dew point temperature and that the relative humidity is below 85% during surface preparation and coating application.

Irregular surface roughness, sharp edges and weld splatter shall be removed

Abrasive blast with clean angular abrasive media. For steel surfaces, blast to a Near White Metal Blast (SSPC-SP10; NACE 2; SA 2.5) with a minimum 2 mils (50 µm) depth profile. Blow down the surface before applying the coating to ensure it is free of dust and other loose contaminants.

Salt Water Service - It is highly recommended that where the substrate has been exposed to salt water immersion that the surface is abrasive blasted, allowed to sit for 12 hours, followed by high pressure water jetting with a neutralization solution before re-blasting for the application of the coating.

MIXING INSTRUCTIONS

Ensure product temperature is between 68-85°F (20-30°C).

MeCaCorr 850 is sensitive to atmospheric moisture and will form a layer of skin on the surface if left exposed to air. Once the kit is open, it is recommend to mix immediately.

Due to the high pigment and ceramic loading of MeCaCorr 850, heavy settling will occur over time especially as a consequence of long distance transportation. It is recommended to turn the kit upside down for 24 hours before use. Use a paint shaker for 10 minutes to break up the material sedimentation.

Only after shaking, is it recommended to open the lid to mix the material. Mix for 5 minutes until a uniform color and consistency is achieved. To ensure complete mixing, scrape sides and bottom of container and continue mixing for an additional 1 minute. Longer mixing time may be required to ensure that the material is homogeneous and that the ceramic loading is fully reincorporated. If a mechanical drill with Jiffy mixer is used, mix at slow rpm speed. Excessive mixing speed will induce air into the mixture and is not recommended. Once mixed, remember to close the product lid until it is ready to be applied. This will prevent the material from skinning over.

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Once mixed the product is ready to be applied.

MeCaCorr 850 may be applied by brush, roller, conventional and airless spray.

Ensure adequate ventilation when applying this product in confined spaces.

Once mixed, the material must be screened with 60 to 80 mesh filter. Prior to use, flush all equipment with clean xylene solvent. Frequently mix material during application. If spraying stops for more than 60 minutes, recirculate the material remaining in the spray line. Do not leave product in the hoses for long durations. Do not expose the open container to air as the product will skin over.

CONVENTIONAL SET UP

Pressure pot equipped with dual regulators, Material hose: 3/8" I.D. (minimum) with a maximum length of 50', 0.070" I.D. fluid tip and appropriate air cap. Tip size 1 mm. spray pressure 30 psi (2 Bar)

AIRLESS SET UP

Pump Ratio: 30:1 (minimum), Material hose: 3/8" I.D. (minimum), Tip size: 0.011-0.015", Output PSI: 1750-2400, (120 - 165 Bar) Filter size: 100 mesh.

The product is applied in thin multiple passes less than 1.5 mils (37.5 microns) to the desired thickness. The wait time between passes varies based on environmental conditions, substrate type/temperature and final use.

SPRAY APPLICATION

Prior to full coating application, stripe all continuous welds and edges by brush or spray. Apply the coating at no more than 1.5 mils (37.5 µm) per pass. Apply the coating in a crisscross multi pass technique. Although a multi pass technique is used, it is recommended that two coats are applied at 4 mils (100 microns) dry film thickness per coat. Applying the product is two coats allows for improved film coverage. Coating thickness measurements between coats allows the installer to verify proper thickness coverage and reduces the risk of thin spots or coating overbuild.

Final coating dry film thickness should be 6 mils (150 microns) to 8 mils (200 microns).

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INSPECTION

Immediately following the application of the coating, visually inspect for pinholes and areas of missed coating.

Further inspection is to be performed once the coating has cured. Visually inspect the coating for discoloration, pinholes, and other visual defects. Mechanical removal and reapplication may be required depending on the defect type.

STORAGE & CLEAN UP

1) Use commercial solvents (Xylene, Methyl Ethyl Ketone) to clean tools immediately after use.

2) Once the coating is dry, the material must be abraded off.

3) Keep containers tightly sealed. For cleanup, use M.E.K. or a 50:50 blend of M.E.K. and Xylol.

4) Long term storage should be between 41°F (5°C) and 80°F (25°C). Store indoors. Keep dry.

5) Use product within 1 years of receiving. Once the product lid is opened it must be resealed tightly. The shelf life will be reduced to 3 months.

CURING PERFORMANCE

Force curing for 6 hours at 120°F (50°C) may be used to expedite chemical service. Spray temperature and substrate temperature will affect the coating cure time. The warmer the temperature the faster the reaction speed.

Curing Schedule	50°F 10°C	77°F 25°C	86°F 30°C
Dry to Touch	90 minutes	30 minutes	15 minutes
Dry to Handle	6 hours	3 hours	3 hours
Full Load Exposure	21 hours	11 hours	5 hours
Max. Recoat Time	**48 hours**		

SAFETY

Before using any products, please refer to the Safety Data Sheet (SDS). Follow standard confined space entry and work procedures, if appropriate.

Wear eye safety protection and full skin protection including chemical resistant gloves. Use NIOSH approved respirator where mist occurs.

In the event of welding or cutting by flame, dust and fumes will be emitted. Appropriate personal protective equipment and adequate ventilation is required.

Before applying this product, please refer to the Technical Data Sheet.

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