

SURFACE PREPARATION

Ensure that surface is clean, dry and uncontaminated. Precleaning of the surface is necessary in order to remove oil, wax or other foreign matter which may contaminate 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. Abrasive blast clean with angular abrasive media. **DO NOT USE** steel shot or non-angular media. For steel surfaces, blast to a Near White Metal Blast (SSPC-SP10; NACE 2; SA 2.5) with a minimum 3 mils (75 µm) depth profile. Blow down the surface before applying the coating to ensure it is free of dust and other loose contaminants.

For less severe service or emergency repairs, surface preparation by mechanical flapper wheel grinding (40 grit or coarser) and bristle blasting process is permitted. The surface must be clean with a rough profile of 2 mils (50 µm). Due to the slower rate of cleaning by mechanical means, these methods are ideally suited for smaller repair applications.

MIXING INSTRUCTIONS

Mixing Ratio	
Volume	3 part Resin (A) : 1 part Hardener (B)
Weight	4 part Resin (A) : 1 part Hardener (B)

This is a two-component system. **COMPLETE UNIT MUST BE MIXED AND APPLIED AT ONE TIME. DO NOT MIX PARTIAL QUANTITIES FROM CONTAINERS OR PROPER RATIOS MAY NOT BE OBTAINED.** Ensure product temperature is between 73-85°F (23-30°C), pre mix Resin Part A and Hardener Part B individually, be sure that any settled material at the bottom of the can is dispersed. Slowly pour the contents of the Hardener into the Resin while mixing.

Mix for 2 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. Excessive mixing speed will induce air into the mixture and is not recommended.

APPLICATION INSTRUCTIONS

1) Once mixed, begin application immediately - no induction time is needed. This product has a short working life and will develop exothermic heat due to the polymeric reaction. The higher the temperature and the larger the mass, the faster the product cure speed. Mixed contents may be portioned off into smaller containers to maintain pot life.

2) The product is applied with the application spreader provided. Work the material in a very thin layer to allow the polymer resin to “wet” out the surface to ensure proper adhesion. Once the surface is wet, begin to build up the coating to the desired thickness.

3) The product should be applied in a single layer. When additional thickness is required the coating must be abraded to allow for inter-coat adhesion.

INSPECTION

Immediately following the application of the coating visually inspect the coating for discoloration and areas of missed coating. These areas can be repaired immediately if the coating is tacky to touch.

Further inspection is to be performed once the coating has cured. Visually inspect the coating for discoloration, uncured coating, blisters, and other visual defects.

Mechanical removal and reapplication may be required depending on the defect type.

CURING PERFORMANCE

FOR CHEMICAL SERVICE THE COATING MUST CURE FOR A FULL 7 DAYS. Force curing for 6 hours at 120°F (50°C) may be used to expedite chemical service. Product temperature and substrate temperature will affect the coating cure time. The warmer the temperature the faster the reaction speed.

Curing Schedule	50°F	77°F	86°F
	10°C	25°C	30°C
Pot Life	20 minutes	15 minutes	10 minutes
Dry to Touch	2 hours	1 hour	30 minutes
Dry to Handle	7 hours	3.5 hours	2 hours
Full Load Exposure	13 hours	6.5 hours	3 hours
Max. Recoat Time	While material is soft		

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 time storage should be between 50°F (10°C) and 80°F (27°C).

DO NOT FREEZE.

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

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.

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

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

