

## 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. 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).

## MIXING INSTRUCTIONS

Mixing Ratio	
Volume	3 part Resin (A) : 1 part Hardener (B)
Weight	6 part Resin (A) : 1 part Hardener (B)

This is a two-component system. **COMPLETE MIXING OF THE UNIT IS RECOMMENDED.** Premix both components before use as settling will occur. Ensure product temperature is between 68 – 85°F (20 – 30°C).

Refer the mixing ratio above. Apply Resin Part A to a mixing board, apply the predetermined volume or weight of the Part B to the mixing board. **Mix for 45 seconds until a uniform color and consistency is achieved. 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 will have a short working pot life and will develop exothermic heat due to the polymeric reaction. Contents mixed may be portioned off into smaller containers to maintain pot life. The product may be applied by gloved hand or trowel. 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 specified thickness. Press down and work the coating as it is being applied to prevent air entrapment.

2) This product has a pot life of less than 25 minutes, this will decrease depending on the mass and temperature. The higher the temperature and the larger the mass, the faster the product cure speed.

3) This product does not have a recoat window. If a second layer of coating is to be applied over a cured Any additional coating that is to be applied over a cured film must be sanded to a rough texture to ensure adequate bonding on the second layer.

## 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

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	35 min	25 min	20 min
Dry to Touch	6 hours	4 hours	2 hour
Dry to Handle	12 hours	8 hours	6 hours
Full Load Exposure	24 hours	16 hours	12 hours
Max. Recoat Time	10 hours	8 hours	6 hours

The cure speed will be faster as the thickness of the coating increases and the exotherm of the reaction becomes hotter. The thinner the coating is applied the slower the curing speed.

**For chemical immersion of the coating, it is recommended that the coating cure for 24 hours to maximize it's performance in service.**

## 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 and store upside down. For cleanup, use M.E.K. or a 50:50 blend of M.E.K. and Xylol.
- 4) Store between 50°F (10°C) and 90°F (32°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.*

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