

Application Guide

Surface Preparation

metal coatings provide the maximum performance over near white blasted surfaces. There are, however, situations and cost factors, where grit blasting to near white metal is not possible. Bar-Rust Coatings were designed to provide excellent protection over less than optimum surface preparation.

The preparation recommended for Bar-Rust 235 Coating is to include removal of water, salt, dirt, oil, loose rust and all rust scales. The minimum standard for non-immersion service is Steel Structures Painting Council Standard SSPC-SP-2 or Swedish Standard S 0502. For immersion service, the minimum standard is SSPC-SP-3 or Swedish Standard S 0513. Where very rusty surfaces are encountered, use Pre-Prime 157 Sealer before application of Bar-Rust 235 Coating.

Mixing and Thinning

Bar-Rust 235 Coating is a two component product supplied in 5 Gallon and 1 Gallon kits which contain the base and converter portions. The contents of each container must be mixed together. Power mix the base portion first to obtain a smooth, homogeneous consistency. Then, in the base portion, add the converter slowly with continued agitation. After the converter add is complete, continue to mix the coating. Bar-Rust 235 Coating requires a 15 minute induction time.

solvents are already required or desired; however, at lower temperatures, small amounts (10% or less) of the solvents on the reverse page may be added depending on local VOC and air quality regulations. Any solvent addition should be made after the two components are mixed.

The recommended cure time is 8 hours at 77°F (25°C). Higher temperatures will reduce working life of the coating. Lower temperatures will increase cure time.

Ventilation

In addition to the safety of the applicator and the proper performance of the Bar-Rust 235 Coating that good ventilation is essential in any enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapors. If the vapors are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as being equipped with fans. Ventilation should be provided throughout the cure period to insure all the solvents are removed from the coating. For permanent installations it is essential that full ventilation be maintained for seven days.

Application

Bar-Rust 235 Coating can be applied by both conventional air spray and airless spray equipment.

For spray application, a fluid tip of .070" to .088" (DeVilbiss E and Q tips) and an air cap with good break-up such as DeVilbiss 1000 or 1001 are recommended for good results. The fluid pressure should be kept low, with just enough air pressure to get good break-up of the coating. Excessive air pressure can cause overspray problems.

When airless equipment is used, a 30 to 1 pump and .021" to .025" tip size will provide a good spray pattern. Heavy fluid hoses should not be used. Hoses should be 3/8" ID and not longer than 50 feet to obtain optimum results.

Bar-Rust 235 Coating may also be applied by brush or roller. Care should be taken that proper and uniform film thicknesses are obtained.

Two coats of Bar-Rust 235 Coating at 5 to 6 mils per coat, plus two stripe coats over sharp edges, cutouts and welds. Allow 15 minutes for each coat and stripe coat.

Undercoats should be applied over Bar-Rust 235 Coating before the Bar-Rust 235 Coating has cured hard.

Precautions

See the material safety data sheet and product label for complete safety and precaution requirements.

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