

SELECTION DATA

GENERIC TYPE: Two component polymeric epoxy amido-amine.

GENERAL PROPERTIES: Rustbond Penetrating Sealer ZA is a crosslinking penetrating sealer with excellent wetting properties. It is highly flexible with good chemical and solvent resistance, and accepts a variety of topcoats.

- Universal primer and tie coat
- Provides excellent adhesion to ISO 8501 St2 prepared steel
- Compatible with a variety of topcoats
- Extremely high solids
- Low odour
- Meets the most stringent VOC (Volatile Organic Content) regulations
- Provides 25 - 50 μ film build
- Contains corrosion inhibitors
- Green tint improves visibility

RECOMMENDED USES: Developed specifically for use as a sealer for marginally prepared steel and over old coatings. Its excellent wetting properties allow it to penetrate rust and discontinuities in existing coatings to provide a firm anchorage for a variety of topcoats. Its thixotropic character reduces run off, ensuring that the edges of existing coatings are covered thus reducing undercutting and peeling.

It may also be used as a primer for various non-ferrous metals, including aged and new galvanised steel which is free of white rust, inhibiting chemicals or oils. May also be used as a tie coat for coatings that have exceeded their "recoat window". Consult StonCor Africa Technical Services Department for specific recommendations.

NOT RECOMMENDED FOR: Immersion service, or any application without a topcoat.

CHEMICAL RESISTANCE GUIDE (with suitable topcoat):

<u>Exposure</u>	<u>Spillage</u>	<u>Splash and Fumes</u>
Acids	Excellent	Excellent
Alkalies	Excellent	Excellent
Solvents	Good	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

TEMPERATURE RESISTANCE (non-immersion):

Continuous:	80°C
Non-continuous:	93°C

SUBSTRATE: Apply over steel prepared to ISO 8501 ST2, aluminium, galvanised or others as recommended.

COMPATIBILITY WITH OTHER COATINGS: May be applied over most coatings. May be topcoated with most epoxies, polyurethanes, drying oils, alkyds and acrylics.

March 2012 SA replaces June 2010 SA

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL:

Rustbond Penetrating Sealer ZA	<u>By Volume</u> 98% \pm 2%
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VOLATILE ORGANIC CONTENT:

The following are nominal values:

As supplied:	24 g/l
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Do not thin

RECOMMENDED DRY FILM THICKNESS PER COAT:

25 - 50 microns

Puddles on horizontal surfaces should be minimised.

THEORETICAL COVERAGE:*

39.0 m²/l at 25 microns

19,5m²/l at 50 microns

***NOTE:** Mixing and application losses will vary and must be taken into consideration when estimating job requirements.

STORAGE CONDITIONS (store indoors):

Temperature:	4-43°C
Humidity:	0-90%

SHELF LIFE: 24 months minimum when stored at 25°C.

COLOURS: Green

GLOSS: High. Chalks rapidly in sunlight

ORDERING INFORMATION

Prices may be obtained from StonCor Africa Sales Representative or Main Office.

APPROXIMATE SHIPPING WEIGHT:

Rustbond Penetrating Sealer ZA	<u>2 L Kit</u> 2,5 kg
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FLASH POINT (Pensky-Martens Closed Cup):

Rustbond Penetrating Sealer ZA Part A	96°C
Rustbond Penetrating Sealer ZA Part B	80°C

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

SURFACE PREPARATION: Remove any oil or grease from surface to be coated prior to abrasive blast or power tool cleaning to a minimum standard of ISO 8501 St 2.

For galvanised surfaces wash with Carboclean 250 and rinse thoroughly. Solvent wiping is not recommended.

A test patch is recommended to verify compatibility with existing coatings, to evaluate the adhesion to any existing coating and the adhesion of existing coatings to the substrate.

MIXING: Slowly mix the part A, then add the Part B. Keep the mixing blade at low speed and submerged in the product to minimise whipping of air into the material. Mix to blend thoroughly. Scrape the sides of the container occasionally to ensure uniformity. Continue to mix for 1-2 minutes.

Mix in the following proportions.

Rustbond Penetrating Sealer ZA PT A	1 part by vol
Rustbond Penetrating Sealer ZA PT B	1 part by vol

THINNING: Thinning is recommended for spray applications to previously unpainted surfaces only. Please contact StonCor Africa Technical Service for specific instructions.

POT LIFE: (Minutes in 2l quantities)

<u>Temperature</u>	<u>Rustbond Penetrating Sealer</u>
21°C	80
27°C	50
32°C	40
38°C	30

CAUTION: This product exotherms at the end of its potlife. Any unused quantities may become extremely hot and may generate smoke and fumes. The material begins to thicken at the end of its potlife which is an indication of the onset of exotherm. Immediately spread out on an appropriate surface or add sand or other suitable heat sink to the unused material to reduce the severity of the exotherm. Take appropriate precautions against breathing fumes.

APPLICATION TEMPERATURES:

	<u>Material*</u>	<u>Surfaces</u>
Normal	21-32°C	27-38°C
Minimum	16°C	21°C
Maximum	32°C	48°C

	<u>Ambient</u>	<u>Humidity</u>
Normal	27-38°C	0-90%
Minimum	21°C	0%
Maximum	43°C	90%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special application techniques may be required above or below normal conditions.

SPRAY: May be applied by airless or plural component. Please contact StonCor Africa Technical Service for specific application instructions.

BRUSH: Distribute evenly using full brush strokes.

ROLLER: Use a roller suitable for solvent based materials, to evenly distribute the material. Nap length will depend on the roughness of the substrate.

Apply only enough material to uniformly wet the surface. Any puddles formed must be brushed out.

DRYING TIMES: These times are at the recommended dry film thickness of 25-50µm.

<u>Temperature</u>	<u>To Handle/ Topcoat Time</u>	<u>Final Cure</u>
21°C	34 hrs	9 days
26°C	22 hrs	6 days
32°C	14 hrs	4 days
38°C	11 hrs	3 days

Maximum Recoat Times @ 24°C

Water Borne Coatings :	2 days
Solvent Borne Coatings :	5 days

Please contact StonCor Africa Technical Service for specific instructions if these recoat times are exceeded.

CLEAN UP: Use Carboline Thinner # 2.

CAUTION: READ AND FOLLOW ALL CAUTION STATEMENTS ON THIS PRODUCT DATA SHEET AND ON THE MATERIAL SAFETY DATA SHEET FOR THIS PRODUCT.

CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.



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