



SPI COATINGS

PROVEN PERFORMANCE • REAL WORLD SOLUTIONS

RUST GRIP®-E

INSULATION
AND
CORROSION
SPECIALISTS

Application Instructions (7/10/19)

RUST GRIP-E is a two-part epoxy coating system that has been designed with specific additives to promote adhesion when used on metal and contains metal pigment to strengthen coating and retard chalking. RUST GRIP-E was developed to be applied to metal surfaces that cannot be dry enough to use standard RUST GRIP®. It can be used directly to wet or damp metal surfaces and maintain excellent adhesion to prevent further surface corrosion. It is a water repelling epoxy for use under water or in areas where constant splashing or condensation is a problem. It is resistant to chemicals and solvents and is designed to can be applied directly to concrete, masonry and metal.

SURFACE PREPARATION

Surface must be clean from oil, tar, rust, grease, salts, and films.

- 1) Use general degreaser if needed.
- 2) Clean surface using TSP (tri-sodium-phosphate) or a citrus cleaner to release dirt and degreaser residue.
- 3) Pressure-wash if possible @ 3500 psi.
- 4) Salt contamination on a surface can come as a result of salt water, fertilizers, and car exhaust. Use Chlor-Rid or equivalent to decontaminate surface if salts are present. Acceptable levels: Nitrates: 5-10 mcg/cm², Sulfates: 5-10 mcg/cm², Chlorides: 3-5 mcg/cm².

Surface should be as dry as possible before applying.

- 1) RUST GRIP-E must be applied during proper temperatures (below) and the prescribed overcoat window of the coating over which it will be applied.
- 2) If applied over an existing coating having a glossed or shiny finish, it must be sanded and roughed to remove gloss before application, to improve the profile.
- 3) Additional coats of RUST GRIP-E can only be applied when the 1st coat becomes tacky to the touch and has little to no transfer of coating. If the first coat is allowed to cure more than 3 days to where it is not tacky, the surface must be lightly sanded to make it rough before the second coat is applied.

MIXING

- 1) Open pail, mix base with matched curing agent (4 parts base:1 part curing agent) (ratio by volume, not by weight)
- 2) Mix by hand for two minutes, or using drill and mixing blade for a minimum of 30 seconds with NO vortex.

TEMPERATURE

- 1) Apply between 40°F (4°C) and 150°F (65°C).
- 2) Maximum temperature for use when cured is 400°F (205°C). See tech sheet.
- 3) Store unmixed product between 40°F (4°C) and 100°F (38°C) according to hazmat standards on MSDS.

POT LIFE

4-6 hours at 70°F (21°C) - 1 hour at 90°F (32°C)

APPLICATION

RUST GRIP-E can be applied by brush, roller or airless sprayer; however, the preferred method is by airless sprayer.

- 1) If application is by brush, use a soft bristle brush.
 - 2) If application is by roller, use a 1/2 inch nap roller.
 - 3) If application is by spray, use a standard airless sprayer (1.5 gallons/minute at 3,300 psi) with a .017-.021 tip.
- **NOTE:** The number of applications and the thickness of each should be in accordance with the job specifications.

MINIMUM SPREAD RATES (mil thickness)

Wet Surfaces – Apply 1st application at 200 sq ft/gallon (18 sq mtr/gallon; use a roller to force coating into pores); 8 mils wet/4 mils dry (to penetrate into pores.) Allow 4 hours to dry and ventilate well, then apply 2nd application of 100% RUST GRIP-E at 200 sq ft/gallon; 8 mils wet, 4 mils dry. Wait 24 hours and apply the last coat of RUST GRIP-E at 200 sq ft/gallon.

Dry Surfaces – Apply one coat (8 mils wet/4 mils dry/18 sq.mtr./gallon-200 microns wet/100 dry).

CURE TIME

Note: Surface and ambient temperatures will determine cure time which is normally 14 full days. Introduction of heat over surface will enhance the cure time.

Induction Period: 10 minutes at 70°F (21°C); No induction time is necessary over 90°F (32°C).

NOTE: It is critical that each coat of RUST GRIP-E be firmly adhered to the substrate before the next coat is applied. Depending on ambient and surface temperatures, it may take longer than a 24 hour recoat application window.

NOTE: May use MEK to reduce, if needed.

CLEAN-UP EQUIPMENT

- 1) After completion, spray systems should be flushed and cleaned with MEK or other comparable solvents.
- 2) After completion, brushes and rollers can be cleaned with MEK or comparable solvents, stored and reused.