

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy phenalkamine
Description	Rustbond NG is a cross-linked penetrating primer/sealer with good wetting properties. It is highly flexible and accepts a variety of topcoats. Recommended use as primer/sealers for marginally prepared steel and over old coatings. Its excellent wetting properties allows it to penetrate rust and discontinuities in existing coatings and provide a firm anchorage for a variety of topcoats. Its thixotropic properties reduces the runoff; thus, the edges of the existing coating are properly encapsulated, reducing underlying corrosion and peeling. This product can also be used as a tack coat when a coating exceeds its "maximum recoating time". Consult Carboline Technical Service for specific recommendations.
Features	<ul style="list-style-type: none"> • Universal primer and tie-coat. • Cures down to 2°C (36°F). • Excellent adhesion to SSPC-SP 2 / St2 prepared steel, galvanized steel, aluminum, stainless steel or copper. • Flexible film. • High solids. • Low odor. • Contains corrosion inhibitors. • Compatible with a variety of topcoats. • User friendly application by brush and roller. • Low VOC
Color	Translucent yellow.
Finish	Gloss
Primer	Self-priming. May be applied over most generic types of coatings.
Dry Film Thickness	25 - 51 microns (1 - 2 mils) per coat
Solids Content	By Volume 90% +/- 2%
Theoretical Coverage Rate	35.4 m ² /l at 25 microns (1444 ft ² /gal at 1.0 mils) 17.7 m ² /l at 50 microns (722 ft ² /gal at 2.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : 80 g/l Thinner 76 : thinned at 7% by volume: 150g/l These are nominal values
Dry Temp. Resistance	Continuous: 79°C (174°F) Non-Continuous: 93°C (199°F) Discoloration and loss of gloss is observed above 80°C.
Limitations	<ul style="list-style-type: none"> • Epoxies lose gloss, discolor and chalk in sunlight exposure. • Rustbond sealers must be topcoated.
Topcoats	Acrylics, Alkyds, Epoxies, Polyurethanes.

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Steel	SSPC-SP2 or SP3, or St2/St3 according to ISO 8501-1
Galvanized Steel	SSPC-SP1 - Clean properly and remove any zinc oxides and zinc salts.
Previously Painted Surfaces	A test patch is recommended to verify compatibility with existing coating. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 adhesion test, or ISO 16276-2 Level 3.

MIXING & THINNING

Mixing	Power mix components separately to break down any gel. Keep the mixing blade at slow speed and submerged in the product to minimize whipping of air into the material. Scrape the sides of the container occasionally to insure uniformity. Continue to mix for 1-2 minutes. DO NOT MIX PARTIAL KITS.
Thinning	Thinning not normally required but may be thinned up to 7% with Thinner #76. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether express or implied.
Ratio	By volume: 1/1 - Part A/B
Pot Life	For 2 Liters sample: - 30 min at 30°C - 1 h at 20°C Pot life ends when material begins to thicken and exotherm.

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss et Graco.
Spray Equipment	Contact Carboline Technical Service for specific application instructions.
Brush & Roller (General)	Avoid excessive re-brushing or re-rolling. Apply enough material to uniformly wet the surface. <u>Any puddles formed must be brushed out.</u>
Brush	Use a medium bristle brush and distribute evenly using full brush strokes.
Roller	Use a medium to long nap roller suitable for solvent base materials to evenly distribute the material.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	30°C (86°F)	45°C (113°F)	38°C (100°F)	90%

This product requires the substrate temperature to be 3°C above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat	Final Cure
5°C (41°F)	40 Hours	24 Hours	3 Days
10°C (50°F)	36 Hours	20 Hours	3 Days
20°C (68°F)	24 Hours	16 Hours	2 Days
30°C (86°F)	16 Hours	10 Hours	2 Days

These times are based on 50% relative humidity and 25-50 microns dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing.

Maximum overcoating by epoxy is 30 days. After 30 days, a light surface preparation is needed, using sand paper to abrade the surface.

CLEANUP & SAFETY

Cleanup	Use Thinner#2 or Thinner#76. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions.
Ventilation	When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.
Caution	THIS PRODUCT EXOTHERMS AT THE END OF ITS POT LIFE. Any unused quantities will become hot (70°C). Immediately spread out on an appropriate surface or add sand or other suitable heat sink to the unused material to reduce the severity of exotherm. Take appropriate precautions against breathing fumes. This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A & Part B: Min. 24 months at 24°C (75°F) Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
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Rustbond NG

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Storage Temperature & Humidity | 4°-43°C
0-90% Relative Humidity

Flash Point (Setaflash) | Part A : 96°C
Part B : 27°C

Storage | Store Indoors

Packaging | 5 Liters Kit

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.