

RUST O CAP MIO

PRODUCT DESCRIPTION

Two components, high build, surface tolerant, polyamide adduct cured epoxy coating pigmented with aluminium and lamellar micaceous iron oxide

FEATURES & RECOMMENDED USE

- High performance maintenance coating for coastal & industrial polluted environment
- Self-priming; eliminates the usage of primer
- Recommended on hand or power tool cleaned rusted steel
- Suitable for exposure to dry heat up to 150°C and corrosion protection of steel under thermal insulation
- Enhanced corrosion resistance due to combination of aluminium and MIO pigments
- Good flexibility for long term performance
- Can be applied over prepared stainless steel surface
- Good adhesion to aged and sound epoxy, polyurethane and conventional alkyds
- Can be over coated with most two component paints
- Also available in glass flake version

TECHNICAL DATA

Colour	Aluminium
Gloss	Eggshell
Volume Solids	Approx. 80 %
Recommended DFT / Coat	75 – 150 µm (200 µm for glass flake version)
Theoretical Coverage Capacity	10.6 sq.mtr/ltr @ 75 µm DFT 5.3 sq.mtr/ltr @ 150 µm DFT
Drying time at 30°C	Surface Dry : 6 hours Hard Dry : 9 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 9 hours Max. : 1 Month, provided surface is dry and clean from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity

DIRECTIONS FOR USE

Surface Preparation

General

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification. In case oxidation has occurred between blasting and application of Rust O Cap MIO, the surface should be re-blasted
- A blasting profile of (Rz) 50-60 µm is recommended

Steel

For atmospheric exposure condition

- New hot-rolled steel; blast cleaned to min Sa 2 of Swedish specification
- Weathered steel; power tool cleaned to St 3 or hand tool cleaned to St 2
- Existing sound epoxy coating system and sound alkyd coatings; sufficiently roughened, dried, and cleaned
- High pressure fresh water washing or scrubbing to remove loose paint and contamination. Intact areas to be roughened. Damaged and rusty areas to be derusted to minimum St3 /St2 by power tool / hand tool cleaning

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Rust O Cap MIO is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 4 : 1
Induction Time	None
Pot Life at 30°C	2 hours

Application

Airless Spray	
Recommended thinner	T 131
Volume of thinner	5 – 15 % *
Nozzle orifice	0.53 – 0.66 mm (21 – 26 Thou)
Nozzle pressure	20 – 24 MPa (approx. 200 – 240 atm; 2800 – 3400 p.s.i.)
Cleaning Thinner	T 141
Brush	
Recommended thinner	T 141
Volume of thinner	0 – 10 % *

Note: 1) Air spray is generally not recommended. For touch up of small and inaccessible area air spray can be done.
2) Depending on recommended thickness & application conditions*

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Special Instruction

- Surface discoloration may occur upon exposure to sunlight, elevated temperatures or chemicals. However, this does not impact anti-corrosive performance
- Not recommended for immersion services in acids, alkali & solvents
- A test patch is recommended over non-ferrous metals and adhesion to be checked as per ASTM D 3359 to confirm suitability

Product Characteristics

- Maximum film build in one coat is best attained by airless spray. By brush application typical 75 µm is achieved in one coat and multiple coats will be required to achieve the total specified thickness
- Can be applied to substrates with surface temperature up to 100°C. In these circumstances, rapid application of multiple coats is necessary to achieve correct dry film thickness
- Performance will depend on the degree of surface preparation. For good anti-corrosive performance, a minimum of 200 microns is recommended
- Full cure period must be allowed prior to subjecting coating system to service condition
- The maximum performance is achieved after complete curing
- A minimum of two coats application is recommended over prepared steel for optimum performance
- As common to all epoxy, the product will chalks and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

PACK SIZE	20 L (Base: 16 L ; Hardener: 4 L)
STORAGE	Shelf Life: At least 12 months at 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash Point: Base : Not less than 24°C Hardener : Not less than 24°C VOC: Approx. 190 ± 20 gm/ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.42 ± 0.05 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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