

ABBREVIATED APPLICATION INSTRUCTIONS 5 kg PACK ONLY

SURFACE PREPARATION

Minimum standard required: Sa 2 (grit blasting), St 3 (mechanical) or WJ-2 (water jetting).

These standards refer to the standard of cleanliness of the surface from all forms of contamination. This basically means that all loose rust or old paint and contaminants are removed.

It is essential that the entire surface to be coated is washed with potable water to remove any salt residues.

MIXING (5 kg pack)

Empty the entire content of the plastic bottle (HF 500M part B hardener) into the metal container (RA 500M part A resin) and mix thoroughly using a clean stick or a power mixer. No measurement is necessary.

Do **NOT** part mix. (You can divide the product after mixing the total amount, if required).

Mix thoroughly, paying particular attention to side and bottom of the container. Continue mixing until you achieve a homogenous, streak-free, consistent mix (approximately 1 minute).

Apply the material as soon as possible.

IT IS IMPORTANT TO NOTE THAT THESE PRODUCTS HAVE A LIMITED POT LIFE (approximately 1 hour).

Please note that the pot life given is for 15 - 20°C and if the temperature is higher or lower, the pot life will become shorter or longer respectively.

If gelling has started or the viscosity is increased substantially, the product should **NOT** be used any further.

APPLICATION

Apply the mixed material using good quality brushes and with some pressure, unlike applying conventional low viscosity paint systems when no pressure is applied. Apply the coating to a thickness of about 200 - 300µ in one coat (or as specified). Normally no additional coats are required/necessary.

Application of further coats, if required, can proceed as soon as the first coat is touch dry. There is no over-coating restriction as long as the surface is cleaned from any contamination.

When applying on a rough or pitted surface, ensure the peaks are covered. The applied film must be closed and continuous without any pin holes or exposed metal especially on the sharp edges and weld seams.

After the application, clean all equipment with a suitable solvent (S11A) and dry with a clean cloth.

Please refer to the full Application Instruction for airless spray applications

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