

## Selection & Specification Data

<b>Generic Type</b>	Polymeric epoxy amine
<b>Description</b>	Rustbond is a cross-linked penetrating primer/sealer with excellent wetting properties. It is highly flexible with good chemical and solvent resistance, and will accept a variety of topcoats. Recommended use as primer/sealer for marginally prepared steel and over old coatings. The excellent wetting properties allows it to penetrate rust and discontinuities in existing coatings and provide a firm anchorage for a variety of topcoats. The thixotropic character reduces run off, ensuring that the edges of existing coatings are encapsulated thus reducing undercutting and peeling. Rustbond may also be used as a tie-coat for coatings that exceed their "recoat window." Consult Carboline Technical Services Department for specific recommendations.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Universal primer and tie-coat</li> <li>• Cures down to 10°C**</li> <li>• Excellent adhesion to hand-tool prepared steel, galvanizing, aluminium, stainless steel and copper</li> <li>• Low stress, highly flexible film</li> <li>• Extremely high solids</li> <li>• Low odour</li> <li>• Contains specialised corrosion inhibitors</li> <li>• Compatible with a variety of topcoats</li> <li>• User friendly brush and roller application</li> <li>• VOC compliant to current AIM regulations</li> </ul>
<b>Colour</b>	Translucent Green (0300)
<b>Finish</b>	High gloss (films over 40 microns). Chalks rapidly in direct sunlight
<b>Primers</b>	Self-priming. May be applied over most generic types of coatings.
<b>Topcoats</b>	Acrylics, Alkyds, Epoxies, Polyurethanes, drying oils
<b>Dry Film Thickness</b>	25 – 50 microns. Optimum 40 microns NOTE: To avoid extended cure times do not exceed 40 microns DFT over sealed surface at temperatures below 15°C
<b>Solids Content</b>	99% ± 1%
<b>Theoretical Coverage Rate</b>	40 m <sup>2</sup> per litre at 25 microns DFT 25 m <sup>2</sup> per litre at 40 microns DFT
<b>Mix Ratio</b>	1:1 by volume (Part A : Part B)
<b>VOC Values</b>	As supplied: 85 g/l EPA Method 24: 228 g/l **Thinned 15% w / Thinner #2: 178g/l These are nominal values.
<b>Dry Temp. Resistance</b>	Continuous: 80°C Non-Continuous: 93°C

## Selection & Specification Data continued

<b>Limitations</b>	Epoxies lose gloss, discolour and eventually chalk in sunlight exposure Do not use for immersion service Rustbond sealers must be topcoated
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## Substrates & Surface Preparation

<b>General</b>	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. <b>**The surface temperature should be 10°C or more – in maintenance situations in cooler conditions "work with the sun" to ensure the surface is 10°C or more at the time of application and for a minimum 2 hours thereafter.</b> Refer to red cautionary notes in "Mixing and Thinning", "Application Conditions", and "Curing Schedule" overleaf.
<b>Steel</b>	Hand or power tool clean.
<b>Galvanized Steel</b>	Hand or power tool clean.
<b>Concrete</b>	Not normally recommended – refer to Carboguard <sup>®</sup> 1340.
<b>Previously Painted Surfaces</b>	A test patch is recommended to verify compatibility with existing coating. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

## Application Equipment

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. **General Guidelines:**

<b>Spray Application (General)</b>	Contact Carboline Technical Service for specific application instructions
<b>Brush &amp; Roller (General)</b>	Avoid excessive re-brushing or re-rolling. Apply enough material to uniformly wet the surface. Any puddles formed must be brushed out.
<b>Brush</b>	Use a medium bristle brush and distribute evenly using full brush strokes.
<b>Roller</b>	Use a short to medium nap roller, suitable for solvent base materials, to evenly distribute the material. Avoid excessive thicknesses.

## 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, and do not intermix unpaired components.  
**It is recommended to pre-warm each component to 15°C to 21°C**

**Ratio** 1:1 by volume (Part A : Part B)

**Thinning** Ambient, Surface & Material Temperatures above 15°C  
 Thinning not normally required for Rustbond, but may be thinned up to 5% with Thinner #2. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether express or implied.

**\*\*Ambient, Surface & Material Temperatures above 10°C and less than 15°C**  
 To reduce viscosity and minimise risk of overbuild above 40 microns DFT it is recommended to thin Rustbond 5% to 10% with Thinner #2.

**Pot Life** 2 litre mix – unthinned:  
 80 minutes at 21°C  
 50 minutes at 27°C  
 40 minutes at 32°C  
 30 minutes at 38°C  
 Pot life ends when material begins to thicken and exotherm.

## Cleanup & Safety

**Cleanup** Use Thinner #2 or Acetone. 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 MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

**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 vapour concentration from reaching the lower explosion limit for the solvents used.

**Caution** This product exotherms at the end of its pot life. Any unused quantities will become extremely hot. Immediately spread out the unused material 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 may contain flammable solvents. Keep away from sparks and open flames.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	21° - 32°C	27° - 28°C	21° - 38°C	0 – 80%
Minimum	16°C (10°C)**	15°C (10°C)**	15°C (10°C)**	0
Maximum	38°C	54°C	43°C	90%

**\*\*Refer to Surface Preparation, Mixing and Thinning notes**

## Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle	Dry to Topcoat	Final Cure
10°C	48 hours**	24 hours**	12 days**
21°C	34 hours	18 hours	9 days
26°C	22 hours	12 hours	6 days
32°C	13 hours	9 hours	4 days
38°C	11 hours	4 hours	3 days

**\*\*Refer to Surface Preparation, Mixing and Thinning & Application Conditions.**

These times are based on a 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. Thicknesses over 40 microns at temperatures below 16°C should be avoided. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discolouration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. During high humidity or cooler conditions, it is recommended that the application be done while temperatures are increasing.

## Recoating Schedule

Surface Temp. & 50% Relative Humidity	Maximum Recoat Time – Epoxies & Urethanes	Maximum Recoat Time – Acrylics & Alkyds
10°C	30 days	14 days
24°C	30 days	14 days
32°C	15 days	7 days

## Packaging, Handling & Storage

**Pack Sizes** 2 litre kit – 1 litre Part A + 1 litre Part B

**Flash Point (Setaflash)** Rustbond Part A: 96°C  
 Rustbond Part B: 80°C

**Storage Temperature & Humidity** Store under cover  
 4°-43°C  
 0-90% Relative Humidity

**Shelf Life** Part A & B: Min. 36 months at 24°C

**\*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**

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