Rustbond PS

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Proprietary epoxy blend
Description	Rustbond PS is a very low VOC epoxy primer/sealer that combines outstanding surface tolerance characteristics over marginally prepared substrates and user-friendly features. It accepts a variety of topcoats and can help save time and money by minimising surface preparation requirements for new construction, maintenance and overcoating projects. Rustbond PS has good pot life at higher temperatures to help minimise waste and also cures at low temperatures down to 1.7°C with Epoxy Accelerator so you have one Rustbond product for year-round application.
Features	• Excellent wicking characteristics resulting in very good adhesion to a variety of substrates • Low stress during application and cure, can be applied over aged coatings and tight rust • Universal primer and tie-coat • Very low VOC, less than 100 g/l, and low odour for compliance in many stringent locations • Low temperature cure with Epoxy Accelerator to extend the painting season • Good pot life in hotter weather without Epoxy Accelerator, one Rustbond PS for year-round application • User-friendly application with brush, roller, and spray • Tolerates higher dry film thickness (DFT) range, easier to apply • Excellent sealer for metallising and thermal sprayed aluminium (TSA)
Colour	Translucent Green (0300)
Finish	Gloss
Primer	Self-priming. May be applied over most generic types of coatings.
Film Build	25 - 75 microns dry
Solid(s) Content	By Volume 90% +/- 1%
Theoretical Coverage Rates	18 m² per litre at 50 microns dry Allow for loss in mixing and application.
VOC Value(s)	**As Supplied** : 96 g/l EPA Method 24 These are nominal values
Dry Temp. Resistance	Continuous: 79°C (174°F) Non-Continuous: 93°C (199°F)
Limitations	• Rustbond PS must be topcoated • Not recommended for immersion service • Not approved for Fireproofing materials
Topcoats	Water borne acrylics, alkyds, epoxies, polyurethanes, polyaspartics, polysiloxanes, etc. Consult your Carboline Sales Representative for specific recommendations

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Remove contaminants in accordance with SSPC-SP 1 (AS 1627.1).

SUBSTRATES & SURFACE PREPARATION

Steel	Minimum Hand Tool Clean or Power Tool Clean in accordance with SSPC-SP 2 (AS 1627.2 St 2) or SSPC-SP 3 (AS 1627.2 St 3).
Galvanised Steel	Clean to remove contaminants in accordance with SSPC-SP 16.
Aluminium	Clean to remove contaminants in accordance with SSPC-SP 16.
Concrete or CMU	Concrete shall be designed, placed, cured, and prepared per NACE No. 6/SSPC-SP 13 latest edition. Abrade to remove all laitance, loose concrete, etc. and to create a surface profile in accordance with the appropriate ICRI CSP standard for the coating system. This product will penetrate into the pores of the concrete and should be applied at approximately 18 square metres per litre.
Stainless Steel	Clean to remove contaminants in accordance with SSPC-SP 1.

MIXING & THINNING

Mixing	Power mix components separately at low speed to avoid whipping air into the product. Continue mixing until all solids are mixed into suspension. Scrape the sides of the container occasionally to ensure uniformity. Combine the two components together in the Part A container and continue mixing for 1-3 minutes until components are thoroughly mixed together with a uniform consistency. DO NOT MIX PARTIAL KITS.
Thinning	Thinning is not normally required. May be thinned up to 5% with Thinner #76 to help with atomisation when spraying. Use of thinners other than those recommended and supplied by Carboline may adversely effect product performance and void product warranty, whether expressed or implied.
Ratio	2:1 Ratio (A to B) **3 Litre Kit** Part A: 2 litres in a 4 litre can Part B: 1 litre can
Pot Life	3 hours at 4°C *With Epoxy Accelerator 90 minutes at 21°C 70 minutes at 21°C *With Epoxy Accelerator 75 minutes at 32°C Pot life ends when material begins to thicken. *Epoxy Accelerator can be added at a rate of 45 ml per mixed 3 litre kit to speed the cure at temperatures at or below 21°C. See the Curing Schedule.

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 (General)	This high solids product builds dry film thickness very fast. Thinning up to a maximum 5% with Thinner #76 will help with atomisation. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss, Graco, etc.

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.

Airless Spray	Pump Ratio: 30:1 (min. recommended)* GPM Output: 3.0 (min. recommended) Output Pressure: 2,000-2,400 psi (138-165 bar) Material Hose: 3/8" I.D., (0.95 cm) min. recommended Tip Size: 0.011 - 0.015" (0.03 - 0.04 cm) recommended *PTFE packings are recommended and available from the equipment manufacturer.
Brush & Roller (General)	Avoid excessive brushing or rolling. Apply enough material to uniformly wet out the surface and do not apply excessive thickness.
Brush	A high quality bristle brush is recommended.
Roller	A high quality, shed resistant and solvent resistant medium nap roller cover is recommended.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	32°C (90°F)	43°C (109°F)	38°C (100°F)	90%

This product simply requires the substrate temperature to be above the dew point. During high humidity conditions it is recommended that the application be done while temperatures are increasing. Condensation forming on uncured coating due to substrate temperatures below the dew point can cause amine blush to form. Amine blush must be removed by washing with clean potable water before top coating. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Topcoat Minimum	*Minimum Dry To Topcoat With Epoxy Accelerator	Maximum Recoat Time Acrylics & Alkyds	Maximum Recoat Time Epoxies & Urethanes
2°C (36°F)	NR	16 Hours	14 Days	30 Days
10°C (50°F)	NR	10 Hours	14 Days	30 Days
16°C (61°F)	11 Hours	5 Hours	14 Days	30 Days
21°C (70°F)	6 Hours	5 Hours	14 Days	30 Days
32°C (90°F)	4 Hours	NR	7 Days	15 Days
38°C (100°F)	2.25 Hours	NR	5 Days	10 Days

These times are based on 50% relative humidity and 50 microns dry film thickness. Higher film thickness, insufficient ventilation and/or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.
*At temperatures below 21°C Altex Epoxy Accelerator can be added at a rate of 45 ml per mixed 3 litre kit of Part A and B to speed up the cure time.

CLEANUP & SAFETY

Cleanup	Use Thinner #76, 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 SDS for this product. Employ normal workmanlike safety precautions.

CLEANUP & SAFETY

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. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use suitable approved respirator.
Caution	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 relevant local electrical standards. 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 & B: Min. 24 months at 24°C When kept indoors and in original unopened containers.
Shipping Weight (Approximate)	3 Litre Kit - 13.3 kg
Storage Temperature & Humidity	4-43°C 0-90% Relative Humidity
Flash Point (Setaflash)	Part A: 63°C Part B: 71°C
Storage	Store indoors

WARRANTY

Manufactured and / or distributed in Australia & New Zealand by Altex Coatings under license to Carboline Company. 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 Altex Coatings 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 or injuries resulting from use. Liability, if any, is limited to replacement of products. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY ALTEX COATINGS OR 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.
Altex Terms and Conditions of Trade, available at www.altexcoatings.com, apply in respect of all coating products and materials supplied, including samples.