

Epoxy

PRODUCT DESCRIPTION

Bar-Rust 234P is a thick-film, 100% solids, proprietary formulated epoxy based low temperature cure tank lining.

INTENDED USES

Designed as a storage tank lining for water applications. Bar-Rust 234P is plural component spray applied from 25-50 mils (625-1250 microns) DFT.

PRACTICAL INFORMATION FOR BAR-RUST 234P

Color	Off White, Buff
Gloss Level	Semi-gloss
Volume Solids	100%
Typical Thickness	25-50 mils (625-1250 microns) dry equivalent to 25-50 mils (625-1250 microns) wet
Theoretical Coverage	49 sq.ft/US gallon at 32.5 mils d.f.t and stated volume solids 1.23 m ² /liter at 812.50 microns d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Plural Component Airless Spray

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating interval with self	
			Minimum	Maximum
35°F (2°C)	7 hours	24 hours	5 hours	7 days
77°F (25°C)	4 hours	5 hours	3 hours	7 days
104°F (40°C)	60 minutes	60 minutes	60 minutes	5 days

REGULATORY DATA

Flash Point (Typical) Part A 199°F (93°C); Part B 199°F (93°C); Mixed 199°F (93°C)

Product Weight 13.4 lb/gal (1.61 kg/l)

VOC 0.12 lb/gal (15 g/l) EPA Method 24

See Product Characteristics section for further details

Epoxy

SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease, foreign matter and be structurally sound. Remove all loose paint, mortar spatter, mill scale, and rust.

Surfaces should be cleaned to SSPC-SP1.

New Surfaces:

Steel

New steel surfaces should be initially abrasive blasted to near-white metal surface cleanliness in accordance with SSPC-SP10 or ISO8501-1:2007 Sa2½. Blast profile on steel should be at least 3.0 mils (75 microns) in depth and be of a sharp, jagged nature as opposed to a “peen” pattern (typically obtained in shot blasting).

Previously Painted Surfaces:

Bar-Rust 234P may not be applied to existing coatings. All coatings should be removed and substrates treated as for New Surfaces.

APPLICATION

Mixing	This material is supplied in full containers for use with plural component airless spray equipment. Once mixed, Bar-Rust 234P must be used within the working pot life specified.	
Mix Ratio	2 part(s) : 1 part(s) by volume	
Working Pot Life	77°F (25°C) 20 minutes	104°F (40°C) 3 minutes
Plural component airless spray	Recommended	For best results the product should be heated to 100°F-120°F (38°-49°C). See Product Characteristics section for further details
Brush	Suitable - Touch up and small areas only	
Roller	Suitable - Touch up and small areas only	
Trowel Thinner	For small areas or repair areas only. DO NOT THIN	
Cleaner	T-10 Thinner	In the SCAQMD region, use #4267 Low VOC Cleaning Thinner or other solvent in compliance with local VOC and air quality regulations
Work Stoppages	Do not allow material to remain in spray equipment. Thoroughly flush all equipment with T-10 Thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
Clean Up	Clean all equipment immediately after use with T-10 Thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

Epoxy

PRODUCT CHARACTERISTICS

Advantages:

- Excellent adhesion to steel and concrete substrates
- Low cured shrinkage
- Low temperature cure - will cure down to 35°F (2°C)
- Excellent water resistance
- Ultra low VOC

Bar-Rust 234P must be applied with a plural component spray system because of the very short pot life. Application tests have determined that a system with two 68:1 airless pumps configured at a 2:1 mix ratio will apply this product with excellent results. For best results the product should be applied heated to 100°F-120°F (38°C-49°C) for each component, then sprayed using minimum 5000 psi (351kg/cm²) rated 1/2" fluid hose, equipped with in-line heaters, and an airless spray gun with Tips from 525 to 529 orifice, or an equivalent pressure rated airless gun and tip package. For smaller areas, touch up and repairs a trowel, brush or roller may be used within the limits of the pot life.

It is very important for the safety of the applicator and the proper performance of Bar-Rust 234P that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry, fresh air to remove all solvent vapors. Since all solvent vapors are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating.

Application should not take place when relative humidity is more than 85% or the surface temperature is less than 5°F (3°C) above the dew point.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

In most circumstances this product is applied direct to the substrate and is not overcoated.

Epoxy

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 US gal	5 US gal	5 US gal	5 US gal	5 US gal
For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	55 US gal	901.9 lb		589.8 lb	
	5 US gal	75.8 lb		46.3 lb	
STORAGE	Shelf Life	12 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Disclaimer

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

Copyright © AkzoNobel, 6/2/2020.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com