

TECHNICAL SPECIFICATIONS GUIDELINE

ANTICORROSION COATING NOXYDE PLUS

Waterproof high build elastomeric acrylic anticorrosion coating

CHARACTERISTICS

- Very durable protection
- Very high thickness per coat, covers edges
- Outstanding adhesion
- 200% permanent elasticity, will not crack or peel
- Dry fall when sprayed
- Shock and impact resistant

ACCEPTABLE SUBSTRATES

STEEL

Surface condition

Steel substrates must be properly supported to avoid warping, which could cause the coating to work and lead to cleavage.

A: Steel substrate extensively covered with adhered mill scale but with few or no rust at all.

B: Steel substrate that has started to rust and whose mill scale has started to delaminate.

C: Steel substrate from which mill scale has disappeared under action of rust, or that can be removed by scrapping, but showing some rust cankers visible by naked eye.

D: Steel substrate from which mill scale has disappeared under action of rust, or that can be removed by scrapping, but showing a lot of rust cankers visible by naked eye.

NON-FERROUS METALS

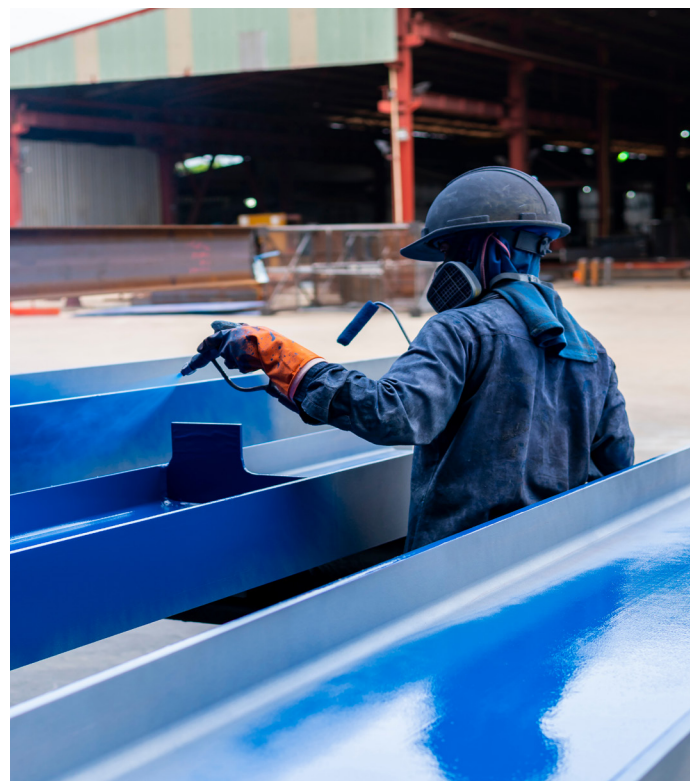
Surface condition

Surfaces must be made up of solid and non-deformable structures.

OLD COATINGS

Surface condition

Old paints and coatings should be perfectly adherent. In case of doubt, carry out a test on a small control-surface. Compatibles glossy coatings will be sanded mechanically.



SURFACE PREPARATION

GENERAL

Remove any dust, debris etc ; degrease and eliminate any contamination by alkaline cleaning with Cleaner-Degreaser RUST-OLEUM ND14 or high pressure cleaning combines with appropriate detergent, followed by thorough rinsing and full drying. In case of presence of mould (moss, lichens etc), decontaminate concerned surfaces with AMW Concentrate, followed by thorough rinsing and full drying. For severely contaminated areas, it is recommended to double the fungicidal treatment.

STEEL

See General.

Remove rust, rust scales, mill scale and old paints in bad condition, either manually or mechanically, according to the surface* :

Grades A and B : abrasive blasting SA 2 ½ (ISO 8501-01), max. rugosity 75 µm.

Grades C and D : pitting, grinding or scrapping-wire brushing to degree of care St 2/3 (ISO 8501-01), abrasive blasting SA 2 ½ (ISO 8501-01), max. rugosity 50 µm.

** Large surfaces will be preferably treated by abrasive blasting*

GALVANIZED STEEL

See General.

New galvanized steel will be degreased and etched with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

Zinc oxides, « white rust » will be eliminated with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

NON-FERROUS METALS

See General.

New aluminum will be degreased and etched with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

Salts and oxides will be eliminated with acidic etching solution RUST-OLEUM SURFA-ETCH 108 followed by thorough rinsing with fresh water.

RECOMMENDED WORKING PROCEDURES

DESIGN (STEEL)

The risk of corrosion can be limited and efficiency of protection dramatically improved when the object design is taken into account.

Preparation :

Sharp edges will be rounded by grinding to an angle of at least 3 mm ; weldings and their spillages will be grinded; cut-outs will be deburred. Avoid non-accessible gaps and discontinuous weldings. Bolts, nuts, rivets etc will be coated with a primer. The latter will be first applied as a touch-up by brush, then as a general coat, ensuring this way a double thickness on most exposed spots.

PRECAUTIONS

During application and first phase of drying (± 3 hours), low temperatures and high humidity and/or condensation can delay the evaporation and drying process, and possibly cause a re-wetting of the applied coat. Do not apply if rain is imminent or expected.

PRIMERS

New galvanized steel and non-ferrous metals will receive an adhesion coat of Metal Cladding Primer or PVDF Primer.

Metallic substrates coated with PVDF will receive Primer PVDF.

Recent Plastisol® claddings will receive Metal Cladding Primer.

APPLICATION CONDITIONS

Temperature of air, substrate and product should be between 3 and 35°C, and relative humidity below 85%. Substrate temperature will be 3°C superior to dew point.

Product mixing: mix base material with a slow speed electric mixing machine, maximum 300 rounds/minutes, until homogeneous result is obtained.

Consult technical data sheets for details on drying times, induction times, pot-life, dilution and recommended application methods. Consult safety data sheets for any information related to safety during use of products.

SURFACE MAINTENANCE

Temperature of air, substrate and product should be between 8 and 35°C,

and relative humidity below 80%. Substrate temperature will be 5°C superior to dew point.

Product mixing: mix material by hand (small packagings 1L) or with a slow speed electric mixing machine, maximum 300 rounds/minutes (packagings 5L and more), until homogeneous result is obtained.

Consult technical data sheets for details on drying times, induction times, pot-life, dilution and recommended application methods. Consult safety data sheets for any information related to safety during use of products.





BACK TO SERVICE

Depending on temperature, most of acrylic coatings will be hard after 24h. However the coating remains vulnerable to the action of humidity, detergents and chemicals, until full hardness is reached. It is therefore necessary to take precautions on the coating system as a consequence for at least one week. During application and drying, coatings require good ventilation ; in closed spaces, a forced ventilation is required (extraction). Best results are obtained when product is applied at an average temperature of 20°C (air, substrate), and when relative humidity can be maintained below 80%. To the extent that hardening of product is a combination of water evaporation and coalescence of the binder, temperature plays an important role ; full hardness is reached after about 14 days at 20°C.

SURFACE MAINTENANCE

A RUST-OLEUM NOXYDE PLUS system can be maintained by cleaning with a neutral detergent or alkaline detergent diluted with water. A worn coat can be easily restored by adequate surface preparation and application of a new coat of product. On metal, in case of rust reformation, it is advised to not postpone repair, to prevent any growth.

SYSTEMS OVERVIEW

ANTICORROSION SYSTEMS								
SUBSTRATES								
Low to moderately aggressive exposure	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :
Primer	-		-		-		-	
1st coat	Noxyde +	125-140 µm	Noxyde +(1)	125 µm	Noxyde +	125-140 µm	Noxyde +	125-140 µm
2nd coat	Noxyde +	125-140 µm	Noxyde +	125 µm	Noxyde +	125-140 µm	Noxyde +	125-140 µm
Total film thickness	250-280 µm		250 µm		250-280 µm		250-280 µm	
Agressive to very aggressive exposure	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :	System :	D.F.S. :
Primer	-		-		-		-	
1st coat	Noxyde +	175-215 µm	Noxyde +(1)	175 µm	Noxyde +	175-215 µm	Noxyde +	175-215 µm
2nd coat	Noxyde +	175-215 µm	Noxyde +	175 µm	Noxyde +	175-215 µm	Noxyde +	175-215 µm
Total film thickness	350-430 µm		350 µm		350-430 µm		350-430 µm	
Remarks :								
(1) Rusted spots will be first treated locally with Noxyde Plus.								

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Available colours and pack sizes: See the relevant product page at www.rust-oleum.eu for actual available colours and pack sizes.

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