

APPLICATION GUIDE



ROKOAT TechShield Rust Inhibitor

Overview

This is designed for Professional use only.

ROKOAT reserves the right to remove all warranties and guarantees on this product if not applied according to this guide.

Safety Notes

Use in well ventilated areas. Use vapour filters on a mask.

Protective gloves and safety glasses must be worn at all times.

Health, safety and environmental information are provided for this product in the Materials Safety Data Sheet (MSDS). This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.

Application Methods

Brush / Roller

Spray

Micro-Fibre

Sponge

Surface Preparation

Surfaces should be free from loose rust, mill scale, paint, grease, oil, loose cement or any other film forming foreign material.

Use any means necessary to achieve a clean tight surface – from wire brushes to high-pressure water sprayers.

Optimal results are achieved on dry surfaces however TechShield Rust Inhibitor can be used satisfactorily if the surface is damp or wet. Pooling water should be removed.

Primer is NOT required.

Mask-up and / or protect surfaces that are NOT to be treated. TechShield Rust Inhibitor has extreme adhesion properties and will require a high level of abrasive to remove.

Product Preparation

Allow 1 hour preparation time.

1. PRIOR to combining Parts A & B, MECHANICALLY mix individual pails for 2 minutes.
2. Combine in a 1 to 1 ratio Parts A & B.

APPLICATION GUIDE



3. MECHANICALLY mix using a power mixer for around 5 minutes until ALL streaks and lumps disappear and the mixture has a uniform colouring & consistency.
4. NOTE : Allow mixing blade to remove/mix product on the sides and bottom of container.
5. Stand for 45 minutes to allow product to ingest.
6. If using thinners* add before application.

*Use of thinners is NOT recommended. Will increase possibility of sag, extend curing time and reduce the dry thickness of the product. Multiple applications may be required to achieve desired protection levels. If to be used, use MEK at a maximum 10%.

Application Methodology

Airless spray is the most efficient for large projects. Roller / Brush for detailed work such as edge termination, filling of voids, pinholes and small cracks.

Example equipment: Graco 5900 with 0.021 to 0.031 tip. 3000PSI capability with reversible self-cleaning tip. REMOVE all filters from gun and hose including the bund hose.

ATTENTION : The coating MUST cover the maximum height / peak of any rust. Ensure thickness is achieved via number of coats.

Spraying apply at 338-508µm, which will dry to 203-305µm at a rate of 11.1 sq metres / US gallon.

NOTE : Any overspray and equipment must be cleaned immediately with MEK.

Curing & Secondary Coatings

Apply secondary coatings when previous coating is tacky to the touch (1 – 2 hours at 25-28°C (80°F)). Secondary coating will cover voids and imperfections.

Drying time : 1 – 2 hours at 25-28°C (80°F).

Initial curing time : 8 hours at 25-28°C (80°F).

Complete cure : 3 days at 25-28°C (80°F).

NOTE : Approximate pot life after mixing is 4 - 6 hours at 25-28°C (80°F).

APPLICATION GUIDE



Properties

Colour	White
Viscosity	16075 centipoise @ 75°C @ 2.5RPM
Percent of Solids	60%
Odour (liquid)	Naphthalenic
Odour (cured)	None
V.O.C.	<5%
RoHS	Compliant
Coefficient of Friction	N/A
Thermal Stability (cured)	454°C
Thermal Conductivity	N/A
Conical Bond	N/A
Pencil Hardness	Shore A Hardness 97
Cross cut adhesion	425 pounds / sq. inch
Specific Gravity	N/A
Average applied film thickness (Dry)	203 - 305µm
Average applied film thickness (Wet)	338 - 508µm
Estimated Coverage Rate (Dry)	11.1 sq metres / US gallon
Transfer to surrounding material	None
Permeability	0.372 perms
Dry (Tack to touch)	1 – 2 hours at 25-28°C (80°F)
Semi-cured (time-ambient)	8 hours at 25-28°C (80°F)
Full Cure Time (ambient)	3 days at 25-28°C (80°F)
Cleaning	MEK

ASTM Test Battery

ASTM B117 500 hour Salt fog test –Passed

ASTM D-2240 Hardness 97 Shore Durometer

ASTM E108-91A UBC32-7 Class A Fire Rated

ASTM D-638 Tensile Strength 3850 PSI

ASTM E-96 Water Vapour Transmission 0.372 perms

ASTM G-53 500 hour accelerated weathering test, bend double with no cracking, highly flexible

ASTM 1640, D-92, D-1644A, D-2196, D-696, D-570, C-836, D-1652, D-1259

Flexibility is retained in sub-zero conditions (down to –92°F)