



Total Coat Rust Prevention Coating

Cleaning:

TC/RPC should be applied on a clean, bare, primed or painted surface, free of oil, grease, dirt, release agents etc. A citrus based or waterborne degreaser is recommended for thorough cleaning, even on new cars. Failure to properly clean and degrease the surface to be coated will result in the loss of adhesion. On rusted areas, scrape/wire brush and power wash loose rust away. Dry surface before application.

Applying:

TC/RPC has to be applied at a min of 60°F at a wet thickness of 0.5 – 0.70 mm (20 to 35 mils). When applying with the Chemicar RA/88 spray gun, use 30 – 70 psi and hold the gun 12 to 14 inches away from the substrate.

Failure to apply at/or above this min temperature or recommended thickness will result in the dried coating being cracked or easily removable.

Drying:

TC/RPC should not be exposed to temp below 60°F during the application and curing process. The drying process actually exists of three different steps: “dry to the touch”, “fully cured” and “fully cross linked”.

TC/RPC will be dry to the touch after:

90 min in ambient air of 72°F and RH 40% . More drying time might be required at higher RH.
30 min in a heated booth at 100°F (Allow 15 minutes flash-off at 72° F before entering the oven)
30 min (10 min flash off at 30” and 20 min full bake at 30”) under Infra-Red lamps.

TC/RPC will be fully cured after:

24 hours at ambient air of 72°F and RH 40%. More curing time might be required at higher RH.
60 min in oven at 100°F and a cool down period of 1 hr. at 72°F.
40 min (10 min flash off at 30” and 30 min full bake at 30”) under the Infra-Red Lamps and a 1 hr cool down at 72°F.

TC/UC will be fully cross linked after 7 to 12 days.



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Drying cont.:

Curing times can be considerably improved by adding air movement (fan) to the drying method. Do not force dry at temps higher than 100°F.

For OEM high bake oven applications call 800 261 7976.

When the coating is "dry to the touch" the sprayed items can be moved, worked on, packaged etc. However they cannot be exposed to water and cold temperatures as this will cause thermal shock. Thermal shock will cause cracking of the coating and the TC/RPC will be easily removable. Allow the coating to fully cure before exposing to water and cold weather. However during the next 7-12 days of cross linking, the coating will gain in hardness and strength. A fully cross-linked coating has a hardness of: Shore A: 92-95.

Storage:

TC/RPC should be stored in a cool and dry place and has a 2-year shelf life when kept in temperatures between 45° - 85° F. Do not store in direct sunlight. Do not freeze.

The above information is given in good faith, but the user should assure himself that the performance of the product is sufficient for his application. The quoted values are average and should not be taken as maximum or minimum values for specific purposes. Chemicar USA cannot be held responsible for product failure unless full testing has been carried out. The client has to decide on the products suitability for their own applications.