

Wearlon Primer and Topcoat Application Guide

- 1) **Very important:** Review the Pro-Tips section BEFORE beginning. (See page 2 for flash rust concerns.)
- 2) **Surface Prep:** Consider roughening the surface, if needed (to optimize adhesion), with sandpaper or media blast (see Pro-Tips "Surface Prep"). **Wipe down** the entire area to be coated with an acetone dampened rag. This removes sanding dust, oils, waxes, and any other contaminants that may adversely affect adhesion. Keep wiping until the rag comes away clean. If applying on fresh sandblasted cold rolled steel, use flash rust additive prior to coating. See Frequently Asked Questions (FAQs) on our website – www.wearloncorp.com.
- 3) **Tape or mask** off the area to be coated.
- 4) **Mixing Instructions:** Wearlon is a 2-component product. Begin by shaking both the "A" and "B" components violently, at least 30 seconds each. Now, pour the entire contents of component "B" into component "A". Mix together thoroughly. Only catalyze the amount of coating needed for the project. For example, if you want to only use 1/2 of the container, simply pour out 1/2 of the A into a clean container, then pour 1/2 of the B directly into the A. Mix the A and B until completely blended. Once catalyzed, Wearlon has a workable pot life of 1 hour. Catalyzed coating gradually thickens through the pot life.
- 5) **Application:** Begin applying either by roller or spray. **Air assist or airless spray** equipment provides the best results in terms of achieving a smooth, uniform surface. *Air assist is best for smaller jobs. Airless is best for high volume jobs. If using a roller, for best results use a 3/8 inch polyester blend medium nap roller.
 - 2020.90 Primer** - Apply. Allow to cure for 24 hours, then apply the topcoat.
 - SF-3M Primer** - Apply. Then you have two options:
 - #1 - Allow to cure for just 15-20 minutes (when it is just between tacky and dry-to-touch) and then apply the topcoat.Or...
 - #2 - Allow to cure for 24 hours. After 24 hours, scuff the primed surface with 220 grit sandpaper, wipe debris off with a wet rag, and then apply the topcoat.FY1 - Option #2 provides for the best overall results, but may not be practical in terms of time restraints.
- (6) **Mil Depth:** A standard mil depth for Wearlon coating is 7 to 9 wet mils. At this depth you should be able to cover approximately 200 sq.ft. per gallon.
- (7) **Cure Time:** Wait at least 5 days before putting the coated unit back into service. If you can press your fingernail into the coating IT IS NOT FULLY CURED

Pro-Tips

- **Climate Control:** Do not apply on days where relative humidity is above 75%, or the temperature below 50°F. The lower the humidity, the better the cure. We advise trying to apply Wearlon when it is below 60% relative humidity. Dehumidifiers, fans, and sunshine are always a plus.
 - **Surface Prep:** Wearlon adheres tenaciously to most substrates. However, if the surface is suspect (surface contains slight corrosion, an unknown paint, questionable alloy or plastic), consider media blasting or sanding. You can prepare the substrate by etching the surface with abrasive sandpaper (150 grit) or media blast. This enhances the adhesion of Wearlon to the surface that needs to be coated.
 - **Masking:** Tape does not adhere well to a Wearlon coated surface. Plan your masking accordingly.
 - **If Spray-Gun begins to clog,** quickly flush water through the system and then resume application.
 - **Bath Life** - 1 hour.
 - **Forced/Faster Curing:** Standard room temperature cure is 5 days. However, adding heat after application - either by heaters, direct sunlight, or other methods, will speed up the curing process. If adding heat, do not begin to add the heat until 2 hours after the coated surface has been room temperature curing. Then add heat gradually beginning at around 120°F for 30 minutes, then turn heat up to around 220°F for 30 minutes. Never exceed 270°F; Adding excessive heat too quickly can result in pinholes or blistering.
 - **Clean** application equipment with water.
 - **Store** at standard room temperature. Do not allow it to freeze. Typically, the shelf life of liquid Wearlon products is 1-2 months. To prolong shelf life, shake the bottles often. Some contents will settle and harden on the bottom.
- ****Refer to Wearlon® Data Sheet for additional information****

If Flash Rusting is an issue - When applying water-based coatings, such as Wearlon® over sandblasted cold rolled steel, flash rusting may occur. The presence of little brown spots is due to flash rusting. These brown spots encourage more rusting and affect the integrity of the coating. This flash rusting mainly occurs when a deep profile such as SSPC 10 is applied to the cold rolled steel, and/or it is a very high humidity climate.

4 Different Methods to Overcome Flash Rusting

- 1) Apply a light mist coat of Wearlon® (approximately 1 mil or 25 microns thick) and allow to dry to touch for approximately 15 to 30 minutes. Apply the desired remaining amount of Wearlon®. Utilizing dehumidifiers and fans in a low RH environment also helps to eliminate the possibility of flash rust occurrence.
- 2) Applying Wearlon® to preheated steel (approximately 100° F or 38° C) will also eliminate the possibility of flash rusting. Other advantages of preheating the steel are: a) fast drying time for quick turnaround time, b) allows for quick evaporation of the water in the Wearlon® coating for faster cure, c) will eliminate the possibility of sagging of the coating when high deposits of Wearlon® are applied.
- 3) Use of a flash rust additive will eliminate rusting of the cold rolled steel when Wearlon® is applied.

Flash

Shield Rust Inhibitor 104-K, can be purchased from Ultra Chem LLC (phone 713-641-1100 or cell # 281- 5438795) or Plastic Maritime Corporation. It should be cut with water. We have found that cutting the flash rust additive with 30 parts water to 1 part of the flash rust additive works excellent to prevent flash rusting. It will delay flash rusting for 3 to 5 days. It is specifically formulated so that water-based coatings can be applied almost immediately directly over it without loss of adhesion.

- 4) In a high humidity marine environment, especially when applying Wearlon to sandblasted steel in an outdoor environment, it may become necessary to apply solvent-based epoxy primer.

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