

Wearlon® 2020-98H (HYBRID)

Stretch Forming Coating Eliminating Oil
APPLICATION GUIDE AND TECHNICAL INFORMATION
Meets EPA, USDA, And FDA 21 CFR 175.300 Requirements

Surface Preparation

Wearlon® 2020.98-Hybrid is a silicone-epoxy top-coat, having unique release properties and excellent adhesion to a broad range of substrates. **Wearlon® 2020.98-Hybrid** can be applied directly to metal or Wearlon 2020-90 primer for improved abrasion. Pre heating the mold is not necessary but is sometimes employed to speed up the cure.

Mixing Instructions

Before mixing, shake or stir each component until homogenous. **Wearlon® 2020.98-Hybrid** is a 2 component product packaged in 1 Gallon and 5 Gallon kits which contain the proper ratio of ingredients. The entire contents of each container should be mixed together.

For quantities less than the pre-packaged kit, mix as follows: To **11 parts** of the **A** component mix in **2 parts** of the **B** component. Mix this until completely blended. **NO INDUCTION PERIOD NECESSARY...**Spray or Roll immediately.

Thinning and Clean up

In most cases it is not necessary to thin **Wearlon® 2020.98-Hybrid**. If you find it necessary to thin **Wearlon® 2020.98-Hybrid** you may add up to 5% DRINKING WATER. Clean up is a snap using soap and water while **Wearlon® 2020.98-Hybrid** is in an uncured state. For best results clean all equipment as soon as the application is complete. After the material has cured you will need to use solvents to remove the **Wearlon® 2020.98-Hybrid**.

Application and Recoating

Product can be rolled, brushed or sprayed. For best results, spray **Wearlon® 2020.98-Hybrid** with airless spray equipment for a 3 to 5 mil dry, or 6 to 10 mil wet coating. Allow to cure at least 24 hours and ideally one week at room temperature before putting into service. Do not coat products at surface temperatures below 40°F and relative humidity above 90%. For fast-turn around, the coating can be applied on a preheated mold. Post heating can also be applied any time after the water is removed to achieve faster curing and improved abrasion properties. For a greater orange peel effect apply **Wearlon® 2020.98-Hybrid** with a short nap Mohair roller or Urethane foam roller. Roll 1 coat, and then follow within 20 minutes with the 2nd coat to achieve your total mil thickness. If the Wearlon surface has become damaged or has excessive wear, then an occasional touch up may be required. This can be achieved by simply spraying 1 to 3 mils of the **Wearlon® 2020.98-Hybrid** over the existing Wearlon surface and allowing it to cure for at least 24 hours prior to putting it back in service. If poor wetting occurs while applying subsequent Wearlon coatings then sand lightly with a Scotch Bright pad, wipe off dust with a dampened Acetone rag and then apply **Wearlon® 2020.98-Hybrid**. **Shelf Life: 1 Year Storage: DO NOT FREEZE**

Coating Type

Silicone/epoxy waterbased **Color:** Various (contact WEARLON® representative)

Pot life: 60 min. @ 68°F **Induction Time:** None **Solids:** by Weight 53%
Coverage Rate: Approx. 200 sq. ft. @ 3-4 mil DFT (85% Yield) **Tensile Strength:** >1750psi
Elongation: ASTM 2370 >5% **Adhesion:** ASTM D451 >1000psi **Abrasion:** (CS 17/Kg/1000 cycles) <40 mg loss
Cure Time: Complete in 5 days. Dry to the touch in 2 hours. Force cure 300°F for 30 min. Many applications can be returned to service the next day. **VOC:** ASTM 3960-0.5#/gl. **Heat Resistance:** Do not exceed 275°F continuous service

CAUTION: Wearlon® surfaces have a low coefficient of friction and therefore tend to be slippery.

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