

# RUST O CAP FC

Fast drying surface tolerant epoxy coating

## PRODUCT DESCRIPTION

Two component, fast drying surface tolerant epoxy coating

## FEATURES AND RECOMMENDED USE

- Fast drying Surface tolerant maintenance coating for steel with rapid recoating times
- Recommended as a self-priming coating for concrete, steel, aluminium and galvanized surfaces.
- Excellent adhesion to tight adherent rust and prepared damp surfaces
- Good adhesion to aged and sound epoxy, polyurethane and conventional alkyds
- Can be over coated with conventional coatings and most two component paints
- Suitable as a touch up coat in projects for weld seams and damaged epoxy coatings
- Excellent corrosion protection in industrial and marine environments
- Certified to overall migration standard as per 21 CFR 175-300 of US – FDA by CFTRI India in contact with potable water

## TECHNICAL DATA

Colour	Range
Gloss	Semi Glossy
Volume Solids	Approx. 80%
Recommended DFT / Coat	100 - 200 microns
Theoretical Coverage Capacity	8.0 sq.mtr/ ltr @ 100 microns DFT 4.0 sq.mtr/ ltr @ 200 microns DFT
Drying Time at 30°C	Surface Dry : 90 minutes Hard Dry : 3 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 3 hours Max. : 1 Month, provided surface is cleaned from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances

The volume solids indicated are as per ASTM D 2697 air drying method.

The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.

The information provided above is at 30°C and 65% relative humidity.

## DIRECTIONS FOR USE

### Surface Preparation

#### General:

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

## Blast Cleaning:

- Steel, abrasive blast clean to min. Sa 2 1/2 (ISO 8501-1: 200) or SSPC –SP6. In case oxidation has occurred between blasting and application of Rust O Cap FC, the surface should be reblasted.
- A blasting profile of (Rz) 50-75 microns is recommended.

### A. Steel

a. For immersion condition

- Steel, blast cleaned to Sa 2.5 of Swedish specification.

b. For atmospheric exposure condition:

- New hot-rolled steel; blast cleaned to min Sa 2 of Swedish specification.
- Weathered steel; power tool cleaned to St 3 or hand tool cleaned to St 2.
- Existing sound epoxy coating system and sound alkyd coatings; sufficiently roughened, dried, and cleaned.
- High pressure fresh water washing or scrubbing to remove loose paint and contamination. Intact areas to be roughened. Damaged and rusty areas to be derusted to minimum St3 /St2 by power tool / hand tool cleaning.

### B. Concrete:

- Acid etching as per ASTM D4260 or abrasive blasting as per ASTM D4259. New Concrete should be cured for minimum 14 days prior to surface preparation and coating application

### C. Galvanised Steel & Aluminium:

- Remove oil, grease or other contaminants from the surface. Alloys that oxidise should be lightly sanded to remove all loose materials from the surface. Refer special instruction below.

## Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

## Mixing

- Rust O Cap FC is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing.
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture.
- Thinner should be added after mixing the components and post the induction time. Addition of excessive thinner will lead to reduced sag resistance.

<b>Mixing Ratio (by volume)</b>	Base : Hardener 1 : 1
<b>Induction Time</b>	15 minutes
<b>Pot Life at 30°C</b>	1 hours

## Application

<b>Air Spray</b>	
Recommended thinner	T 141
Volume of thinner	5 - 25 %
Nozzle orifice	1.5 - 3.0 mm
Nozzle pressure	0.3-0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Cleaning Thinner	T 141
<b>Airless Spray</b>	
Recommended thinner	T 141
Volume of thinner	5 - 25%
Nozzle orifice	0.53 - 0.66 mm (21 – 26 Thou)
Nozzle pressure	20 – 24 MPa (= approx. 200 – 240 atm; 2800 – 3400 p.s.i.)
Cleaning Thinner	T 141
<b>Brush</b>	
Recommended thinner	T 141
Volume of thinner	0 - 10%
Cleaning Thinner	T 141

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap.
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation.

## Special Instruction

- Surface discoloration may occur upon exposure to sunlight, elevated temperatures or chemicals. However, this does not impact anti-corrosive performance.
- Not recommended for immersion services in acids, alkalies & solvents
- A test patch is recommended over non-ferrous metals and adhesion to be checked as per ASTM D 3359 to confirm suitability.
- While applying on condensed areas, thoroughly wipe out the moisture before application.

## Product Characteristics

- Maximum film build in one coat is best attained by airless spray. Air spray (pressure pot) may require a multiple cross spray pattern to achieve optimum film build. By brush application 75 -100 microns is achieved in one coat and multiple coats will be required to achieve the total specified thickness.
- The maximum performance is achieved after complete curing.
- As common to all epoxy, the product will chalks and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

## Overcoating and Topcoats

<b>PACK SIZE</b>	20 ltrs (Base : 10 ltrs & Hardener : 10 ltrs)
<b>STORAGE</b>	<b>Shelf Life:</b> Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash Point:</b> Base : Not less than 24°C Hardener : Not less than 24°C <b>VOC:</b> Approx. 220 gm/ ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 1.42 kg/ ltr (depending on shades)

## SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.



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