

PRODUCT DATA SHEET

RIGSPRAY

Polyester Glass Flake Coating

Description

Rigspray is a polyester two-part high solids reinforced glass flake coating that offers outstanding resistance to corrosion and abrasion. It is resistant to corrosive acids, alkalis, salts and a range of oxidizing chemicals.

Uses

Corrosion protection of steel structures that are subject to the most aggressive marine environments (i.e., pilings, bulkheads, helidecks, splash zones, underdeck areas, main deck areas, and many other corrosive environments).

Features

- Excellent corrosion resistance
- Fast dry and set times
- High build up to 40 mils in one coat
- High abrasion resistance
- Excellent undercutting resistance
- Very low water permeability
- Excellent water/sea water resistance
- High temperature tolerance
- Excellent cathodic disbondment results

Application

Prepare surfaces by grit blasting to a clean near white finish, SSPC-SP10/NACE No. 2. For larger areas the Archco PD2 Primer shall be used. The coating can be applied by brush or airless spray in one coat (up to 40 mils thick in one coat). A wet film thickness gauge shall be used to measure uniform application. Plate edges, corners and weld areas shall be stripe coated by brush prior to application. This will help ensure adequate coverage of these areas.

Initially stir Part A (base) prior to adding Part B. The materials shall be 50°F (10°C) minimum before spraying. The Part B (catalyst) material shall then be added according to quantity and ambient conditions (see Catalyst Ratio Chart). Ensure the two components are fully mixed thoroughly using a mechanical whip prior to application. The mixed material shall be sprayed immediately after mixing. **Note: Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.**

Inspection and Testing:

The dry film thickness of the completed coating shall be measured with an electronic instrument to ensure proper film thickness.

The finished cured coating shall be tested for holidays using a D.C. spark detector. A coating test voltage of 100 volts/mil shall be used.

When applying by airless spray, refer to the equipment manufacturer's operating procedures. In addition, remove pump filter, surge pot, and in-line filters.

Clean tools and equipment with Acetone prior to material curing. Great care must be taken to avoid contaminating the coating material with Acetone as this can have adverse effects on the cure of the material.

Denso[®]

Rigspray

Technical Data

PROPERTIES

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| Solids Content | 98 - 99% |
| Specific Gravity | 1.2 |
| Maximum Humidity During Application | 90% RH |
| Min. Substrate Temperature | 50°F (10°C) |
| Minimum Dewpoint/Substrate Differential | Dewpoint +5°F (+3°C) |
| Dry Film Thickness Per Coat | 24 - 40 mils |
| Theoretical Coverage | 39 SF/Gal @ 40 mils DFT |
| Overcoating Times 68°F (20°C) | Min. 4 hrs – Max. 3 days |
| Min. Substrate Temperature | 50°F (10°C) |
| Preferred Equipment | Graco King 63:1 Airless |
| Airless Spray Tip Size | 0.025 - 0.031 in. |
| Pressure at Tip | 2500 - 3500 psi |
| Pot life 68°F (20°C) | 15 - 20 minutes |
| Typical Curing Characteristics | |
| Substrate Temperature 59°F (15°C) | Touch Dry – approx. 2.5 hrs Full Cure – 2 - 7 days |
| Shelf Life | 4 - 6 months |
| Flash Point | 88°F (31°C) |
| Abrasion Resistance ASTM D 4060 | 0.035gm |
| Adhesion Properties ASTM D 952 | 8 Mpa |
| Salt Water Resistance ASTM B 1117-57T | 20,000 hrs – No effect |
| Cathodic Disbondment BG/PS/CW6 68°F (20°C) – 28 days | 6 - 7 mm |
| Tensile Strength ASTM D 638 | 4715 psi |
| Flexural Strength ASTM D 790 | 10040 psi |

STORAGE: Minimum 4 - 6 months when stored in original containers @ 41°F (5°C) to 80°F (27°C).

CLEANING: Clean equipment with solvent cleaner (Acetone).

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

PACKAGING: 1 gallon kit and 5 gallon kits standard. Other kit sizes are available.



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