



Dampney Protective Coatings

Endcor[®] 460 Rust Conversion Coat

Description

A water-borne copolymer that is designed for application to rusted ferrous metal surfaces. When properly applied the coating converts the rusted surface to a dark, stable organic iron compound. This product has a low permeability factor and is impermeable to oxygen and moisture while providing a rust free surface ready for priming or finish painting

It converts and primes rusted surfaces in one operation; dries to a hard, gloss finish combines excellent flexibility, toughness and impact resistance.

Uses

- Used as a primer over surfaces which have minimal surface preparation
- Converts rust into a primed surface ready for priming or topcoating
- For use in industrial, marine, chemical, refineries, and pipeline

Features

- Outstanding adhesion to substrate
- Low permeability to water vapor and oxygen
- VOC compliant
- Tolerance for lower standards of surface preparation
- User friendly - single package system

Surface preparation

Apply Endcor 460 only over properly prepared surfaces. All loose rust should be removed by scraping, wire brushing and washed with water. Remove oil and grease by solvent wiping or cleaning with an alkaline detergent. Remove loose and flaking rust, mill scale and old paint by power or hand wire brushing, chipping and scraping. Follow by fresh water rinse to remove all residues

Application guidelines

1. Coating is formulated for application by brush, roller, airless or conventional spray.
2. Do not apply coating if temperature is below 50°F (10°C) or if relative humidity is above 80%. Do not apply in foggy or misty weather or if rain is imminent. Mix thoroughly with power mixer before use.
3. Theoretical coverage is 687 sq. ft. / gal. @ 1 mil dry film thickness. Practical coverage rate will be lower and will depend on surface roughness, depth of rust and application losses, and will vary from 200 to 300 sq.ft. per gallon.
4. Apply one coat of ENDCOR 460 to 2 - 3 mils dry film thickness (5 - 7 mils wet film). Coating will dry and turn dark within 10 - 15 minutes.
5. For maximum protection of badly corroded surfaces, apply a 2nd coat at 2 - 3 mils dry film thickness. Apply within 20 - 30 minutes of 1st coat to ensure complete chemical reaction with the rusted surface.

Thinning

If thinning is required use only clean water up to a maximum of 1/2 pint per gallon of coating. Never add solvents to ENDCOR 460.

Cleanup

Flush and clean brushes and rollers with clean warm water before primer sets up.

Mixing

Mix to a uniform consistency with a power mixer.

Drying Time

Endcor 460 is ready to be topcoated in 24 hours (See technical data section).

Bulletin 460

Storage

Store in cool, dry place with temperature between 50°F and 100°F (10°C and 38°C). Keep from freezing. Keep container closed when not in use.

Precautionary Information

Do not breathe vapor or spray mist. Avoid contact with eyes, skin and clothing. Use only with adequate ventilation during mixing and application. Only open containers in a well-ventilated area. Wear appropriate, properly fitted respirator (NIOSH approved) during and after application unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow manufacture's directions for respirator use. Wear neoprene gloves, chemical goggles and protective clothing. In confined areas required a constant flow, hood-type respirator. Observe safety precautions described in OSHA regulations.

Spillage and Disposal

In case of spill absorb with inert cleanup material, then place in a chemical waste container. Dispose of in accordance with applicable regulations.

Material Safety Data Sheet

See Material Safety Data Sheet (MSDS) on this product for complete safety information.

KEEP OUT OF THE REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

MADE IN THE USA

KEEP FROM FREEZING.

PHYSICAL PROPERTIES

Properties	Endcor 460
Generic Type	Water-borne Copolymer
Color	Clear
Volume Solids	43%
Weight per gallon	10.3 lbs. (1.2 kg./l.)
Viscosity	38 cps at 100 RPM
Ph	1.9 ± 1
VOC(Volatile Organic Content)	0.52 lb./gal. (62 g./l.)
Temperature resistance (dry)	120°F (49°C)
Dry film thickness per coat	2-3 mils (50 - 75 microns)
Wet film thickness per coat	5-7 mils (125 - 175 microns)
Theoretical coverage per gallon	687 @ 1 mil
Application temperature	
Ambient Air	Normal Minimum Maximum
Substrate	60-85°F (16-29°C) 50°F(10°C) 100°F(38°C)
Coating Material	60-85°F (16-29°C) 50°F(10°C) 120°F(49°C)
Humidity	65-85°F (18-29°C) 60°F(16°C) 90°F(32°C)
Drying Time*	30-70% 0 80%
To touch	at 50°F(10°C) at 70°F(21°C) at 90°F(32°C)
To recoat	30 min. 15 min. 10 min.
To topcoat	40-60 min. 20-30 min. 10-15 min.
Flash point	48 hrs. 24 hrs. 12 hrs.
Shelf life	Above 200°F (93°C)
	6 months

* Drying time will depend upon temperature, humidity and air flow over the surface. For still air conditions allow up to double the drying time listed in the above chart.

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