



MARINE BARRIER COAT APPLICATION GUIDE

RUST BULLET® MARINE BARRIER COATING APPLICATION GUIDE

SURFACE PREPERATION

1. All paint should be removed below the waterline. The recommended method for this is media blasting, as it will remove the paint as well as profile the bottom of the boat allowing for a superior bond. Other methods of paint removal include hand sanding or chemical stripping.
2. Depending on your method of paint removal it may be necessary to sand the gelcoat with 80 grit sandpaper to achieve a good profile for the Rust Bullet® to bond with.
3. If an epoxy had been applied to the boat previously it is important to remove any loose or flaking areas, if the other areas have a good bond to the boat you do not need to fully remove the epoxy. In this case you should sand the entire hull with 80 grit sandpaper to abrade the remaining epoxy.
4. Wipe the bottom of the boat down using Acetone, Toluene, Xylene, or MEK to remove any dust, debris or mold release wax from the surface.

PRODUCT STORAGE AND HANDLING

1. Care should be taken to ensure that new unopened containers or left-over partial containers are kept sealed, and a plastic polyethylene film to be laid on top of remaining material to displace as much air as possible.
2. Rust Bullet® is moisture sensitive. It is recommended to limit the time the container is opened. Transfer only the amount needed for the application of your project. Immediately wipe clean any Rust Bullet® from the rim of the container and reseal. This should be done every time you use Rust Bullet® and in between coats. **Never pour back into the original container any Rust Bullet® that has been exposed to the outside air for any length of time because it will destroy the remaining Rust Bullet®.**
3. If a skin has formed in a new, unopened container or a sealed container, remove by cutting edge of skin at the skin/container surface. Discard the skin properly. Stir until uniform. Filter if necessary and apply.
4. Rust Bullet® is packaged in unlined paint cans. If for any reason Rust Bullet® is transferred to another container; clean, unlined, paint cans (or similar unlined metal containers) must be used.

STIRRING

1. Do not open and stir Rust Bullet® when the coating temperature is below dew point.
2. Since Rust Bullet® is a single-component material, it is not necessary to mix "part A with part B"; however, Rust Bullet® should be stirred thoroughly for at least 2 minutes or until completely uniform. (Avoid whipping air into product.) Shaking the container of Rust Bullet® prior to application may cause the formation of bubbles in the finish of the coating.
3. Aged Rust Bullet® (six months or older) may develop settling. Follow the same process as in "STIRRING, #2" but increase the stir time and be sure to break up clumps on bottom, if any.
4. Do not reduce or thin Rust Bullet®. Because of the exacting chemical balance required by Rust Bullet®, thinning will compromise the quality of the cured product.

COVERAGE RATES

Rust Bullet® will coat approximately 400 square feet per gallon. To calculate the square footage of your boat, multiply the length of the waterline and the beam of the boat. If you operate a non-standard or non-recreational vessel, and require help determining the quantity of Rust Bullet® needed please contact your local distributor for assistance.

APPLICATION

1. Application may be performed with either Roller/Brush or Airless Spray. Due to over-spray concerns when working outdoors and near other boats the Roller/Brush method is recommended. Instructions for both methods appear below.
2. For optimum protection in the harsh marine environment 3 coats of Rust Bullet® should be applied, dry film thickness of 4 mils each for a total dry film thickness of 12 mils. Due to the porosity of gelcoat the first coat will need to be slightly more generous.
3. Subsequent coats of Rust Bullet® may be applied after approx. 2-4 hours of dry time. A simple test is that when the product will not transfer to a gloved finger you are ready for the next coat.
4. You may wait up to 72 hours between coats before additional sanding is required. The total dry film thickness of 12 mils is more important than the actual number of coats.
5. With proper planning it is possible to apply all 3 coats in a single day.
6. Allow 24 hours before applying anti-fouling bottom paint or any other topcoat.

ROLLER OR BRUSH

1. Use 1/4 to 3/8 inch nap synthetic fiber roller cover. Pay special attention when brush-applying product to prevent brush stroke lines in the film.
2. When spraying, rolling, or brushing it is important to keep a wet edge.

AIRLESS SPRAY

1. Rust Bullet® is supplied ready to stir and apply with airless sprayer.
2. We recommend straining through a nylon bag strainer.
3. Recommended tip size is 011-015. (517-519 tip)
4. Inspect all spray equipment and ensure it is clean and in good working order.
5. Flush xylene or toluene through pump link gun to remove any existing moisture or alcohol from previous coatings or solvents. Note: Do not re-circulate solvent through pump, as the solvent will be contaminated with moisture and debris. Draw solvent from one container and flush into another. Never allow old solvent in the coating lines to enter Rust Bullet®.
6. Follow all stirring instructions as listed above under "STIRRING." Note: Ensure that minimum cure times are followed for recoat. Published cure times (under normal weather conditions) are recommended per coat as specified on the data sheet. When excessive wet film is applied, additional cure time will be necessary.

CLEAN-UP

1. Use acetone, xylene, toluene, or MEK. Do not substitute any other solvent. Do not make assumptions about other cleanup solvents without consulting Rust Bullet® Customer Support. Even a very small contamination of Rust Bullet® with alcohol or other hydroxyl-containing solvents can destroy the moisture-cure reaction partly or entirely without any indication or jelling.
2. Always flush equipment clean. Do not leave residue as it will harden and become insoluble in solvent. Clean equipment as you would with any typical two component catalyzed coating. Always clean brush or roller thoroughly. Dunking dirty equipment in solvent will not prevent the coating from curing overnight. Avoid contact with skin or clothing. Use gloves, safety glasses, and other protective equipment. Any coating must be removed within 10 minutes or it will harden and become next to impossible to remove. After drying, Rust Bullet® can only be removed with rigorous abrasive action.

GOOD PRACTICES

1. Always prevent rain, mist, or sweat from falling directly into an open can of Rust Bullet®. A plastic, cardboard, or metal cover is always a good practice.
2. When saving partial cans, always lay a plastic sheet on the remaining material, then reseal. When done this way, any partial Rust Bullet® can be saved. If a skin forms on the surface of the material in the can, remove from the container and dispose of properly. Stir until uniform. Strain if necessary.

FINAL POINTS TO REMEMBER WHEN APPLYING RUST BULLET® ®

1. Never allow sweat, rain, or mist to fall into Rust Bullet®.
2. Never over stir, entrap, or whip air into Rust Bullet®.
3. Never allow lacquer thinner, vinyl thinner, epoxy solvent, or any alcohol or unapproved solvent to enter Rust Bullet®. For clean-up use only clean xylene, toluene, acetone, or MEK.
4. Never neglect to purge all paints, moisture, or debris from equipment before spraying Rust Bullet®.
5. Never apply Rust Bullet® while raining or under threat of rain.
6. Applying a topcoat over Rust Bullet® is not necessary. If one is desired, please wait 24 hours after application of the final coat of Rust Bullet®.

SAFETY CONSIDERATIONS*

1. A certain degree of risk is involved in the use - or more properly, the misuse, of most industrial materials. Rust Bullet® is no exception to this rule.
2. The applicator and his assistants need to ensure that there is adequate ventilation at the worksite. If this is not possible, a self-contained breathing apparatus or organic vapor filter with a particulate pre-filter must be used. Filters must be changed if and when they become saturated. Protective gloves and safety glasses must also be worn.
3. Due to the superior adhesive properties of Rust Bullet®, we strongly recommend that protective clothing be worn including long sleeves and a spray sock.
4. It is also critical to avoid any conditions that may cause a fire. Avoid open flames, pilot lights, sparks, heating elements, cigarettes, or any and all possible sources of ignition.

*For more complete coverage of safety issues, see MSDS.