

High Solids Surface Tolerant Epoxy

Features

- Outstanding wetting and adhesion properties
- Low temperature cure
- Excellent adhesion to old coatings and marginally prepared substrates
- Reduces edge lifting of old coatings
- Outstanding flexibility
- Excellent as a universal primer and/or tie coat
- Very low stress
- Trace solvent
- Contains corrosion inhibitors
- Contrasting translucent yellow color

Typical Uses

RustGrip 2330 is used as a universal primer over marginally prepared steel substrates and as a bonding (tie) coat over old existing, aged coatings. The outstanding wetting characteristics of RustGrip 2330 allows the coating to penetrate tightly adherent rust and voids in existing coatings to yield a sound base for a wide variety of fresh topcoats. Being solvent free, edges of existing coatings are not lifted thus reducing undercutting and peeling of the existing coating.

Excellent for use as a tie coat over existing coatings, as well as over rusted and pitted steel surfaces. Excellent for use on structural steel, steel tanks, barges, water tanks, refineries petrochemical plants, power plants, railcars, pulp & paper mills and others as recommended.

Physical Data

Impact resistance (ASTM D 2794)	
Direct impact	160 in.-lbs.
Adhesion (ASTM D 4541)	4664 psi
Temperature resistance (non-immersion)	
Continuous	250°F
Non-continuous	300°F
Theoretical volume solids of mixed material:	100%
Theoretical coverage of mixed gallon (1 mil)	1,604 sq. ft.
Volatile Organic Content	
Unthinned	0 lbs./gal.
Reducer 1 @ 1 pint/gal.	.90 lbs./gal.
Reducer 2 @ 1 pint/gal.	.96 lbs./gal.

Resistance

Refer to desired finish coat for chemical resistance information.

Film Thickness (per coat)

Dry film thickness: 1 to 2 mils
Wet film thickness: 1 to 2 mils
Theoretical coverage: 1,604 sq. ft. @ 1 mil DFT
802 sq. ft. @ 2 mils DFT

Primer/Substrates

RustGrip 2330 is used primarily over Hand Tool cleaned steel where high performance is required and abrasive blasting is impractical. Should be used as a tie coat over most existing aged coatings. A test patch over aged existing coatings is recommended.

Topcoats

RustGrip 2330 is typically topcoated with epoxies and / or polyurethanes such as EpoxyGrip 2100, EpoxyGrip 2000, EpoxyGrip 2200, MasticGrip 2500, UreGrip 3000 and UreGrip 3300. RustGrip 2330 may also be topcoated with alkyds, silicone alkyds, vinyls, acrylics and others as recommended.

Color

RustGrip 2330 is supplied in a translucent yellow color to facilitate contrast to the substrate being coated.

Shipping Data

Packaging unit	<u>2 gal.</u>	<u>10 gal.</u>
Base	1 gal.	5 gal.
Converter	1 gal.	5 gal.
Shipping weight (approx.)	<u>2 gal.</u>	<u>10 gal.</u>
Package unit	20 lbs.	100 lbs.
	<u>1 gal.</u>	<u>5 gal.</u>
Reducer 1	8 lbs.	40 lbs.
Reducer 2	9 lbs.	45 lbs.
Flash Point: (Setaflash)		
Base	above 140°F	
Converter	above 140°F	
Reducer 1	53°F	
Reducer 2	100°F	
Shelf Life: 3 years for both the base and the converter when stored inside at 40°F to 110°F.		

RustGrip 2330 Product Data Sheet

Surface Preparation

Remove oil and grease from the surface with solvent or a commercial cleaner, which does not leave a residue according to SSPC-SP1.

Steel and Aged Galvanized: Hand Tool cleaning per SSPC-SP 2, Power Tool cleaning per SSPC-SP 3 or High Pressure Water cleaning per SSPC-SP12/NACE 5 WJ-4.

Mixing

Power mix each component, then blend Converter into the Base and mix until uniform at the following ratio:

	<u>2 Gal. Kit</u>	<u>10 Gal. Kit</u>
RustGrip 2300 Base	1 gallon	5 gallon
RustGrip 2330 Converter	1 gallon	5 gallon

Thinning

Thinning is not required for most applications; however RustGrip 2330 may be thinned up to 1 pint/gal. Reducer 1 is recommended for applications temperatures below 70°F and Reducer 2 is recommended above 70°F.

Pot Life

One hour at 60° and less at higher temperatures.

Applications Conditions

	<u>Material</u>	<u>Surface</u>	<u>Ambient</u>
Minimum	50°F	50°F	50°
Maximum	90°F	110°F	110°F

Special thinning and application procedures are required outside these temperatures. Surface temperatures should be 5°F above dew point to prevent condensation.

Application Equipment

Conventional Spray: Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8" I.D. minimum material hose and a .070" I.D. fluid tip and air cap are recommended.

Airless Spray: Sprayer such as Graco's Bulldog with a 30:1 ratio and a .017" to .021" tip is recommended. A 30 mesh inline filter is recommended.

Power Mixer: Use only explosion proof power mixers.

Brush or Roller: Use medium brush and short nap roller with solvent resistant fibers and core.

Drying Time

The following minimum times are based on a 2 mil DFT unthinned film.

<u>Surface Temperature</u>	<u>To Recoat</u>
50°F	24 hrs.
60°F	18 hrs.
70°F	12 hrs.

Maximum Recoat

<u>Surface Temperature</u>	<u>Days</u>
50°F	120
75°F	60
90°F	30

If the maximum recoat time is exceeded, the coating should be sweep blasted with fine aggregate to roughen the surface.

Cleanup

Cleanup with Reducer 1 or Reducer 2.

1/28/10

CAUTION: Read and follow all caution statements on this product data sheet and on the Material Safety Data Sheet for this product.

CONTAINS COMBUSTIBLE LIQUIDS. OSHA CLASS IIIA LIQUIDS. Vapors are heavier than air and will accumulate. Extinguish all flames and prevent all sparks. All electrical equipment and installations should be made and grounded in accordance with the National Electrical Code. Where explosion hazards exist workers are required to use non-sparking tools and wear non-sparking shoes

HEALTH: In confined spaces workers must wear fresh airline respirators.

WARRANTY: Any recommendation of U.S. Coatings contained herein, covering use, utilization, chemical or physical properties and other qualities of the products sold is believed reliable; however U.S. Coatings makes no warranty or representation with respect thereto. Use or application is at the discretion of the Buyer without liability or obligation whatsoever of U.S. Coatings.