POR15-Rust Preventive Paint

CONTAINS ISOCYANATES

Application Information

DIRECTIONS FOR USE PLEASE READ (When all else fails)!

KEY POINTS TO MAKE YOUR POR-15 WORK
POR15 Rust Preventative Paint withstands up to 232℃

1. **You should have a rough, clean and DRY surface.**
2. **Apply a MINIMUM of two coats, too thin a total coating will allow rusting.**
3. **If not sandblasting, use the Marine Clean and Metal Ready after sanding.**
4. **DO NOT use other Solvent Based Preparation products, Prepsol, Rust Converters, Thinners etc.**
5. **If a wire brush on a drill/grinder is used, it leaves a burnished (polished) surface so you must sand afterwards and then use Metal Ready.**
6. **Applications applied too thickly or subsequent coats too soon will cause bubbles.**
7. **If used in underwater applications (boat keels) allow at least 3 days cure time and top coat.**
8. **As this paint is generally used on rough rusty surfaces it is not milled to a top coat specification. If a smooth finish is required it is advisable to strain it.**

PRODUCT DESCRIPTION

NOTE: THIS PRODUCT IS UNLIKE ANY OTHER PAINT OR COATING YOU HAVE USED IN THE PAST. Therefore, please read the instructions carefully and completely before using POR-15. Please also read the instructions on the label of the can. Reading this material will better acquaint you with POR15 and enable you to achieve a superior result. POR15 is a rust preventive paint designed for application ***directly*** onto rusted or seasoned metal surfaces. It ***bonds*** to the metal and therefore for best results it should be applied directly onto bare metal. It dries to a rock-hard, non-porous finish that won't chip, crack or peel, and it prevents rust from re-occurring by protecting metal from further exposure to air & moisture. POR15 is sensitive to UV light (sun) and must be top-coated for ***prolonged*** exposure to sunlight. Whilst the product doesn't breakdown the colours will change. Top-coating is only required for areas exposed to sunlight..

APPLICATION PROCEDURES

If the temperature is below 12℃ do not apply POR15 unless the object to be painted has been heated.

Surface preparation: Rusted surfaces are best; seasoned metal and sandblasted surfaces (not bead blasted) are also good. Smooth surfaces, bead blasted or body panels should be keyed with at least a 320 Grit sandpaper to roughen the surface, prior to painting and use of Metal Ready is strongly advised.

STIR CONTENTS OF CAN THOROUGHLY before painting. Do Not Shake (creates bubbles). If you experience difficulty in taking the lid off, dent the centre of the can lid slightly with a hammer.

Dispense a quantity of POR-15 into a separate container and seal the can immediately, ensuring the groove is free of paint (use glad wrap between the lid and the can). Refrigerate unused portion of POR-15 for longer shelf life.

NOTE: Left over portions of POR-15 should not be put back into the can as this will shorten its shelf life. Moisture will shorten the life of un-used POR-15.

Application is a 3 or 4 stage process

1. CLEANING

Like all paints you need to get rid of all loose rust, old paints, oils, greases, grime or other foreign substances. (wire brush)

Then remove any grease or oil with POR15 Marine Clean as it does not have any silicones or solvents in it's makeup. It may be diluted by upto 50% which makes it an economical general cleaner. (except on carpets). Spray Marine Clean (mixed with hot water) onto the metal and leave for approx. 15 minutes to half an hour. Wash off with water and repeat if necessary. **Do not use solvent based cleaners.**

2. ETCHING

Spray on Metal Ready which neutralizes surface rust and zinc phosphate etches the metal. Leave the Metal Ready on the surface keeping it "wet" for 20-30 minutes, then wash off with water. Dry the surface completely. 100% (heat gun is best) You should see an orangey salt and pepper look.. Any white powder residue should be washed off the metal and dried again. (excessive zinc phos). Failure to dry it properly will trap moisture under the paint and the rust will form again. **Do not leave Metal Ready on for long period, more rust will form.**

3. PAINTING

Wear gloves, POR-15 does not come off skin after it has dried (stays 4-5 days).

Apply POR15 in light coats, with a minimum of brush strokes, which gives a sprayed on effect.

Allow to dry approx. 3-5 hours depending on humidity. Tacky but almost dry, your finger nail will still dent it but it doesn't come off on your finger. Too soon will leave bubbles through the 2nd coat. Apply the 2nd coat. (A min of 2 coats or 3 coats for Marine or Industrial use.) If any of the coats become more than 12 hours old, wet sand with a 600 grit paper to roughen up the surface.

THINNING:

You may thin with POR-15 Solvent up to 5% for brushing purposes.

SPRAY APPLICATION:

Use 250KP (30-35lbs) pressure for an HVLP gun or 60 psi (414 KPA for a high pressure gun) normal gloss. Reduce pressure for lower gloss 200 KPA (20-25lbs HVLP or 50 to 60 High Pressure Fun). Thin only with POR-15 Solvent, if necessary, we have found that 12% is best, no more than 20%.

- We recommend 3 coats to build paint thickness to get 1.6ml or 40 microns dry.
- NOTE: Organic Vapour particulate respirators, NIOSH/MSHA Approved, **must be used** when spraying POR-15.

4. TOP COATING (optional)

If it's exposed to UV then it does require a top coat.

Our Chasiscoat (semi gloss) or Blackcote (gloss) make excellent top coats for chasis usage. The Hardnose two pack POR-15 paint range has more colour selection and is very similar to the other POR-15 products with excellent finish coat appearance and toughness of POR-15. Other brands of single and two pack paints may be used.

Tie Coat or Self Etching Primer make excellent sand-able primers which can be applied to POR-15 Rust Preventative Paint. Tie Coat can be applied from touch dry to upto one month later and Self Etch can be applied when paint is fully cured upto one month later. (As long as the surface is free of grease and oil).

If using another primer then use te following method:- After the last coat of POR-15 has been applied, wait approx. 2 hours until the POR-15 coating is tacky: then apply a light dust coat of primer and let dry. Next apply a full coat of primer and follow normal top coating procedures. If the primer is lacquer based, apply dust coat only after POR-15 is dry to touch. OR, to topcoat a cured POR-15 surface with product other than Tie Coat, wet sand with 600 Grit until gloss is dull, then paint.

SANDBLASTED SURFACES

Apply POR-15 Rust Preventative Paint directly to the sandblasted surface. **No other preparation is necessary.** Etch Primer should not be used after sandblasting. If surface rust is observed at a later stage use **Metal Ready** as per above. *Glass bead blasting needs keying and Metal Ready to give it good adhesion.*

CLEAN UP

Use POR-15 Solvent or lacquer thinner for clean up. This must be done before the POR-15 dries. Once it is dry it cannot be removed by any solvent. Avoid skin contact. Remove from the skin at once to avoid temporary staining.

USE OF GLOVES AND VENTILATING EQUIPMENT IS STRONGLY RECOMMENDED. *KEEP OUT OF REACH OF CHILDREN, PETS, ETC. HARMFUL OR FATAL IF SWALLOWED. DO NOT USE ON CHILDRENS TOYS WHICH MAY BE PUT INTO THE MOUTH. USE IN WELL VENTILATED AREAS ONLY.*

POR-15 QUESTIONS AND ANSWERS

LOTS OF PRODUCTS CLAIM TO STOP RUST; SOME ARE PAINTS, SOME ARE CONVERSION PRODUCTS, SOME ARE RUST TREATMENTS. NONE OF THEM SEEM TO REALLY STOP RUST PERMANENTLY.

WHY IS POR-15 DIFFERENT, AND WHY SHOULD I BELIEVE IT WILL WORK ANY BETTER THAN OTHER PRODUCTS?

Rust is caused by moisture coming in contact with metal, which causes a chemical reaction called oxidation. All paints provide a measure of protection for a while, but they are eventually softened and weakened by moisture, it is a matter of time before moisture penetrates the painted surface and attacks the metal below. All of the so-called rust preventative paints on the market (except POR-15) are weakened by exposure to moisture. POR-15 is strengthened by exposure to moisture. Notice the hardness of POR-15 coating. It doesn't chip, crack, or peel like ordinary paints do, and its hardness will resist the wear and tear of every day life.

Rust conversion products claim to change the chemical nature of rust and convert it to a more stable element that won't rust again. History of the failure of these products is well documented; most simply don't work for more than a few months at best, and they are subject to the same chipping and cracking that occurs with ordinary rust coatings.

POR-15 works because it chemically bonds to rusted metal and forms a rock-hard, non-porous coating that won't crack, chip or peel. It keeps moisture away from metal with a coating that is strengthened by continued exposure to moisture.

CAN I PAINT OVER POR-15 WITH OTHER PAINTS?

Yes absolutely. Be sure to read our directions and tips regarding top coating before using POR-15.

CAN I USE A BODY FILLER OR PUTTY WITH POR-15?

Yes. First paint both sides of the rusted area with POR-15, then use body filler or putty as soon as the POR-15 is dry to the touch. As soon as the putty is dry to the touch, paint another coat of POR-15 over it sandwiching it in.

HOW LONG DOES IT TAKE TO DRY?

The more humid the air is, the faster it will dry. Usually 2 - 5 hours and up to 48hrs for a full cure.

IS IT DANGEROUS TO GET POR-15 ON MY HANDS?

No, but if you do you will have to remove it at once with solvent or lacquer thinner. If it dries you will be "wearing" it for 4 - 5 days until the natural oils and flaking skin remove it.

ARE THE VAPOURS DANGEROUS?

Yes. Always paint in a well ventilated area. It is not dangerous if you follow our simple instructions.

WHAT IS THE "PROPER PREPARATION"?

We have developed a product which we call 'Metal Ready'. NOTE: New steel is coated with a protective oil finish at the mill. This finish must be removed before using POR-15 or Metal Ready. Wash metal with our product 'Marine Clean', then rinse with clean water and dry.

WHICH COLOUR SHOULD I USE - BLACK, SILVER, GREY OR CLEAR?

Silver contains metal filler and should be used in badly rusted, pitted areas. It will fill in holes better than black or clear. Black is generally used on frames, undersides of fenders. Clear renders the smoothest finish and is often used as pre-primer on exterior surfaces and on fiberglass. Grey is an excellent choice for all general work, especially machinery.

MUST I PAINT OVER POR-15 TO MAKE IT LAST?

No, but POR-15 is UV sensitive and must be top coated if the area to be painted will be continually exposed to sunlight. The sun will not destroy the POR-15 but its appearance will change cosmetically. That is why we recommend top coating it.

CAN I APPLY POR-15 OVER OTHER PAINTS?

Yes, but you will lose the important benefits of POR-15. You must remember that ordinary paints are weakened by exposure to moisture. POR-15 can't stop rust if it isn't in direct contact with the base metal.

CAN POR-15 BE USED WITH FIBREGLASS?

Yes. It will adhere better than polyester resin and has a greater strength. You can also use it with a fiberglass cloth to make super-strong surfaces in rusted out areas. Just give it a light sand to provide a key. Clear is used here.

POR-15 Tips

POR-15 HAS MANY USES OTHER THAN SEALING RUST. HERE ARE SOME HELPFUL TIPS WE HAVE PICKED UP OVER THE YEARS:

CHROME MOULDING CLIPS can scratch a new paint job when they are pushed through the body. Put a coat of POR-15 around the holes, under the chrome, before you prime and paint.

FIBREGLASS BODY REPAIRS POR-15 Clear is as hard and more flexible than two part epoxy resins, but requires no mixing and is impervious to topcoat thinners - epoxy is not. POR-15 Clear can be used in place of Fibreglass resin.

STAINLESS STEEL TRIM PIECES that push down around the windshield...if they won't stay down, put some POR-15 in the channel and brace it with wood strips overnight. Regarding windshields, with the rubber removed, put a coat of POR-15 around the body where the rubber rests; this is a high humidity area and should be sealed with POR-15.

POR-15 INSIDE REAR EXHAUSTS will stop rust where it starts. Soak a round glass-cleaning sponge with POR-15 and pull it through the pipes with a wire. Coat exterior from the muffler back.

RUSTED OUT PINHOLES Put a piece of tape behind the larger pinholes, then paint. When the paint dries, pull the tape off and paint the back side as well. POR-15 can be used to seal gas tanks, also, and POR-15 Putty will take care of large holes.

PPC
Permanent Painted Coatings

PERMANENT PAINTED COATINGS (2009) LIMITED
PO Box 5614, Frankton, Hamilton 3242
EMAIL: sales@por15.co.nz **WEBSITE:** www.por15.co.nz