

DualCure™ 200

High Solids Moisture Cure Urethane Primer / Finish

Description:

DualCure 200 is designed for application directly over rusted surfaces. They are engineered to encapsulate the rust and permanently bond to the metal surface, preventing further rust formation by eliminating the possibility of moisture or chemical permeation. DualCure 200 provides excellent durability, impact resistance, flexibility and superior adhesion to rusted, blasted or cleaned metal surfaces. It can also be applied to concrete surfaces.

Advantages:

- Unique Rust Encapsulation Technology
- Economical
- Superior Adhesion
- Flexibility
- Dry in Hours
- No Heat Cure
- Excellent Corrosion Resistance
- Extends Useful Life

Uses:

- Heavy-Duty Machinery
- Exposed Steel & Pipe
- Containers
- Implements
- Restoration
- Vehicles
- Marine

Surface Preparation:

Rusted Surfaces: Remove any loose rust, prepare to the desired level of smoothness by using a wire brush, sandpaper, scotch brite pad or steel wool. Clean any dust, dirt or contaminate and apply directly over the rusted surface.

New or Unfinished Surfaces: Ferrous metal: For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as the minimum for blast cleaning. Proper blast media and blasting equipment shall be used to produce an average profile depth of 1.5 mils minimum. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. If blasting is not possible, use "Hand or Power Tool Cleaning: (SSPC-SP2 or -SP3).

Galvanized Metal: Remove oil by pressure washing with a cleaning soap solution, or "Brush Blasting" (SSPC-SP7) to create the best profile for the maximum adhesion.

Aluminum: Etching with a phosphoric acid pretreatment solution is recommended for maximum adhesion. Clean contamination by scrubbing with a with a cleaning soap solution. Rinse clean with water and allow to dry.

Previously Painted: Repair all damaged areas. Remove gloss from previous paint by sanding or "Brush Blasting" (SSPC-SP7) remove heavy chalk and loose or peeling paint by "Hand or Power Tool Cleaning" (SSPC-SP2 or -SP3). If doubt exists concerning compatibility of this coating with the previous system, apply coating to a representative area (5 square feet minimum) and allow to cure and age several weeks. Then inspect for adhesion failure, wrinkling, lifting, blistering or any other sign of incompatibility. If there are no signs, coating work can proceed.

Mixing Instructions:

Do Not Shake ! Shaking can cause pressure to build up in the can. Open the container carefully in case of pressure build up. Stir with stick . If entire contents of container are not going to be used; then using small cups, dip out the amount of product needed and pour it into a separate container. Seal unused portion. Left open and exposed to moisture the unused portion will thicken and become unusable. Be careful not to seal the can with paint in the lip. This product cures so hard the lid will be sealed shut and cannot be reopened without destruction of the can. If top coating, mix 4 parts Dual Cure 200 with 1 part ACC-909 additive to insure intercoat adhesion.

Material Properties

Gloss Level	95 (black), 70 (aluminum)
Density	9.60 lbs/gal (1.15kg/ltr) mixed
Volume Solids	67-69% (mixed)
VOC	2.50 lbs./gal (299 grams/ltr) mixed
Dry Film Thickness	2.0 - 4.0 mils
Colors Available	Gloss Black, Gray or Aluminum
Pot Life (68°F/20°C)	20 minutes mixed
Theoretical Coverage	553 ft ² / gal @ 2.0 mils dry film thickness
Practical Coverage	As a guideline for airless spraying on large dimensions: 70% of theoretical coverage. For small dimensions: 50%

Application Instructions

Spray Method	Airless	Air Assisted Airless	Air Spray / HVLP	Brush or Roll
Thinner	Xylene	Xylene	Xylene	Use a China Bristle Brush or a Urethane Core short nap roller cover. Apply with even strokes and do not apply excessive amounts. Avoid multiple back-rolls. Allow 2 hrs before re-applying second coat.
Quantity	0-10%	0-10%	0-10%	
Nozzle or Tip Size	0.011-0.013	0.011-0.013	1.0-1.5	
Fluid Pressure	2000 - 3000 PSI	2000 - 3000 PSI	8-10 PSI	
Air Pressure	N/A	50 PSI	45 PSI	
Dry Film Thickness	2.0 - 4.0 Mils	2.0 - 4.0 Mils	2.0 - 4.0 Mils	

Performance Characteristics

Accelerated Weathering: ISO 11507 / ASTM G154	Aluminum: 3500 hours gloss retention @ 60° > 80% <2ΔE color change
Accelerated Weathering: ISO 2813 / ASTM D523	Gloss Black: 3500 hours gloss retention @ 60° < 20% >10ΔE color change
Impact (Direct & Indirect) ASTM D-2794	160 in lbs
Chemical Resistance	100 Double MEK Rubs
Flexibility: ISO 1519 / ASTM D522	Cylindrical Mandrel 10mm ISO 1520 Cupping 5-7 mm
Abrasion Resistance: ASTM D4060	Taber CS-17 / 1kg 400 cycles: 150 mg loss
Salt Spray ASTM B-117	Direct to Rust or Direct to Metal Blasted: 3000 hours
Atmospheric Environmental Corrosion Protection Std:	ISO 12944 C3 @ 200 μm (8 mils DFT)

Dry Times: 70°F @ 3-5 mils DFT

To Touch:	1-2 hrs
To ReCoat:	2-3 hrs
To Topcoat with Aeresol:	3 hrs min / 24 hrs max
To Topcoat with Urethane:	4 hrs min / 24 hrs max
To Handle:	3-4 hrs

Health & Environmental:

In accordance with OSHA regulations on hazardous materials, harmful and irritating if in contact with skin, eyes and by inhalation. Observe safety information from MSDS sheets. Always wear proper protective suits, gloves and eye protection. In case of eye contact, immediately wash with large amounts of water and contact a medical expert. If spraying, always wear proper NIOSH approved respirators. Fresh air fed respirators are preferred. Do not eat, drink or smoke during application. Discharge, treatment or disposal is subject to federal, state, commonwealth, provincial and local laws. Since empty containers retain product residue, follow label warnings even after container is emptied. Residual vapors may explode on ignition; do not cut, drill, grind or weld on or near this container.

Cleaning Instructions:

Cleaning tools: Clean immediately after application using MEK.

Warranty / Disclaimer:

The technical data and other printed information furnished are true and accurate to the best of our knowledge. The products are warranted pursuant to acceptance of limited warranty. A copy of which can be obtained from Baril Coatings, which is the exclusive warranty with respect to the sale of this product. The modification of any component or uses not outlined in this bulletin nullifies the warranty unless advance written confirmation is obtained from Baril Coatings. No other warranties expressed or implied shall apply. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, shall be to supply replacement materials as set forth in the limited warranty.