Epoxy Recoat Window Technical Bulletin

MANUFACTURER

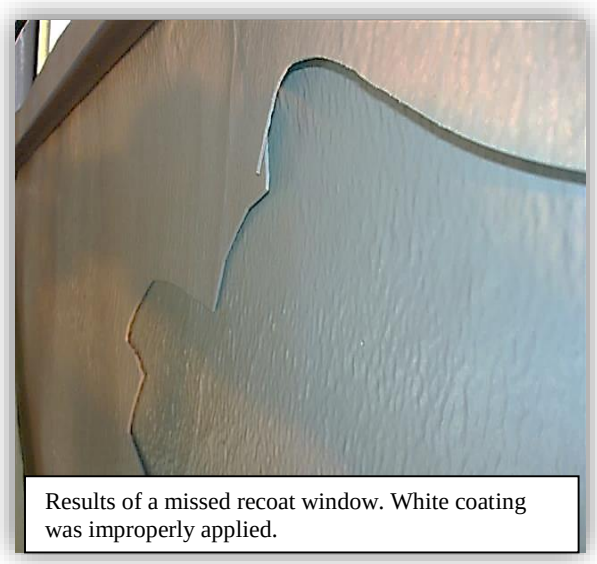
Raven Lining Systems
13105 E. 61st Street, Suite A
Broken Arrow, OK 74012
(918) 615-0020

DESCRIPTION

In some situations, multiple applications of Raven Lining Systems coating may be necessary. In such instances, care must be taken not to exceed the recoat window of the previous coat in order to protect the surfaces from contamination and, if necessary, perform the proper surface preparation to ensure adequate inter-coat adhesion. Please refer to each product's Technical Data Sheet (TDS) for up-to-date recoat windows and proper application.

In general, once mixed and applied, Raven epoxies progress through the cure cycle, which is largely dependent upon temperature. Once the coating has gelled, typically 2-4 hours after mixing, an additional coat may be applied. This will allow the previous coat to support the successive coat without sagging while still allowing the two coats to bond successfully to one another. As the coating continues to cure, the ability of the epoxy to chemically react with successive applications diminishes. Under controlled conditions recoating may be permissible up to 18 hours. <u>However, it is recommended that no more than 12 hours, at 70° F substrate temperature, should be allowed to pass in between applications</u>. Some products may have a higher or a limited recoat window. The recoat window narrows as the temperatures increase. Additionally, the surfaces to be recoated must be kept free of contamination such as dust, dirt, water, condensation, oils, grease, amine blush, etc. If the recoat window is exceeded or the surface becomes contaminated, certain procedures must be performed to prepare the coating for additional coating applications.

If the recoat window is exceeded, the area to be recoated will need to be profiled to provide a mechanical means for the additional coating to adhere. Prior to profiling, all surfaces should be cleaned in order to avoid driving contaminates into the coating. Typically, pressure washing will remove most contaminates; however, a degreasing agent may be required if contamination has occurred. Profiling can be accomplished by grinding the surface, dry abrasive blast or wet abrasive blast. When grinding, use a rough grinding disc, such as 36 to 80 grit, to create a profile. Dry or wet abrasive blasting should be done in a manner similar to sweep blasting with medium grit media. The surfaces should be evenly blasted to create a profiled surface. All prepared surfaces will then need to be cleaned of dust and blast media then thoroughly dried prior to the coating application. <u>Topcoats should be applied to a minimum thickness of 30% of the basecoat</u>.



Results of a missed recoat window. White coating was improperly applied.