InterChem

METAL TREATMENT
RUST CONVERTER

CORROSEAL

FEATURES

- Two in one copolymer rust treatment
- Clings to vertical surfaces
- Neutralizes rust
- Leaves black acrylic protective coating
- Prevents future rusting for up to 1 year
- Dries in 30 minutes
- Non-flammable, water based polymer

PROPERTIES

Appearance: Milky white/beige paste.
Boiling point: 212 ºF
Specific gravity: 1.05-1.10 gr/cc
Non volatiles: 25 %
Solubility in water: Soluble
Flash point: None
Storage stability: Keep away from strong oxidizers
pH of liquid: 4-5
Flammability: Non-flammable
Packaging: 4x1 gallon Case
5 gallon pail
55 gallon drum
275 gallon tote

- Properties are typical and subject to usual manufacturing tolerances.

INTERCHEM CORROSEAL® is a combination of acrylic copolymers and acids that will neutralize rust and leave a black glossy coating of acrylic paint. It converts rust into an acrylic-iron coating. It also prevents future rusting for up to one year. **INTERCHEM CORROSEAL®** is easy to apply and may be brushed or rolled on. It combines two steps in one; a single application neutralizes rust and leaves a protective black acrylic coating. Product will dry within 30 minutes and it can easily be cleaned up by washing down with water.

Refer to the label and attached SDS for instructions and precautions. The information contained in this safety sheet is aimed at creating a guide for the selection and use of the product. However, we are not responsible for any use not recommended by Interchem.

PROFESSIONAL ENGINEERING PRODUCTS

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INTERCHEM CORROSEAL® RUST CONVERTING PRIMER

Product Description: Water based, single component, unpigmented, styrene butadiene elastomeric polymer, with rust converting modifiers.

Basic Use: INTERCHEM CORROSEAL® is recommended for use on rusted or partially rusted steel surfaces as a rust converter/paint primer, and as an etch-primer on aged tight paint of any color, and as sealer on some non ferrous metals Protects against future rusting. Can be used on welds. Eliminates need to mechanically blast to white metal.

Availability	CS-001 4ea 4 Litre containers, CS-032 12 ea 1 Litre, CS-520 55 gallon
	Milky, off-white to tan liquid.
Appearance:	Very Mild.
Odor:	Do Not Thin.
Thinning:	200 square feet per gallon @ 2.5 mil dry film thickness.
Coverage:	4.9 square meters per liter.
Spreading Rate	8-10 mils wet film thickness, 200-250 microns, to create optimum dry film thickness of 2.5 mils to 3.5 mils DFT (65 to 90 microns) to cover anchor profile.
Clean up	Soap and water for equipment, hands, clothes. Clean dry spatter with lacquer thinner.

INTERCHEM CORROSEAL® RUST CONVERTING COPOLYMER PRIMER

SURFACE PREPARATION STANDARDS

• SSPC-SP 1	Solvent Cleaning - (Do not use hydrocarbon solvents)
• SSPC-SP 2 PWB C Sa 1	Hand Tool Cleaning
• SSPC-SP 3	Power Tool Cleaning
• SSPC-SP 7/NACE 4	Brush-Off Blast Cleaning
• SSPC-SP 12/NACE 5	Surface Preparation & Cleaning of Metals by Waterjetting Prior to Recoating Field
• SSPC-TU 4	Methods for Retrieval and Analysis of Soluble Salts on Substrates Standard Method
• SSPC-VIS 2	for Evaluating Degree of Rusting on Painted Steel Surfaces Indicating Oil or Water
• ASTM-D4285-83	in Compressed Air

Standards are available at www.sspc.org www.astm.org & www.nace.org

INTERCHEM CORROSEAL® RUST CONVERTING COPOLYMER PRIMER

APPLICATION SPECIFICATIONS

APPLY ON STEEL rust and aged paint over an anchor profile where mill scale has been removed by any prior sandblasting or by ultra-high pressure water jetting:

• Clean surface with a degreaser with good rinsability (Simple Green) to remove oils, grease, fuels, salt, other chemicals, to SSPC-SP 1. Rinse off cleaner with fresh water. Do NOT use acetone and ordinary dish washing detergents as they leave behind a residue of sulfonic acids or other unknown chemicals which interfere with paint adhesion. Use Simple Green degreaser to also remove mineral salts as to SSPC-TU- 4.
(Sunshine Makers Inc., www.simplegreen.com)
• Remove lose flaking rust, weld slag, loose paint with power sanding tools, needle gun, descaler, wire brush, or water blast; to SSPC SP2, SP 3, SP7 or SP12.
• Air and steel temperature shall be between 45°F (4.5ºC) and rising to 100°F (37.7ºC) & falling.
Wait until morning dew is off the surface before coating. Do not apply within 4 hours of expected rain fall or fog. Prepared surface shall be eye-visible dry. Do not apply to sweating steel. INTERCHEM CORROSEAL® will tolerate some moisture. However, this does not include running, dripping, or sweating steel.
• In enclosed compartments you must have two way air flow (ASTM Spec). Apply mechanical air movement of at least 10 to 20 atmosphere changes per hour. If temperature is low add heat.
• DO NOT THIN INTERCHEM CORROSEAL®.
• Prepared surface shall have a neutral pH of 6-8 before INTERCHEM CORROSEAL® application.
• Mix until color is uniform tan.
• Always prepare a test patch to ensure compatibility with substrate and follow-on coatings.
• Apply by synthetic bristle brush or short nap roller from a plastic or stainless pan.
Spray application can be by pot sprayer or airless sprayer using a 19 - 21 tip. Do not over mist during application. With air unit, work about 10" (25 cm) from surface with 6"-8" (15 to 25 cm) fan. Airless work depends on the equipment. Electrostatic works well.
• Apply 8-10 mil wet coat (203-254 micron) checking with wet film gage. This will appear as a thick white/gray film with no rust showing through. INTERCHEM CORROSEAL® turns from white to black with rust conversion. 8-10 mil WFT produces 2.5-3 mil DFT to cover standard profile of the steel.
• There shall be no runs, sags, streaks, flashes, laps, pin holing or catering. Do not apply multiple coats of 8-10 mils WFT. Do not pattern or groove. Deep grooves from poor application will re-rust.
• If INTERCHEM CORROSEAL® turns gray upon application, a 2nd light coat of INTERCHEM CORROSEAL® needs to be applied to gray areas. Second coat, if needed to achieve correct 8-10 mil wet film thickness should be applied when first coat is still damp and tacky. There shall be no picking up or rolling up of the first coat during second application.
• Drying time is related to air circulation, temperature, film thickness, number of coats. At 77° F (25° C) INTERCHEM CORROSEAL® should be dry to touch in 30 minutes.
• Do not pour unused INTERCHEM CORROSEAL® from roller pan or air pot back into original container to avoid contamination.
• Clean up with soapy water and rinse well.

To Etch-Prime aged tight paint, new fiberglass, some aluminum:
• Always test for required adhesion to substrate and coating compatibility. • Remove contaminates from surface. Small areas may be solvent-wiped with clean cloth. •Apply INTERCHEM CORROSEAL® in 5 mil wet film thickness (127 micron). • If you abrade surface by SP 2, SP 3 or SP 7 to achieve 1-2 mil surface profile (25-51 micron) apply INTERCHEM CORROSEAL® 6-8 mil wet (to 203 micron) to cover anchor profile with dry film. • Allow 2 hours drying, then topcoat within 30 days with any marine- grade coating compatible with INTERCHEM CORROSEAL® Primer.

Cleanup

Normal clean up: Use detergent and cold water for equipment, hoses, hands, cleaning wet Interchem Corroseal® from clothing. Rinse with tap water. Use no mineral spirits. Dark stains clean up with 1:4 bleach to water. Use lacquer thinner to remove hard splatters.

Handling & Toxicity:

Refer to SDS sheet for complete details. Interchem Corroseal® contains no chemicals listed in EPA 40 CFR cp 1, Part 433. If swallowed, induce vomiting. Interchem Corroseal® presents no significant vapor hazard but you should not breathe mist during spraying. Wear rubber gloves and protective glasses. In case of eye contact flush with plenty of water. Skin contact, clean with detergent and water. Allow empty container to air dry then dispose as waterborne latex container.

Limitations:

- **DO NOT THIN.**
- Keep from freezing. •Apply between 45°F and rising and 100°F and falling (7°-37°C).
- Test on all zinc galvanized steel as some formulations do not accept Interchem Corroseal® converters.

Refusal appears as transparent Interchem Corroseal® finish with unconverted rust areas clearly visible.

- Do NOT USE on zinc chromate or phosphates, lead, magnesium, copper powder, graphite, borate pigments, on most chromate.
- Chromate-treated prefabricated steel building cold rolled perlins and gutters shall reman dry until top coated.
- Cold rolled steel can require abrading to anchor profile and degrease.
- Do not use where in direct contact with food. May be used when top coated with an FDA approved topcoat. Check first with the top coat supplier to see if an extraction test is required.
- Waterborne topcoats can be subject to tannin staining and must be tested ± 48-60 hours before overall use. If stain through occurs apply oil based stain blocker over INTERCHEM CORROSEAL® or apply oil-based topcoat. See Interchem's Corroseal® label and topcoat manufacturer requirements.
- Always prepare a test patch to ensure compatibility with substrate and follow-on coatings.
- Refer to Safety Data Sheet (SDS) and label for precautionary information.

Top coating Guide

- ON STEEL DO NOT TOP COAT BEFORE 24 HOURS - or rerusting may occur. 24 hour cure is required to complete the chemical conversion process within the rust.
- The surface shall be free from any contamination prior to applying subsequent top coat.
- INTERCHEM CORROSEAL® bonds well with marine/industrial quality oil based enamel, urethane, moisture-cure polyurethane, epoxy, coal tar and most other oil based industrial/marine topcoats.
- Follow all intermediate/topcoat manufacturers specifications. Always apply a test patch to ensure compatibility.
- Do not thin intermediate or topcoats beyond manufacturers specification as excess solvent creates cohesive failure.
- Avoid tannin staining through water based topcoats by applying an oil-based stain blocker as an intermediate coat when top coating with a waterborne product. See “Limitations” for specific issues.