



# Xp<sup>3</sup>RB5100

## Anticorrosive Coating – Application Guide

### PRE-APPLICATION

#### 1. Brush and Dry the Surface

The surface to be coated with Xp<sup>3</sup>RB5100 must be completely dry, and large flakes of rust should be scraped or wire brushed off. Remove loose mill scale by lightly scraping, sanding, or wire brushing.

*The surface to be coated must be completely dry.  
No additional surface preparation is necessary.*



#### 2. Stir the Product Before Using

- Xp<sup>3</sup>RB5100 should be shaken or stirred thoroughly for 2 minutes or until completely uniform. Continue stirring during application.
- If product has been sitting for six months or more, it may develop settling. Follow the same process as above but increase the stir time and be sure to break up clumps on bottom, if any.
- Do not dilute or mix Xp<sup>3</sup>RB5100 with any other product

#### 3. Clean All Application Products – Before and After

- All application equipment should be cleaned and flushed with Xylene or Methyl Ethyl Ketone (MEK) (DO NOT USE THINNER), and dried as Xp<sup>3</sup>RB5100 will be affected by water contamination. Do not allow mixed material to stand in equipment after use.

### APPLICATION

Apply Xp<sup>3</sup>RB5100 with a sprayer, roller, or brush. A minimum of two even coats totaling 6 mil (0.006) of an inch should be applied making sure none of the coats are too thick, also taking into account variations in design configurations, application equipment, temperature and other factors. The second coat of Xp<sup>3</sup>RB5100 must be applied to completely seal the first coat. Ensure seams and irregularities are completely covered. Application below minimum or above maximum suggested dry film thickness ranges might adversely affect performance.



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#### RECOAT AND REPAIR:

If material has reached complete cure and hardness, or if subjected to extended exposure to sunlight, uniformly abrade the surface and feather the edges. The surface must be roughened sufficiently to provide a profile adequate enough to ensure a mechanical bond between the previous coat and new coat.

#### AIRLESS SPRAY:

Graco or equal. Pump ratio 30:1 or higher, 206-7 18 gun with fluid tip of 0.021" or larger orifice size with Reverse-A-Clean tip, 3/8" I.D. or larger high pressure solvent resistant fluid line, 1/2" I.D. or larger air supply line. Continuous air source capable of 80 to 100 psi inbound pressure at pump.

#### CONVENTIONAL SPRAY:

Binks or equal. Pressure material pot with mechanical agitator, dual regulators, air-gages, and oil and moisture separators. No. 18 gun (external mix), 67 fluid nozzles, 65 fluid needle, 67 PB air cap, heavy-duty fluid spring, Teflon fluid packing, 1/2" I.D. or larger high solvent resistant fluid line and 3/8" I.D. or larger air-supply line. Continuous air source capable of 20 cfm or more at 80 psi per nozzle and 60 psi to the pot.

#### GENERAL:

Regulate pressure as required for proper application. Proportionally adjust pressure higher for smaller hose diameter and/or longer hose length and adjust pressure lower for larger hose diameter and/or shorter hose length. Select tip angles and orifice diameters according to application needs.

#### BRUSH:

Short hair or natural bristle.

#### ROLLER:

Carpet-type roller covers.

#### CLOTHING

Wear protective garments, shoes, goggles, and filter masks. Use protective barrier creams on exposed skin areas

#### CONFINED SPACES:

Use explosion-proof lighting and electrical equipment, non-sparking tools, clothes and shoes. Ground all structures and equipment. Use procedures that prevent static electrical sparks. Wear properly fitted appropriate NIOSH/MSHA approved fresh air respirator such as MSA or equal with 1/4" I.D. or larger air supply line connected directly to proper air source during and after application unless air monitoring demonstrates vapor/mist levels are within safe limits, use suction type exhaust fans and blowers with sufficient cfm capacity to keep solvent vapors below 20% of the explosive limit. CAUTION! Air circulation and exhausting of solvent vapors must be continued until the coatings have fully cured to ensure that no potential for fire, explosion or health hazard remains.

#### CURING TIME:

First coat takes 2-24 hours to dry. Once dry to the touch and within 24 hours, second coat should be applied. Additional coats can be applied once previous coat is dry, as long as it is within 72 hours. However, important to note that all times will vary depending on the relative temperature and humidity. Curing time is significantly shorter for higher temperatures or higher relative humidity and longer for lower temperatures or lower

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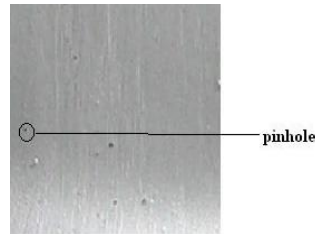
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relative humidity. Curing time is affected by the method of application; the quantity of solvent used; the amount of ventilation and air circulation. Recoat will also take 4-72 hours to cure. (Refer to RECOAT AND REPAIR section if coating reaches complete cure and hardness or if subjected to extended exposure to sunlight).

#### INSPECTION:

Check for desired dry film thickness and for pinholes, holidays, bare areas, etc. before placing in coated object in operating use.



#### PRODUCT STORAGE AND HANDLING

1. Care should be taken to ensure that left-over partial containers are sealed as soon as possible and kept sealed with the original lid or with a plastic polyethylene film remembering to displace as much air as possible.
2. It is recommended to limit the time the container is opened; i.e., only pour what you need and then close the container to protect from skinning.
3. If a skin has formed in a new unopened container or a re-sealed container, remove by cutting edge of skin at the skin/container surface. Discard the skin properly. Stir until uniform. Filter if necessary and apply.
4. **Xp<sup>3</sup>RB5100** is packaged in unlined paint cans. If for any reason **Xp<sup>3</sup>RB5100** is transferred to another container; clean, unlined, paint cans (or similar unlined metal containers) must be used.

#### SAFETY CONSIDERATIONS

We strongly recommend that protective clothing be worn. Protective gloves and safety glasses must also be worn. Follow the Material Safety Data Sheet (MSDS) recommendations.

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