

## RIGSPRAY

### Polyester Glass-Flake Coating

#### Description

Rigspray is a polyester, two-part, high solids, reinforced, glass-flake coating that offers outstanding resistance to corrosion and abrasion. It is resistant to corrosive acids, alkalis, salts and a range of oxidizing chemicals.

#### Uses

Corrosion protection of steel structures that are subject to the most aggressive marine environments (i.e. pilings, sheet piling, bulkheads, helidecks, splash zones, underdeck areas, main deck areas and many other corrosive applications).

#### Features

- Excellent corrosion resistance
- Fast dry and set times
- High build up to 40 mils (1 mm) in one coat
- High abrasion resistance
- Excellent undercutting resistance
- Very low water permeability
- Excellent water/sea water resistance
- High temperature tolerance (up to 150°F / 65°C)
- Excellent cathodic disbondment results
- Good chemical resistance

#### Application

Prepare surfaces by grit blasting to a clean, near-white finish, SSPC-SP10/NACE No. 2. The coating can be applied by brush or airless spray in one coat, up to 40 mils (1 mm) thick in one coat. A wet-film thickness gauge shall be used to measure uniform application. Plate edges, corners and weld areas shall be stripe coated by brush prior to application. This will help ensure adequate coverage of these areas.

The materials shall be 50°F (10°C) minimum before spraying. Initially stir Part A (base) prior to adding Part B (catalyst). The Part B (catalyst) material shall then be added. Ensure the two components are mixed thoroughly using a mechanical whip prior to application. The mixed material shall be sprayed immediately after mixing. **Note: Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.**

When applying by airless spray, refer to the equipment manufacture's operating procedures. In addition, remove pump filter, surge pot and in-line filters.

Clean tools and equipment with Acetone prior to material curing. Great care must be taken to avoid contaminating the coating material with Acetone as this can have adverse effects on the cure of the material.



# Rigspray

## TECHNICAL DATA

PROPERTIES	VALUE
Color	Gray
Solids Content	98% ±2%
Specific Gravity	1.2
Dry Film Thickness Per Coat	20 - 40 mils (508 - 1016 microns)
Recommended Mil Thickness (min./max.)	20 - 60 mil DFT (508 - 1524 microns) (Depending on application environment)
Theoretical Coverage	39 SF/Gal (0.96 m <sup>2</sup> /L) @ 40 mils DFT
Actual Coverage (w/ 30% waste)	27 SF/Gal (0.65 m <sup>2</sup> /L) @ 40 mils DFT
Maximum Humidity During Application	90%
Minimum Dewpoint/Substrate Differential	Dewpoint +5°F (+3°C)
Cure Time @ 72°F (22°C) - Product and Air Temp	
Pot Life	25 - 30 minutes
Re-Coat Window	2.5 hrs. - 2 days
Shore D (80 - 85)	3 - 3.5 hrs
Cure Time @ 50°F (10°C) - Product and Air Temp	
Pot Life	50 - 60 minutes
Re-Coat Window	5 hrs to 4 days
Shore D (80 - 85)	6 to 7 hrs
Substrate Temperature	40°F (4°C) - 110°F (43°C)
Service Temperature	0°F (-18°C) - 150°F (65°C)
Equipment Required	56:1 Airless (min.)
Airless Spray Tip Size	0.023 - 0.031 in. (584 - 787 microns)
Pressure at Tip	1,500 - 2,500 psi (10.34 - 17.24 MPa)
Flash Point	88°F (31°C)
Abrasion Resistance ASTM D4060	0.035 gm
Adhesion Properties ASTM D952	1160 psi (8 MPa)
Salt Water Resistance ASTM B117-57T	20,000 hrs - No effect
Cathodic Disbondment Test	
28 days @ 68°F (20°C)	6 - 7 mm (6,000 - 7,000 microns)
Tensile Strength ASTM D638	4,715 psi (32.51 MPa)
Flexural Strength ASTM D790	10,040 psi (69.22 MPa)

**STORAGE:** 6 month shelf life when stored in original containers @ 41°F (5°C) - 80°F (27°C).

**CLEANING:** Clean equipment with solvent cleaner (Acetone).

**HEALTH AND SAFETY:** Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

**PACKAGING:** 1 gallon (3.8 liter) kit and 5 gallon (19 liter) kits with gray color standard. Other colors available upon request.



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