

DualCure 306

Organic Zinc Rich Primer



U.S. Patents:
6,833,424 & 7,169,876

Description:

Dual Cure 306 is a proprietary organic zinc rich urethane primer. It is formulated for ease of application as a two component system that enables low temperature cure, fast recoat times and resistance to mud-cracking. A self-priming and corrosion resistant primer, 306 is proven to protect steel in the harshest environments. This product was designed for production environments that require fast recoat times. Unlike typical zinc coatings on the market, 306 provides a very smooth, near automotive quality finish at a low VOC. Applications using DualCure 306 Primer may achieve ISO 12944 CX - Extremely High Corrosion protection with a VERY HIGH service life expectancy of >25 years.

Advantages:

- Extreme Corrosion Resistance
- Versatile Single or Dual-Component System
- Superior Adhesion
- 86% Zinc in the dried film
- Fast Recoat
- No Heat Cure
- Easy to Mix and Apply
- Superior Impact Resistance

Uses:

- Heavy-Duty Machinery
- Piping
- Structural Steel
- Manufacturing Equipment
- Vehicles

Material Properties

| | |
|----------------------|--|
| Gloss Level | Matte |
| Density | 20.10 lbs/gal 2.40 kg/ltr (mixed) |
| Volume Solids | 63% (mixed) |
| VOC | 3.2 lbs/gal 383 grams/ltr (mixed) |
| Dry Film Thickness | 2.0-4.0 mils |
| Pot Life | 2-hours mixed @ 68°F/20°C uncovered. May be extended by sealing against moisture |
| Theoretical Coverage | 336 ft ² /gal @ 3.0 mils DFT <i>*Excess millage may cause blistering. 7 Mils max DFT</i> |

Surface Preparation:

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 a minimal profile depth of 1.5 mils, 2 mils is ideal. 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 another Baril high performance primer.

Galvanized Metal: For best performance, application to abrasive blasted surface is recommended. "Brush Blast Cleaning". (SSPC-SP7) is recommended as the minimum for blast cleaning. Comply with the instructions from the applicator of the galvanizing for the proper time frame from when the galvanizing is applied until the blasting process should be performed. Proper blast media and blasting equipment shall be used to produce a minimal profile depth of 1.5 mils. 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.

Aluminum: Not recommended

Previously painted surfaces: Not recommended

Mixing Instructions:

Thoroughly mix product preferably using a mechanical mixing device. The temperature of the mixed product should at least be 45°F during application. Maintain agitation during application. Mix 4 parts of Dual Cure 306 Series Part A with 1 part of ACC-910 Part B.

Application Instructions

| Spray Method | Airless | Air Assisted Airless | Air Spray / HVLP |
|--------------------|-----------------|----------------------|------------------|
| Thinner | MAK | MAK | MAK |
| Quantity | 0-25% | 0-25% | 0-25% |
| Nozzle or Tip Size | 0.013-.017 | 0.013-.015 | 1.1-1.8 |
| Fluid Pressure | 2000 - 3000 PSI | 1000 - 1500 PSI | 15-25 PSI |
| Air Pressure | 50 lbs. | 50 lbs. | 50 lbs. |
| Dry Film Thickness | 3.0 - 5.0 Mils | 3.0 - 5.0 Mils | 3.0 - 5.0 Mils |

Performance Characteristics

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|--|---|
| Accelerated Weathering: ISO 11507 / ASTM G154 | N/A |
| Impact (Direct & Indirect) ASTM D-2794 | 180 in lbs / 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 (5 mils) 306, (3mils) DualCure 174 Topcoat | 9600 Hours |
| Acid Resistant: | Spills: Good, Fumes: Excellent |
| Chlorine Resistant: | Spills: Good, Fumes: Excellent |

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.

Dry Times: 70°F @ 3-5 mils DFT

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|-------------|---|
| To Touch: | 30 mins. |
| To Handle: | 1-hr |
| To Re-Coat: | 15 mins. to 30 mins |
| To Topcoat: | 45 mins. min. to 6 hrs. max. Sanding required > 8 hrs. |

**Applying topcoat prior to ZRU drying may result in solvent pop. Relative humidity will assist in curing process. High humidity may cause a reduction in maximum available re-coat window.*

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.