



POR-15 RUST PREVENTIVE PAINT

Application Information

DIRECTIONS FOR USE Please READ (When all else fails)!!

KEY POINTS TO MAKE YOUR POR-15 WORK

1. You should have a rough, clean and DRY surface.
2. Apply a **MINIMUM** of two coats, too thin a total coating will allow rusting.
3. If not sandblasting, use the Marine Clean and Metal Ready after sanding.
4. Do not use other products, Prepsol, Rust converters, thinners etc.
5. If a wire brush on a drill / grinder is used, sand afterwards and use Metal Ready.
6. Applications applied too thickly or subsequent coats too soon will cause bubbles.
7. If used in underwater applications (boat keels) allow at least 3 days cure time and top coat. Phone if in doubt.
8. As this paint is generally used on rough rusty surfaces it is not milled to a top coat specification. If a smooth finish is required it is advisable to strain it.

PRODUCT DESCRIPTION

Note: This product is **unlike any other paint or coating you have used** in the past. Take time to carefully **read** the instructions completely before using **POR-15**.

Reading this material will better acquaint you with **POR-15** and enable you to achieve a superior result. **POR-15** is a rust preventative paint designed for application *directly* on rusted or seasoned metal surfaces. It *bonds* to the metal and therefore for **best results** it should be applied **directly** onto bare metal. It dries to a rock-hard, non-porous finish that won't chip, crack or peel, and prevents rust from re-occurring by protecting metal from further exposure to air and moisture.

POR-15 Rust Preventative Paint is sensitive to UV light and must be top coated for prolonged exposure to sunlight. Whilst the product doesn't breakdown the colours will change.

APPLICATION PROCEDURES

Surface preparation: Rusted surfaces are best, seasoned metal and sandblasted (not bead blasted) surfaces are also good.

Smooth surfaces, bead blasted or body panels should be keyed with at least a 600 Grit sandpaper to roughen the surface, prior to painting and the use of Metal ready is strongly advised.

STIR CONTENTS OF CAN THOROUGHLY before painting. **Do not shake (creates bubbles)**. If you experience difficulty in taking the lid off, dent the centre of the can lid slightly with a hammer.

Dispense a quantity of **POR-15** into a separate container and seal the can immediately, ensuring the groove is free of paint (use glad wrap between the lid and the can). Refrigerate unused portion of **POR-15** for longer shelf life.

Note: left over portions of **POR-15** should not be put back into the can as this will shorten its shelf life. Moisture will shorten the life of unused **POR-15**.

Application is a three or four stage process:

1. **CLEANING**

- Like all paints you need to get rid of all loose rust. Old paints, oils, greases, grime or any other foreign substances.
- We recommend our **Marine Clean** as it does not have any silicones or solvents in its makeup. It may be diluted by up to 50% which also makes it an economical general cleaner. There are many household uses, except on carpets.
- Spray Marine Clean (mixed with Hot Water) onto the metal and leave for approx. 15 minutes to half an hour. Wash off with water and repeat if necessary

Do not use Solvent based cleaners.

2. **ETCHING**

- Spray on **Metal Ready** which neutralises surface rust and zinc phosphate etches the metal
 - Leave on for approximately 20—30 minutes, keeping wet. Wash off and dry thoroughly. (Heat gun best method)
 - **Dry the metal thoroughly (100%)**. You should see an orangey salt and pepper look. Any white powder residue should be washed off the metal and dried again. (excessive zinc phosphate).
- Do not leave Metal Ready on for long periods, more rust will form.**

3. **PAINTING**

- Wear gloves, POR-15 does not come off skin after it has dried (stays on skin 4-5 days).
 - Apply **POR-15 Rust Preventative Paint** in light coats, and with the minimum of brush strokes, which will give you an almost sprayed on effect.
 - Allow to dry for approx. **3-5 hours** depending on the humidity. Tacky but almost dry, your finger nail can still dent it but it doesn't come off on your finger. Too soon will leave bubbles as the carbon dioxide bubbles through the second coat.
 - Apply the second coat (**min. two coats, three for industrial or marine usage**).
- If any of the coats become more than 12 hours old, wet sand with a 600 grit paper to roughen up the surface.

THINNING:

- You may thin with **POR-15 Solvent** up to 5% for brushing purposes.

SPRAY APPLICATION:

- Use 250 KPA (30-35 lbs) pressure for and HVLP gun or 60 psi (414 KPA for a High Pressure Gun) normal gloss. Reduce pressure for lower gloss 200 KPA (20-25 lbs HVLP or 50 to 60 High Pressure Fun). Thin only with **POR-15 Solvent**, if necessary, we have found that 12% is best, no more than 20%.

We recommend 3 coats to build paint thickness to get 1.6 ml or 40 microns dry.

NOTE: Organic vapour particulate respirators, NIOSH/MSHA Approved, **must be used** when spraying POR 15.

4. **TOP COATING (optional).**

- If it's exposed to UV then it does require a top coat.
- Our **Chassiscoat (semi gloss) or Blackcote (gloss)** make excellent top coats for chassis usage. The **Hardnose** two pack **POR-15** paint range has more colour selection and is very similar to the other **POR-15** products with excellent finish coat appearance and toughness of **POR-15**.
- Other brands of single or two pack paints may be used.
- **Tie Coat** or **Acid 8** primer make excellent sand-able primers which can be applied to **POR-15 Rust Preventative Paint**. **Tie Coat** can be applied from touch dry to up to one month later and **Acid 8** can only be applied when paint is fully cured up to one month later. (As long as the surface is free of grease and oil). It is also a tie between **POR-15** and any other single or two pack that you may wish to use.
- If using another primer then use the following method:- After the last coat of **POR-15** has been applied, wait approximately 2 hours, until the **POR-15** coating is tacky: then apply a light dust coat of primer and let dry.
- Next, apply a full coat of primer and follow normal top coating procedures.
- If the primer is lacquer based, apply dust coat only after **POR-15** is dry to touch.
- OR, to Topcoat a cured **POR-15** surface with product other than **Tie Coat**, wet sand with 600 grit until gloss is dull, then paint.



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SANDBLASTED SURFACES

- Apply POR-15 Rust Preventative paint directly to the sandblasted surface. **No other preparation is necessary.** Etch Primer should not be used after sandblasting. If surface rust is observed at a later stage use **Metal Ready** as per above. *Glass bead blasting needs keying and Metal Ready to give it good adhesion*

CLEAN UP:

- Use **POR-15 Solvent** or lacquer thinner for cleanup, which must be done before **POR-15** dries; once dry, it cannot be removed by any solvent. Avoid skin contact. Remove from skin immediately to avoid temporary staining.

USE OF GLOVES AND VENTILATING EQUIPMENT IS STRONGLY RECOMMENDED. KEEP OUT OF THE REACH OF CHILDREN, PETS, ETC. HARMFUL OR FATAL IF SWALLOWED. DO NOT USE ON CHILDREN'S TOYS WHICH MAY BE PUT INTO THE MOUTH. USE IN WELL VENTILATED AREAS ONLY

POR 15 QUESTIONS AND ANSWERS

LOTS OF PRODUCTS CLAIM TO STOP RUST; SOME ARE PAINTS, SOME ARE CONVERSION PRODUCTS, SOME ARE RUST TREATMENTS. NONE OF THEM SEEM TO REALLY STOP RUST PERMANENTLY.

WHY IS POR 15 DIFFERENT, AND WHY SHOULD I BELIEVE IT WILL WORK ANY BETTER THAN OTHER PRODUCTS.

Rust is caused by moisture coming in contact with metal, which causes a chemical action called oxidation. All paints provide a measure of protection for a while, but they are eventually softened and weakened by moisture, it is a matter of time before moisture penetrates the painted surface and attacks the metal below. All of the so-called rust preventive paints on the market (except **POR-15**) are weakened by exposure to moisture. **POR-15** is *strengthened* by exposure to moisture. Notice the hardness of the **POR-15** coating. It doesn't chip, crack, or peel like ordinary paints do, and its hardness will resist the wear and tear of every day life.

Rust conversion products claim to change the chemical nature of rust and convert it to a more stable element that won't rust again. History of the failure of these products is well documented; most simply don't work for more than a few months at best, and they are subject to the same chipping and cracking that occurs with ordinary rust coatings.

POR-15 works because it chemically bonds to rusted metal and forms a rock-hard, non-porous coating that won't crack, chip or peel. It keeps moisture away from metal with a coating that is strengthened by continued exposure to moisture.

CAN I PAINT OVER POR-15 WITH OTHER PAINTS?

Absolutely. POR 15 will accept all paints, including lacquer based paints. Aerosols and latex paints are fine. Be sure to read our directions thoroughly.

CAN I USE BODY FILLER OR PUTTY WITH POR-15?

Yes. First paint both sides of the rusted area with POR 15; then use U-POL—P38 body filler as soon as the POR 15 is dry to the touch. We also suggest putting another coat of POR 15 over the putty, sandwiching it in, again as soon as the putty is just dry to the touch.

HOW LONG DOES IT TAKE POR-15 TO DRY?

That depends on the ambient humidity (surrounding area). The more humid the area, the faster the drying time, which usually varies from 2 to 5 hours. **Heat has no affect on the drying process.**

IS IT DANGEROUS TO GET POR-15 ON MY HANDS?

No, but if you do, remove it at once with solvent or lacquer thinner. If POR 15 dries on your skin, nothing will take it off, and you will "wear" it for 3 or 4 days until natural oils and flaking skin remove it.

ARE THE POR 15 VAPOURS DANGEROUS TO MY HEALTH?

Yes. That's why you must always paint in a well ventilated area and keep your nose away from the paint container, POR 15 is not dangerous if you follow our simple directions.

WHAT IS THE "PROPER PREPARATION"?

We have developed a product which we call **"Metal Ready"**. NOTE: **New steel is coated with a protective oil finish at the mill.** This finish must be removed before using **POR-15** or **Metal Ready**. Wash metal with our product **Marine Clean**, then rinse with clean water and dry.

WHICH POR-15 FORMULA (BLACK, SILVER, GREY, CLEAR) SHOULD I USE?

Silver contains metal filler and should be used in badly rusted, pitted areas. It will fill in holes better than black or clear. Black is generally used on frames, underside of fenders, etc, because that's the usual colour there. Clear renders the smoothest finish and is often used as a preprimer on exterior surfaces, it is also best for fibreglass repairs. Grey is an excellent choice for all general work, especially machinery.

WILL THE SUN DESTROY MY POR-15 COATING IF I DON'T TOPCOAT IT?

No, your POR 15 protection will remain, but the sun will change its appearance cosmetically, that's why we recommend you topcoat.

CAN I APPLY POR-15 OVER OTHER PAINTS?

Yes, but you will lose the important benefits of POR 15. You must remember that ordinary paints are weakened by exposure to moisture. POR 15 can't stop rust if it isn't in direct contact with the base metal.

CAN POR 15 BE USED WITH FIBREGLASS?

Absolutely. POR 15 is fully compatible with fibreglass and can be used to repair cracks in gelcoat. It will adhere better than polyester resin and has greater strength. Use also with fibreglass cloth to make super-strong surfaces in rusted out areas. Just give it a light sand to provide a key. Generally Clear POR 15 is used here.

POR-15 TIPS

POR-15 HAS MANY USES OTHER THAN SEALING RUST. HERE ARE SOME HELPFUL TIPS WE HAVE PICKED UP OVER THE YEARS.

CHROME MOULDING CLIPS: can scratch a new paint job when they are pushed through the body. Put a coat of POR-15 around the holes, under the chrome, before you prime and paint.

FIBREGLASS BODY REPAIRS: POR 15 Clear is as hard and more flexible than two part epoxy resins, but requires no mixing and is impervious to topcoat thinners - epoxy is not. POR 15 Clear can be used in place of fibreglass resin.

STAINLESS STEEL TRIM PIECES that push down around the windshield... if they won't stay down, put some POR 15 in the channel and brace it with wood strips overnight. Regarding windshields, with the rubber removed, put a coat of POR 15 around the body where the rubber rests; this is a high humidity area and should be sealed with POR 15.

POR 15 INSIDE REAR EXHAUSTS will stop rust where it starts. Soak a round glass-cleaning sponge with POR 15 and pull it through the pipes with a wire. Coat exterior from the muffler back.

RUSTED OUT PINHOLES: Put a piece of tape behind the larger pinholes, then paint. When the paint dries, pull the tape off and paint the back side as well. POR 15 can be used to seal gas tanks, also, and POR-15 Putty will take care of large holes.

MARINE TIPS:

Please contact Permanent Painted Coatings, for advise on all your Marine Applications.

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Hazardous ingredients: Diphenylmethane Dilsocyanate Cas#26447-405, Naptha Petroleum Cas#6472-95-6, Carbon Black Cas#12438-9, Aluminim Cas#7429-90-5. Contents partially unknown

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