



RUST HOLE REPAIR KIT

Application Information

PRODUCT DESCRIPTION

- **Metal Ready 250mls:** Removes surface rust and coats metal with zinc phosphate. It also helps provide adhesion to smooth metal and aluminium.
- **POR 15 Rust Preventive Paint 100mls:** POR 15 Rust Preventive Paint is a non porous paint designed for application directly on rusted or seasoned metal surfaces. It dries to a rock-hard finish that won't chip, crack or peel, and it prevents rust from re-occurring by protecting the metal from further exposure to moisture.
- **P40, 100mls:** is a two component reinforcing polyester filler for adding strength and filling holes to repaired areas.
- **P 38, 100mls:** Is a two component polyester surface filler, used for filling imperfections.
- **Tie-Coat 100mls:** Is a single pack, sandable primer used for tying in POR-15 to topcoats or primers and fillers.
- This Kit also contains **3 brushes**, one each for Metal Ready, POR 15 Rust Preventive Paint, and Tie-Coat.
- A pair of gloves .
- Coarse & fine sandpaper.

Discuss with an engineer if repair is in a structural area.

PROCEDURE

Cleaning:

- Remove all foreign material from surrounding areas, if any wax's, oil's or grease are present these must be removed with **Marine Clean** or similar water based degreaser. (Not solvent based preps).
- Remove any loose paint on and around rusted area. The best method is to expose the metal completely around the rusted area, to be sure that rust has not tracked under the paint, but not as yet bubbled through.

Surface Preparation:

- Rough up surrounding paint with coarse sandpaper, this preparation should be done to both sides of the rust hole where practical. Then knock back the edge of any rusted through areas with a small ball peen hammer.
- Apply Metal Ready to rusted metal and smooth surfaces with brush provided, surfaces should remain wet with Metal Ready for 30min, a longer period will not harm metal, only continue to remove rust, if heavily rusted.
- Rinse off well with water. This will leave behind a coating of zinc phosphate. Salt / pepper look
- Leave to dry.
- **(Metal must be bone dry before painting.)**

Application:

1. Apply a minimum of two thin covering coats of POR 15 Rust Preventive Paint to the exposed metal on both sides of the panel.
Note: Apply the second coat only after the first coat is dry to the touch, generally this is about 3-5 hours - depending on humidity. The higher the humidity the faster it will dry. If it's left longer than 12 hrs lightly sand off the gloss and paint.
2. Mix a small amount of P40 for the job required. **4 lengths of paste to 1 length of hardener, and mix.** The paste is useable until it begins to gel or stiffen. Usually this will be after 5 - 10 minutes.
 - a. Use applicator provided with the filler to apply to gap / recess to be filled. Filler will normally be hard within 30 minutes. Try to avoid excess as once cured it's hard to sand.
 - b. Sand P40.
Note P40 MUST be applied within 3-5 hours of the final coat of POR 15 Rust Preventive Paint being touch dry.
3. Mix P38 **4 lengths of paste to 1 length of hardener, and mix.** The paste is useable until it begins to gel or stiffen. Usually this will be after 5 - 10 minutes.
 - a. Apply as per 2a above.
 - b. Sand to desired finish, with paper provided. Be careful not to sand through the POR 15 Rust Preventive Paint as this will allow moisture to penetrate the metal and then rust may return.
 - c. Coat the whole area with another coat of POR-15.
 - d. Allow the POR-15 to cure. We have found that anywhere between 5 hours and 7 days is the best for applying Tie-Coat.
4. Apply a thin covering coat of Tie-Coat to repaired area and allow to cure (24 hours). Lightly sand with fine sandpaper if required.
5. Mask up the surrounding area with newspaper and masking tape and topcoat with your choice of topcoat.

**PERMANENT PAINTED
COATINGS PTY LIMITED,**
1/4 Prosperity Parade,
Warriewood
NSW 2102.

Free Phone: 1-800 643 229;
Telephone: 02 9999 0122;
Fax: 02 9999 0394
WEBSITE: sales@ppc.au.com
EMAIL: sales@ppcco.com.au

