OneGuard™

REPAIR KIT PROCEDURE

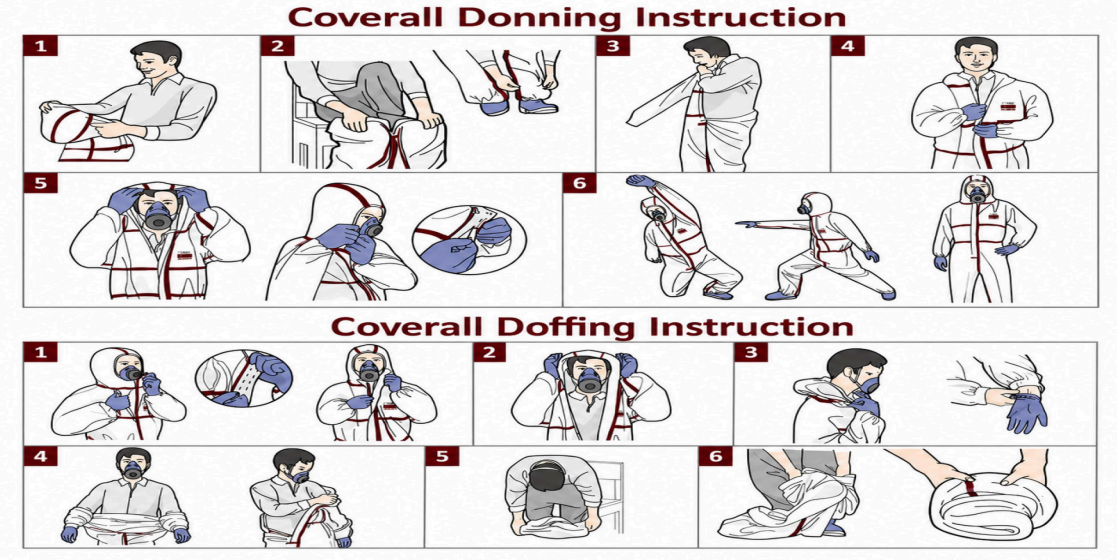
**This Repair Kit Procedure supersedes those previously issued.*

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The Purpose of this procedure is to clearly explain what must be done to spot repair a product tanker coated cargo tank using a OneGuard™ Repair Kit. This spot repair procedure should be used when the original epoxy coating has been misapplied or damaged. OneGuard™ Repair Kit is compatible with standard and phenolic (novolac) epoxies. If you have any questions prior to the application that has not been covered in this procedure, please contact Advanced Polymer Coatings for assistance.

PERSONAL PROTECTIVE EQUIPMENT (PPE)

Donning	Put on and use PPE properly to achieve the intended protection and minimize the risk of exposure.
Doffing	Removing PPE in a way that avoids self-contamination.



PPE APPLIED IN LAYERS

Nitrile Gloves: 7 mil thickness or greater	HazMat Suit: Tychem 2000-4000 or equivalent
Chemical Resistant Gloves	Safety Eye Protection
Long Sleeve T-shirt or Sleeve Covers	Respiratory Protection
Pants	

STEP 1: PRE-SURFACE PREPARATION

Identify and mark all areas that need to be repaired.
All surfaces must be completely dry before surface preparation.
Note: Do not open OneGuard™ repair kits

STEP 2: SURFACE PREPARATION

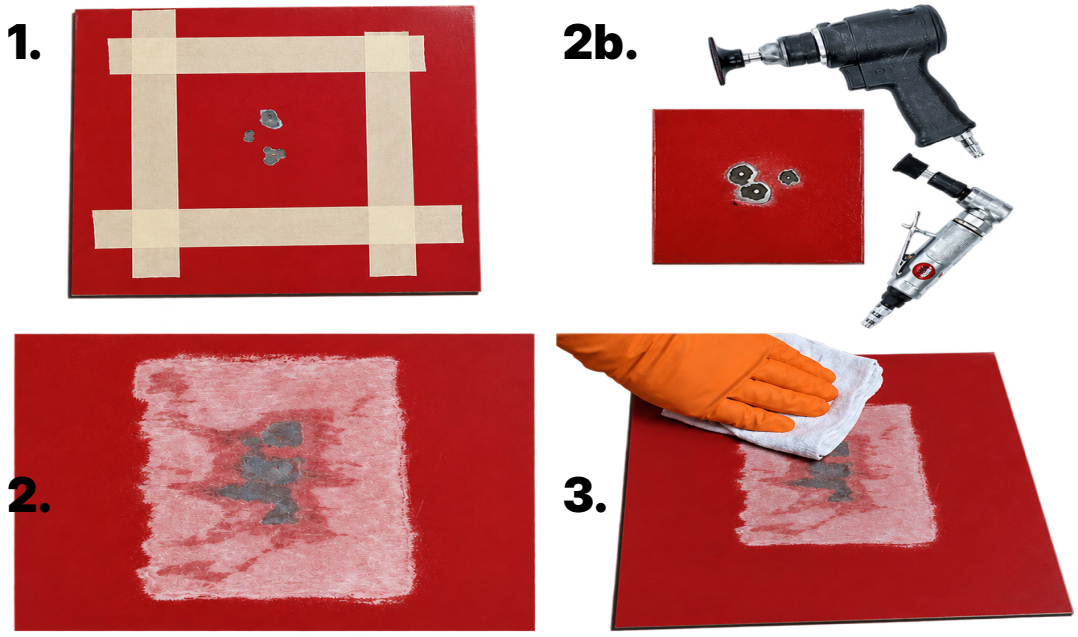
1. Identify all areas to be repaired and tape off 25 mm around its periphery.
2. Remove previous epoxy coating and feather in the edges.

    a.) If the damaged areas are small and independent (separate) from each other, the small damaged areas may be hand sanded with a medium grit aluminum oxide sandpaper. Sand the epoxy coating and remove any rust spots.

    b.) For areas that are larger, use one of the following methods:

        1. A vacuum blaster, which gives the best adhesion profile
        2. A disk grinder with medium grit aluminum oxide disk, or needle head.

3. The area should then be vacuumed thoroughly to remove all dust particles and washed with solvent (Acetone is preferred, Toluene and MEK are suitable). Note: Always use a clean white cloth. Do not use shop rags.



STEP 3: OneGuard REPAIR APPLICATION

1. Tape off the edges only revealing the bare steel surface.
2. Make sure all areas to be coated have been prepared before opening and mixing the OneGuard™ Repair Kit.
3. Mixing: Pour the entire contents of OneGuard™ Part B (catalyst) into the Part A (Resin) container and mix thoroughly for 2-3 minutes.**The pot life for OneGuard™ once mixed is 60 minutes at 25 degrees Celsius.**
4. Use a small brush to apply the mixed OneGuard™ repair coating to the properly prepared bare steel surface at a dry film thickness of 400-500 microns.
5. After applying the coating, remove the tape immediately to reduce thick coating edges.
6. Allow the coating to fully cure with good ventilation for 24 hours.







STEP 4: CURING REQUIREMENTS

All repair areas should be allowed to dry ambiently for atleast 24 hours to achieve a full cure.

TECHNICAL SPECS

Color	Red		
Mix Ratio	Gallon Kit:	Part A: 0.55	Part B: 0.45
Solids Content	93% +/- 2%		

APPLICATION CONDITIONS

Material	15ºC - 35ºC
Surface	10ºC - 30ºC
Humidity	< 65%

SHELF LIFE

When stored at a temperature of 4ºC - 43°C, the shelf life is 12 months.
Store material in a climate-controlled area between 15ºC - 35°C 48 hours before using material.

POT LIFE

When applied at a temperature of 25°C, the pot life is 60 minutes.

- An induction time is not required
- If the temperature is cooler, the pot life will be longer
- If the temperature is warmer, the pot life will be shorter

SURFACE PREPARATION

- A profile needs to be created that allows bonding of the coating to the surface.
- The best method to achieve a proper profile is vacuum blasting
- This can also be achieved by sanding, either by hand or machine (scored, not smooth)
- The surface must be free of rust and clean of debris/contaminant

- **Note:** Do not use “Puddy” (ex. Belzona), to fill in pitted or cracked areas in the steel.

Please contact Advanced Polymers Coatings Customer Care Department if you have any questions regarding your OneGuard™ coating.

Please use our Customer Care Portal for all inquiries regarding your OneGuard™ coating.