



EONCOAT APPLICATION CHEAT SHEETS

READ YOUR ITP, WORKS INSTRUCTION. UNDERSTAND THE JOB AND WHAT IS REQUIRED.

SURFACE PREPARATION

1. No contaminants on steel substrate, No Exceptions
 - Free from Oil, Grease
 - Free from old coatings
 - Free of any Mill scale
2. Remove weld spatter, grind slithers and make sure all edges have a 2mm radius.
3. No Recycled abrasive, fresh only.
4. No maximum profile size.
5. Light to Moderate Flash rusting after blast is acceptable. Go ahead, blast for a week!
6. Water wash at min 3000Psi at 10lts per minute - preferably 5000Psi @ 21 lts per minute to remove any loose contamination if blast is left open.
7. Look for uniform flash rusting. Any spots that don't flash may be contaminated. Degrease if necessary.



***IMPORTANT, IF IN ANY DOUBT, DO NOT APPLY EONCOAT AND
CONTACT AN EONCOAT REPRESENTATIVE.***

MATERIAL HANDLING

1. Keep EonCoat supply buckets out of the sun.
2. Keep EonCoat in a cool dry environment under 30°C.
3. Under no circumstances, add any water to the components.
4. Record your batches.

Mixing

1. Use mixing paddle to loosen part A.
2. Do not push mixing paddle too hard against the bucket wall. You will shave plastic into the mix. Keep paddle vertical.
3. Use separate round bar stirrers to mix both A and B buckets. No lumps at all, mix needs to be smooth and creamy. If in doubt, mix longer.
4. Prepare more Part A buckets in advance. These take longer to mix.
5. Cover buckets with their lids after mixing to prevent contamination and evaporation.



6. Never ever cross contaminate anything between part A and B, that goes for stirrers, brushes, rags, buckets, cleaning water etc. Never the two shall meet!

SPRAY EQUIPMENT

1. Always ensure all your equipment is clean and serviced
2. Ensure you have the following ready prior to mixing,
 - Correct Spray Tips plus spares
 - Spare Tip Holders
 - Spare static mixer housing
 - Spare static mixers
 - Backup spray gun
 - Spare Whip hoses
 - Wet Film Gauge
 - Tools for servicing and or gun changeover
3. Circulate water through the system.
4. Pressure test the system with water to spray pressure.
5. Check for any leaks on all the valves at the MicroMix manifold.
6. Ensure the water flush pump is working, left under pressure and has plenty of water.



***ANY ISSUES WITH THE EQUIPMENT, DO NOT LOAD PRODUCT.
RECTIFY THE ISSUE.***

LOADING EONCOAT INTO PLURAL

1. Remove all test water from the pump and hoppers.
2. Drain hoppers from the hopper drain valves. Ensure valves are closed after draining.
3. Load only full kits of part A and part B. Never “top up” the hoppers.
We need to see that they are dropping at the same level.
4. Put recirculation tubes into waste bucket, and cycle pump slowly in recirc until good material comes through recirc lines.
5. Stop pump and put recirc lines back into the hoppers.
6. Take pump out of recirc and into spray mode.
7. Open MicroMix and trigger the spray gun.
8. Slowly start the pump to push all water out of the spray lines until good EonCoat emerges.



9. Close MicroMix, and open flush valve to clean out whip hose, gun and static mixer.
10. Close flush valve and trigger gun to relieve any residual pressure.

SPRAY APPLICATION

1. Check required DFT.
2. Have Wet Film gauge ready.
3. Pressurise spray unit.
4. Test spray onto Cardboard or suitable area.
5. Make sure fan pattern is good.
6. Make sure material volume is suitable for the substrate you are spraying as well as the required WFT.
7. The target is to ***apply full WFT in as few passes as possible*** without allowing material to cure. Wet on wet passes only.
8. Do Not Trigger on and off. Keep gun triggered during passes back and forth.
9. No Flicking at the end of a pass.
10. Keep gun at right angles to the substrate.



11. Avoid overspray or dry spray onto any part of the substrate you are yet to coat.
12. Plan your job, start at the bottom and work your way up.
13. If overspray or dry fall is unavoidable, cover the prepared substrate that this will affect.
14. If you do get overspray or dry fall on a yet to be coated substrate, ***do not spray over this***, pressure wash at 3000Psi to remove the overspray or dry fall. The coating will fail otherwise.
15. If conditions are very dry and hot, mist the EonCoat you have just applied using the spray gun on flush to keep the product hydrated until the ceramic forms. A few minutes is fine.

THERE ARE NO SHORT CUTS TO EONCOAT. IF YOU ARE CONCERNED ABOUT ANYTHING REGARDING THE APPLICATION, STOP AND ASK.

FOR MORE DETAILS, CONSULT THE SURFACE PREPARATION AND APPLICATION GUIDE.