



Powercrete® R-65/F1-C Girth Welds / Rehabilitation

Liquid Epoxy Coating with Quick Applications and Long Term Corrosion Protection of Bare Steel

Powercrete R-65/F1-C FBE spray cartridge is a 100% solids liquid epoxy coating with quick cure time for efficient, user-friendly application. Product can be applied on bare steel and fusion bond epoxy. This Manual Application guide gives detailed explanation regarding the use of the cartridge for spray. The use of the spray cartridge is recommended, for rehabilitation, for girth weld area & patching. For large repair areas, please consult a Corrosion Protection Group representative.

1. Cartridge



1. The two component Epoxy coating "Powercrete R-65/F1-C" is supplied in 400 ML as well in 1000 ML cartridge for spray. Each cartridge is filled with premeasured Part-A and Part-B in their respective compartments of this dual cartridge. At the time of use, the temperature of cartridge must be minimum 125°F (51°C) and maximum 140°F (60°C). Cartridge is supplied in sealed condition with a seal-cap on the nozzle and along with static mixer.

2. Pneumatic Spray Dispenser



2. Always use suitable pneumatic spray dispenser which operates with compressed air. Connect compressed air connection. Compressed air pressure needs to be set at 100 psi.

3. Placing Dual Cartridge



3. Place 400 ML or 1000 ML Dual Cartridge (as the use may be) as per the position matching to their cylinder sizes. (Before placing the cartridge, ensure that piston moves forward & reverse freely and smoothly when triggered.)

4. Placing the static mixer



4. Open the threaded cap of cartridge.



4.1. Remove individual seal for Part-A & Part-B.



4.2. Place the static mixer in its position.

5. Installing Air Connection



5. Press fit the air connection to cartridge nozzle. Air pressure on the regulator of the gun needs to be set at 100 psi. Turn 'ON' the air for spray-tip.



6. Press the trigger of Dispenser and purge some material on waste plastic sheet or cardboard. And then immediately start spraying on the Girth-Weld OR on patch area. Once spray is started do not stop but, complete the spray of the entire cartridge materials in one go.

7. Applied Coating



7. Allow the sprayed coating to cure. Dispose-off empty cartridge and static mixer, properly.

Pneumatic Dual Component Applicator Operating Instructions

Safety:

This applicator is designed for heavy duty cycles over extended operating periods. As compressed air is used as the power source, operator fatigue is minimal, but it must be remembered that compressed air can be dangerous when used incorrectly. The user should take time to read and understand these operating instructions fully prior to using the applicator. Any modifications to the applicator made by the user will void the warranty and could cause personal injury.

Always:

- Use protective eye and ear equipment when operating.
- Wear a face mask or respirator when operating.
- Test the forward/reverse function before loading a cartridge.
- Disconnect the air supply before starting any maintenance/cleaning tasks.
- Make sure cartridge is loaded properly.
- Use a new static mixer.
- Read the material manufacturer's instructions carefully.
- Make sure you have not cross-contaminated the contents of the two cartridges as it may have cured in one of the sides.

Do Not:

- Connect the applicator to an air supply that can exceed 115 psi.
- Immerse the gun in solvent.
- Operate the gun with loose, broken, or missing parts.
- Carry the gun by the air pipe.
- Use damaged cartridges or the wrong type of cartridge in the applicator.
- Point the applicator at another person.
- Disassemble the handle and adjust the safety valve inside.
- Use a static mixer that has material inside it that has cured.
- Use partially extruded cartridges unless you use a new static mixer and know there is no cross-contamination.
- Use expired material or material that has cured.

Connecting

Check the supply pressure. For optimum performance the supply pressure must be greater than 100 psi and less than 115 psi. The applicator will work at lower supply pressures, but flow rates could be reduced and may vary. Connect the applicator to a suitable compressed air source using the fitting supplied, or with suitable fitting. All applicators are fitted with a male ¼" NPT thread.

Operating

- A. Internal pressure regulator
The internal pressure regulator controls the material flow rate and ensures a stable flow of material is maintained. To increase the flow of material, turn the knob in the (+) direction. To decrease flow, turn the knob in the (-) direction.
- B. Trigger
By pulling the trigger (with index and middle fingers), a cushion of compressed air is built up inside the applicator, which starts the flow of material. On releasing the trigger, the material flow ceases as the compressed air escapes rapidly by a quick exhaust valve at the rear of the gun.

- C. **Forward Air/Reverse Air Buttons**
Push the “Forward Air” button for extrusion of material. Push the “Reverse Air” button to pull the plunger rods back automatically and to “ready” the applicator for the next cartridge.
- D. **Push Disks**
Refer to the enclosed Push Disk Alignment Chart for instructions on how to change to other mix ratios. Using incorrect push disks will damage the applicator, void the warranty and the cartridge will have blow back. Make sure the push disks are snapped in completely before use.
- E. **Safety Valve**
If you hear air leaking from the handle, then your compressor source is exceeding 115 psi and the safety valve is bleeding off the excess air. You should adjust the source so that it is lower than 115 psi. NEVER disassemble the handle and adjust the safety valve.

NOTE: If the cartridge is improperly made, there is a risk of the cartridge bursting open. For other risks associated with the particular cartridge you are using, BE CAREFUL TO READ ALL OF THE INSTRUCTIONS AND WARNINGS OF THE MATERIAL YOU WILL USE IN THE APPLICATOR. IF YOU HAVE ANY QUESTIONS ON ANY OF THEM, CONTACT THE MATERIAL MANUFACTURER FOR CLARIFICATION.

- F. **Cartridge Loading**
It is important that the cartridge is seated properly in the applicator frame. If the front of the cartridge is not seated properly, breakage of the cartridge can result. The front face of the cartridge can result. The front face of the cartridge must be flush to the front plate of the applicator. If the cartridge does not seat properly, DO NOT USE.



Maintenance:

- Daily: Wipe the applicator using the material manufacturer's recommended solvent before it has time to set up. Special care should be taken to make sure no residue is left on the rods.
- Weekly: Check the plungers and all external bolts and screws are tight. Tighten if found to be loose.
- Monthly: Lubrication of internal pistons and seals. Place 3 drops of oil on the air inlet at the air regulator. Reconnect the air line and when next operated, the compressed air will blow the oil into the inner workings of the gun.

Storage

For optimum performance, store Powercrete® Epoxy products in a dry, well-ventilated area. Maintain products in original packaging and sealed until just before use. Avoid exposure to direct sunlight, rain, snow, dust or other adverse environmental conditions or contaminants.

NOTE: Avoid prolonged storage at temperatures above 40°C (104°F) or below 5°C (49°F). Do not use static mixer if it is blocked. Also, do not try to clean mixing element by using solvent. If mixer element is blocked, replace with another static mixer element.

Contact your Berry Plastics representative for additional requirement of cartridge guns.

Safety Guidelines

Important: Read the MSDS prior to using the products. Product installation should be done in well-ventilated area and in accordance with local health and safety regulations. These applications guidelines are intended as a guide for standard products.

PPE such as Hand-gloves, Protective goggles, Protective clothing and Respirator should be put-on by a person while operating spray cartridge. Consult your Berry Plastics representative for specific projects or unique applications.

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