

ONE-STEP RUST TOP COAT RECOMMENDATIONS



Surface Preparation Options

(in sequence: from the lowest level of surface corrosion to the most difficult surface condition)

Surface Condition	Wire Brush	Water Rinse	Light Sandblast	Power Wash	Apply One Step Primer	Dry 24 Hours	Apply suitable topcoat for environment
Light rust, no paint Heavy rust, no paint Large area option	X	X		X	X X X	X X X	X X X
Light rust, loose paint Large area option #1 Large area option #2	X	Χ	X	X X X	X X X	X X X	X X X
Heavy Rust with Loose paint or rust under paint blisters Large area option #1 Large area option #2	X	х	Х	X	X X X	X X X	X X X

Topcoat Recommendations for application over One Step

(Determine your environment - recommend topcoats are listed in order of relative expected performance - ie: #1 = Best, #2 = Second Best, #3 = Third Best, etc.)

Environmental Condition	Catalized Epoxy	Chlorinated Rubber	Catalyzed Urethane	Coal Tar Epoxy	Vinyl	Alkyd Enamel	Acrylic Enamel
Moisture, salt spray	#5	#1	#3	#2	#4	#7	#6
Alkaline environment	#3	#4	#1	#2	#5	#7	#6
Acid Environment	#1	#4	#5	#3	#2	#7	#6
Oxidizing agents		#3	#2		#1		
Abrasives	#1		#2				
Solvent Environment	#2		#1	#3			
Water immersion	#2	#1	#4	#3			
General atmosphere						#2	#1



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General Description:

One Step is a synthetic latex emulsion that chemically neutralizes rust in to a nuetral organic layer and dries to a tough, long lasting black protective coating. Dried One Step is an excellent primer for all types of industrial and automotive topcoats.

One Step Properties - Specifications

Solids	35%± 1% by Weight
Coverage	
One Medium Coat	450-500 sq. ft./ gal.
Two Thin Coats	250-300 sq. ft./ gal.
Weight/Gallon	8.5± .1 lbs.
Flash Point	Above 250 F - (110 C)
Viscosity	48 Ku ± 3 (krebs units)
Shelf Life	Minimum 1 year
Composition	Synthetic latex, organic acids, glycol ether and water.
Dry Times	Dry to touch: 30 min.; Recoat: 30min 4 hrs.; Topcoat: 24 - 72 hrs.
Storage	Protect from freezing; Store at 50 F - 110 F

Cost Comparison of Methods

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Power Washing	\$0.15-\$0.20 Per Sa	uare Foot			
Light Sandblasting \$0.45-\$0.65 Per Square Foot					
		1.60-\$2.75 Per Square Foot			
Surface to be Treated					
Condition of Surface					
	. Metal, 40% Tightly Sdhered paint				
Work Step-Costs	One Step with Power Wash Preparation	One Step with Light Sandblast Preparation	Standard Primer with White Metal Sandblast Preparation		
1. Cost of Power wash at \$0.15 Sq. Ft.	\$750.00				
Rust conversion primer at \$40.00/Gal. 25 Gal. one coat labor 1 man @ 20.00/Hr. Priming 12 hours	\$1,000.00				
	\$240.00				
2. Cost of Sandblasting \$0.45/Sq. Ft. Rust conversion primer at \$40.00/GL. 25 Gal.	, , , , ,	\$2,250.00			
one coat labor 1 man at \$20.00/Hr. for 12 hours		\$1,000.00			
		\$240.00			
3. Cost of white metal sandblasting at \$1.60/Sq. Ft. Standard metal primer at			\$8,000.00		
\$18.00/GL. 18 Gal. labor 1 man at \$20.00/Hr 12 hours priming.			\$324.00		
			\$240.00		
TOTAL COST*	\$1,990.00	\$3,490.00	\$8,564.00		

U.S.D.A. Approval - One Step is approved for non-food contact applications under USDA guidelines. Approval of your local USDA inspector must be obtained before application of One Step. Contact factory for additional information.