R-Mer® Coat
Field-Applied Kynar® Resin-Based Metal Coating System
Spray Application Guidelines

since 1895

DESCRIPTION

R-Mer Coat is an industrial maintenance coating system designed to enhance and protect a variety of metal walls and roofs. This guide covers proper application equipment and techniques for spray applicators.

Personnel using these products should familiarize themselves with procedures for personal safety, workplace precautions, and equipment operation. Please refer to product data sheets and Safety Data Sheets.

EQUIPMENT

The R-Mer Coat system, including primers and topcoat, must be applied by spray equipment. Airless spray pump must have minimum 2,000 psi output pressure rating and adequate delivery volume to support the spray tip orifice gallons per minute rating.

Recommended Sprayer: Graco GMAXII 7900
Airless spray equipment generates very high fluid pressure. Spray equipment must be properly maintained and operated. Air-atomized application is not allowed because it will affect the application appearance of the coating. Read and follow the equipment manufacturer's instructions and recommendations.

Spray Pump Recommendations
1. Max GPM Rating: 2.2
2. Max PSI: 3300 psi
3. Hose: 3/8" ID Hose first 50' (30.48 m) with swivel connections, or 1/2" ID Hose for 200' (30.48 m)
4. Pump pressure: 2,000 psi
5. High pressure fittings
6. Spray tip: .015 - .019 for an 8" pattern at 12" distance (20.32 cm pattern, 30.48 cm distance)
7. Recommended 12" (30.48 cm) extension with swivel tip
8. Tip and pump sizes will change depending on temperature and pattern concerns

Protection Equipment Recommendations:
1. Fabric coveralls are recommended
2. Impervious gloves are recommended

SURFACE PREPARATION

The service life of the coating is directly related to the surface preparation. The surface to be coated must be properly prepared, dry, clean and free of all contamination. Solvent clean to remove all contaminants. Abrade substrate with hand/power tools or sand-blasting where required to remove loose mill scale, loose rust, loose paint, old repair materials and other contaminants. Ensure substrate is clean and free of dust/debris before primer coating application. In addition to proper preparation, perform an adhesion test using ASTM D3359 (the standard test method for measuring adhesion by tape test) to ensure satisfactory adhesion of R-Mer Coat Primer.

NOTE: Inspect and make all necessary repairs to damaged substrates, including, but not limited to, rust fasteners, excessive gaps and seams.

APPLICATION

Weather Conditions
1. Rain, fog, dew, frost, relative humidity above 90%, will adversely affect water-based coatings, affecting adhesion and physical properties of the coating. Do not apply if any of these conditions exist or will exist within five hours of application. The substrate must be dry at the time of application.

2. At temperatures below 50°F (10°C), store and maintain material temperature above 65°F (18°C) in the container. Application is not allowed below 50°F (10°C).

3. At temperatures above 90°F (32°C), reduce the application rate on vertical or irregular surfaces and apply in additional coating layers to prevent sags or runs. Do not apply at temperatures above 95°F (35°C).

Spraying Technique
For roof slopes greater than 3:12, R-Mer Coat may need to be applied in multiple coating layers to meet required coverage rates. Consult your Garland Technical Department for specific prep recommendations and which R-Mer Coat primer is required.

1. Hold the spray gun perpendicular to the surface at a distance of 18-24" (46-62 cm) from the roof. While triggering the spray gun, move it at a rate to produce the desired coating wet mil thickness without thin spots or "holidays." Spray technique should include a "half lap" technique where each spray pass is overlapped 50% for uniform coverage. Check applied film thickness using a wet mil gauge.

- R-Mer Coat topcoat: 350-400 sq.ft./gal. (8.6-9.8 m^2/l) per coat (two coats required)
- R-Mer Coat Primer: 400-450 sq.ft./gal. (9.8-11.05 m^2/l)
- R-Mer Coat PVDF Primer: 400-450 sq.ft./gal. (9.8-11.05 m^2/l)

2. Using the 2,000 psi fluid pressure will provide a uniform spray pattern without fingering.

3. Allow the appropriate cure time between coats for cure and water evaporation.

Spraying Precautions
a. Rope off the area within 150 feet (46 meters) of spray area.
b. Seal off ventilation intakes within the affected area.
c. Use windbreaks, where necessary, to confine spray mist and avoid damage to nearby surfaces due to overspray or drift.
d. Keep spectators and personnel away from spray area.

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CLEAN UP

1. Clean airless spray equipment with warm soapy water. Re-circulate thinner through pump supply, airless spray pump and spray hose to remove residual coating. Then flush with clean water.
2. Do not leave in airless spray system for more than 4 hours.
3. For long-term storage, a final flush with mineral spirits is recommended.

STORAGE & HANDLING

Storage

1. Keep containers closed.
2. Store in a dry cool place away from heat, sparks and open flames.
3. For cold weather application, keep material stored above 65°F (18°C).
4. Open containers should be resealed with the proper lid and a tight seal should be confirmed before storage.

Mixing

1. Settling or separation may occur.
2. Mix material to uniform consistency before using.
3. Ground container and equipment to prevent accumulation of static charge.

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