



## POR-15 RUST PREVENTIVE PAINT

### Application Information

**Please Note:** This product is unlike any other paint or coating you may have used in the past. Please take the time to carefully read the instructions from beginning to end before using POR-15. In addition, we have provided you with a question and answer sheet and also a tips and supplementary information sheet. Reading this material will better acquaint you with POR-15 and enable you to achieve a superior result.

#### PRODUCT DESCRIPTION

POR-15 is a rust-preventive paint designed for application directly on rusted or seasoned metal surfaces. It dries to a rock-hard, non-porous finish that won't chip, crack, or peel, and it prevents rust from re-occurring by protecting metal from further exposure to moisture. POR-15 is sensitive to UV light (sun) and must be topcoated before prolonged exposure to sunlight. POR-15 is cured and strengthened by exposure to moisture and will dry faster under extreme humidity, but moderate to dry atmospheric conditions are most desirable when applying this product. That's because extreme humidity may cause an immediate surface cure, trapping carbon dioxide gas below the surface. When this happens, bubbling may occur. Extreme humidity at the time of application may also interfere with proper adhesion of the POR-15 coating to bare metal because it is almost impossible to keep the metal dry under such conditions.

#### APPLICATION PROCEDURES

Surface preparation: Rusty surfaces are best; seasoned metal and sandblasted surfaces are also good. Surface must be dry and free of grease, oil, or other foreign substances.

**TO COAT SMOOTH METAL SURFACES:** First use Marine Clean to clean and degrease the surface, when clean rinse with water and allow area to dry. Second spray Metal Ready on surface full strength, keep wet for 15-20 minutes then rinse with water and allow to completely dry. Use of "rust converter" products is not recommended as they may affect bonding of POR-15 to metal. POR-15 likes to adhere to surfaces with "tooth" rather than smooth, glossy surfaces.

**STIR CONTENTS THOROUGHLY** before painting. Do not shake. Refrigerate unused portion of POR-15 for longer shelf life.

**APPLICATION** Apply in thin coats, 1 to 2 mil (25-50 um) thickness. Always apply a minimum of two (2) coats. For marine and industrial applications, a minimum of (3) coats is recommended. "Tacky" is defined in our writings as dry to the touch but with a slight finger-drag remaining.

**SPRAY APPLICATION** Use 30-35 lbs (206-250 kpa) pressure for normal gloss. Reduce pressure for lower gloss 20-25 lbs (140-170 kpa). Thin only with POR-15 Solvent, if necessary. If topcoat to be done at later date, apply very light dust coat of primer over tacky POR-15 and let dry. Full priming and finishing can then be done later. Use POR-15 Solvent or lacquer thinner for cleanup, which must be done before POR-15 dries; once dry, POR-15 cannot be removed by solvent. Avoid skin contact. Remove from skin at once to avoid temporary staining.

**USE OF GLOVES AND VENTILATING EQUIPMENT IS STRONGLY RECOMMENDED.**

**NOTE:** Organic vapor particulate respirators, NIOSH/MSHA approved, must be used when spraying POR-15. Moisture will shorten the life of unused POR-15. Seal can immediately after using.

**NOTE** Leftover paint should not be put back in can as this will shorten shelf life and might cause pressure to build up in can, causing the lid to pop off. Refrigerate unused POR-15 for longer shelf life.

#### POR-15 Questions and Answers

**LOTS OF PRODUCTS CLAIM TO STOP RUST; SOME ARE PAINTS, SOME ARE CONVERSION PRODUCTS, SOME ARE RUST TREATMENTS. NONE OF THEM SEEM TO REALLY STOP RUST PERMANENTLY. WHY IS POR-15 DIFFERENT, AND WHY SHOULD I BELIEVE IT WILL WORK ANY BETTER?**

Rust is caused by moisture coming in contact with metal, which causes a chemical action called oxidation. All paints provide a measure of protection for a while, but since they are eventually softened and weakened by moisture, it is only a matter of time before moisture penetrates the painted surface and attacks the metal below. All of the so-called rust preventive paints on the market (except POR-15) are weakened by exposure to moisture. POR-15 is strengthened by exposure to moisture. Notice the hardness of the POR-15 coating. It doesn't chip, crack, or peel like ordinary paints do, and its hardness will resist the wear and tear of every day life.

Rust conversion products claim to change the chemical nature of rust and convert it to a more stable element that won't rust again. History of the failure of these products is well documented; most simply don't work for more than a few months at best, and they are subject to the same chipping and cracking that occurs with ordinary rust coatings.

POR-15 works because it chemically bonds to rusted metal and forms a rock-hard, non-porous coating that won't crack, chip, or peel. It keeps moisture away from metal with a coating that is strengthened by continued exposure to moisture.

#### IS IT BETTER TO BRUSH OR SPRAY POR-15?

Most people brush it on due to its leveling characteristics however it may also be sprayed. Proper equipment and organic vapor particulate respirators for solvents are essential for spraying.

#### HOW DO I THIN POR-15 IF I WANT TO SPRAY IT?

You should use POR-15 Solvent for thinning. Some lacquer thinners will work, but many will not. Keep lacquer thinner handy for clean-up. Do not thin POR-15 more than 5%.

#### CAN I PAINT OVER POR-15 WITH OTHER PAINTS?

Absolutely, POR-15 will accept all paints including lacquer-based paints. Either POR-15 Self-Etching Primer or Tie-coat Primer are the best primers to use before topcoating POR-15. Be sure to read our directions and tip sheets thoroughly regarding topcoating before using POR-15.

#### CAN I USE BODY FILLER OR PUTTY WITH POR-15?

Yes. First paint both sides of the rusted area with POR-15; then use body filler or putty as soon as the POR-15 is dry to the touch. For best results and adhesion use our StraightLine or RestoGrip body fillers over POR-15.

#### HOW LONG DOES IT TAKE POR-15 TO DRY?

That depends on the ambient humidity (surrounding area). The more humid the area, the faster the drying time, which usually varies from 2 to 5 hours.

#### IS IT DANGEROUS TO GET POR-15 ON MY HANDS?

No, but if you do, remove it at once with solvent or lacquer thinner. If POR-15 dries on your skin, nothing will take it off, and you will "wear" it for 3 or 4 days until natural oils and flaking skin remove it.

# POR-15 RUST PREVENTIVE PAINT Continued

## ARE THE POR-15 VAPORS DANGEROUS TO MY HEALTH?

Yes. That's why you must always paint in a well-ventilated area and keep your nose away from the paint container. POR-15 is not dangerous if you follow our simple directions.

## WHAT IS THE BEST SURFACE ON WHICH TO PAINT POR-15?

POR-15 likes rusted surfaces best. Seasoned metal and sandblasted metal are also good. POR-15 does not adhere well to smooth, shiny surfaces, but will adhere well with the use of Marine Clean and Metal Ready preps.

## WHAT IS THE "PROPER PREPARATION"?

If you are sandblasting, blow off the loose dust and apply directly over the surface. On all other bare metal or rusted surfaces use the Marine Clean and Metal Ready preps for proper adhesion. Metal Ready It is a rust remover that leaves a zinc phosphate coating on base metal, the perfect pre-primer for POR-15. Areas that have been previously painted should be cleaned with Marine Clean and then lightly scuffed with 400 grit sandpaper. Keep in mind when POR-15 is applied over another coating it will not prevent against rust long term but will serve as a durable, moisture resistant coating. NOTE: New steel is coated with a protective oil finish at the mill. This finish must be removed before using POR-15.

## WHICH POR-15 FORMULA (GLOSS BLACK, SEMI GLOSS BLACK, SILVER, GRAY or CLEAR) SHOULD I USE?

Silver contains metal filler and should be used in badly rusted, pitted areas. It will fill in holes better than black or clear. Black is generally used on frames, underside of fenders, etc. because that's the usual color there. Clear renders the smoothest finish and is often used as a preprimer on exterior surfaces. Gray is great on concrete floors, bilges and storage areas.

## MUST I PAINT OVER POR-15 TO MAKE IT LAST?

No, but POR-15 has an ultra-violet sensitivity and must be topcoated if continually exposed to sunlight. Once topcoated, POR-15 will remain effective for many years.

## WILL THE SUN DESTROY MY POR-15 COATING IF I DON'T TOPCOAT IT?

No, your POR-15 protection will remain, but the sun will change its appearance cosmetically. That's why we recommend you topcoat it.

## CAN I APPLY POR-15 OVER OTHER PAINTS?

Yes, but you will lose the important benefits of POR-15. You must remember that ordinary paints are weakened by exposure to moisture. POR-15 can't stop rust if it isn't in direct contact with the base metal.

## CAN POR-15 BE USED WITH FIBERGLASS?

Absolutely. POR-15 is fully compatible with fiberglass and can be used to repair cracks in gelcoat. It will adhere better than polyester resin and has greater strength. Use also with fiberglass cloth to make super-strong surfaces in rusted-out areas.

## WHAT TEMPERATURE AND HUMIDITY CAN I APPLY POR-15 IN ?

POR-15 should be applied in temperatures of 50-90°F degrees (10-38°C) and humidity under 80%

## SUPPLEMENTARY INFORMATION & TIPS

### SEASONED OR RUSTED METAL:

First, wire brush loose rust and scale. Then remove any grease or oil with **POR-15 MARINE=CLEAN** and prep with **POR-15 METAL-READY**. **DO NOT USE SOLVENT-BASED CLEANERS**. Apply POR-15 in thin coats.

For Two Coat Application: Apply second coat when first coat is tacky but almost dry. If first coat is fully cured, wet sand first coat with 600 grit sandpaper until gloss is dulled. Next, apply the second coat of POR-15. **TOP-COAT APPLICATION OVER POR-15 PRIOR TO FINISH PAINT IF USING PRIMER:**

After second coat of POR-15 has been applied, wait approximately 45 minutes to 1 hour until the POR-15 coating is tacky; then apply a light dust coat of primer and let dry. Next, apply a full coat of primer and follow normal top-coating procedures. If primer is lacquer-based, apply dust coat only after POR-15 is dry to touch.

## SPRAY APPLICATION PRESSURES:

Use 30-35 lbs (206-250 kpa) for normal gloss application. Reduce gun pressure to achieve lower gloss 20-25 lbs (140-170 kpa).

## POR-15 TIP SHEET

POR-15 has many uses other than sealing rust. In antique car restoration, problems arise that the everyday shop man does not often encounter. Here are some helpful tips we have picked up over the years.

**CHROME MOULDING CLIPS** can scratch a new paint job when they are pushed through the body. POR-15, even if scratched off, will only rust where it is removed, so rust will not travel upward to ruin that new paint job. Put a coat around the holes, under the chrome, before you prime and paint.

**ROOF DRIP RAILS** are another place where rust begins early. Put on a coat of POR-15 and let dry. Then apply a second coat, wait for it to get tacky, then dust lightly with primer. When dry, spray on a good coat of primer.

**FIBERGLASS BODY REPAIRS:** POR-15 Clear is as hard and flexible as two-part epoxy resins, but requires no mixing and is impervious to topcoat thinners—epoxy is not. POR-15 Clear can be used in place of fiberglass resin.

**STAINLESS STEEL TRIM PIECES** that push down around the windshield...if they won't stay down, put some POR-15 in the channel and brace it with wood strips overnight. Regarding windshields, with the rubber removed, put a coat of POR-15 around the body where the rubber rests; this is a high humidity area and should be sealed with POR-15.

**POR-15 INSIDE REAR EXHAUSTS** will stop rust where it starts. Soak a round glass-cleaning sponge with POR-15 and pull it through the pipes with a wire. Coat exterior from the muffler back.

**LOWER COWL SECTIONS, ROCKER PANELS, LOWER PORTION OF FENDERS AND REAR QUARTERS, INSIDE DOORS** are other good places to coat with POR-15.

**RUSTED OUT PINHOLES:** Put a piece of tape behind the larger pinholes, then paint. When the paint dries, pull the tape off and paint the back side as well. POR-15 can be used to seal gas tanks, also, and POR-15 PUTTY will take care of larger holes.

**POR-15 SHOULD BE STIRRED**, not shaken, each time you use it.

**OLD CARDBOARD INTERIOR PIECES AND MOLDED VINYL VISORS** can be coated with POR-15 and then painted over with vinyl dye.

**IF YOU HAVE A SPECIAL USE FOR POR-15**, please call us toll-free at 1-800-45-POR15 and let us know. We will give you credit in a future issue of our newsletter.

## WE HOPE THIS INFORMATION IS OF BENEFIT TO YOU IN THE USE OF POR-15 RUST PREVENTIVE PAINT.

*Please remember these instructions are general guide lines only and cannot and do not cover every application and environment. If you remain unsure as how to proceed, please call toll-free for technical advice at 800-457-6715.*

**KEEP OUT OF THE REACH OF CHILDREN, PETS, ETC. HARMFUL OR FATAL IF SWALLOWED. DO NOT USE ON CHILDRENS TOYS WHICH MAY BE PUT INTO MOUTH. USE IN WELL VENTILATED AREAS ONLY.** Hazardous ingredients: Diphenylmethane Diisocyanate Cas#26447-40-5, Naptha Petroleum Cas #64742-95-6, Carbon Black Cas #12438-9, Aluminium Cas #7429-90-5. Contents partially unknown.

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