

Surface Preparation

Proper surface preparation is critical to the long-term performance of this product. The exact requirements vary with the severity of the application, expected service life, and initial substrate conditions.

Optimum preparation will provide a surface thoroughly cleaned of all contaminants and roughened to an angular profile between 75-125 µm (3-5 mil). This is normally achieved by initial cleaning and degreasing and then abrasive blasting to a cleanliness of *White Metal (Sa 3/SP5)* or *Near-White Metal (Sa 2.5/SP10)* followed by removal of all abrasive residues. Rubber surfaces will require roughening with power tools and then surface wiping with a conditioning solvent such as MEK or acetone prior to application.

Mixing

To facilitate mixing and application, material temperatures should be between 21°-32°C (70°-90°F). Each kit is packaged to the proper mix ratio. If further proportioning is required the kit should be divided according to the correct mix ratio.

Mix Ratio	By Weight	By Volume
A: B	4.1 : 1	4.0 : 1

Add Part B to Part A and mix until free of streaks and a uniform color is achieved. Take care to scrape unmixed material from sides of container and mixing tool. Once mixed spread product out on a clean flat surface to extend working time. If mixing by power tool, place both components in the Part A container, and mix at a low speed until a homogeneous color is achieved. To assure complete mixing, finish blending by hand as described above. Do not over mix as pot-life of I BX1 RC is short.

Working Time – Minutes

	10°C	16°C	25°C	32°C	43°C	This chart defines the practical working time of ARC I BX1 RC starting from when mixing begins.
	50°F	60°F	77°F	90°F	110°F	
1.5 & 2.5 liters	50 min.	40 min.	25 min.	15 min.	10 min.	

Application

ARC I BX1 RC must be applied at a minimum thickness of 6 mm (240 mil). Minimum application temperature is 10°C (50°F). In certain applications requiring additional support, it may be advantageous to weld expanded metal mesh onto the metal substrate prior to application of the ARC I BX1 RC. Using the enclosed plastic application tool or trowel: press the material into the surface profile to completely wet out the surface for proper adhesion. Once the material is placed, it may be smoothed utilizing a variety of methods.

Prior to its light load cure state, ARC I BX1 RC may be overcoated with any of the ARC epoxy materials with the exception of ARC vinyl ester based coatings. If it has cured to the point of "Light Load" described below, the surface should be roughened and dust or other contaminants removed prior to top coating. Prior to curing to "Light Load" no surface preparation is required so long as the surface has not been contaminated. If required, ARC I BX1 RC can be ground using a rotary grinding tool or machined with polycrystalline diamond tools.

Coverage:

Thickness	Unit size	Coverage
6 mm (240 mil)	1.5 liters	0.25 m ² (2.69 ft ²)
6 mm (240 mil)	2.5 liters	0.42 m ² (4.49 ft ²)

Curing Schedule

	10°C	16°C	25°C	32°C	43°C
	50°F	60°F	77°F	90°F	110°F
Over Coat Window End	2 hrs.	90 min.	1 hr.	40 min.	25 min.
Ready for Service	8 hrs.	5.5 hrs.	4 hrs.	3 hrs.	2 hrs.

Clean Up

Use commercial solvents (Acetone, Xylene, Alcohol, or Methyl Ethyl Ketone) to clean tools immediately after use.

Once cured, the material would have to be abraded off.

Safety

Before using any products, review the appropriate Safety Data Sheet (SDS) or Safety Sheet for your area.

Follow standard confined space entry and work procedures, if appropriate.

Shelf life (in unopened containers): 2 years [when stored between 10°C (50°F) and 32°C (90°F) in dry, cool, covered facility]