



ONEDAY BRAKE ROLLER REPAIR KIT

CLASS 5 INSTRUCTIONS



TK/COM34VC1

EXTRA HEAVY DUTY

This kit has been specially developed to produce a hard & durable surface on Commercial Brake Testing Rollers that are subject to Extra Heavy Usage. The kit contains enough material for 1-4 commercial brake rollers & can be used for patching or fully replacing the existing coating. Stored material will keep at least a year between jobs, usually much longer. Oneday kits build up two thick coats to bond very coarse grit. This is then sealed using a solvent free sealer. Kits are also suitable for applying Slip-Resistant Coatings to metal, concrete, wood, stone, brick, and other surfaces where the very coarse nature of the coating is necessary.

KIT CONTENTS

Containers of Bonding Agent BL1
Thickener BR2

Bonding Agent Sealer BL5
Ceramic Grit VC1

Hardener H1
Mixing Cups

Set of Measuring Cups (White 100ml) Large 50ml and Small 25ml Brown
Gloves, Brush, Spatulas, Instructions and Health and Safety Sheet

HEALTH AND SAFETY

With simple precautions the chemicals used before mixing are straightforward to use. (See Health & Safety Sheet.) Once the Bonding Agent and Hardener have been mixed and gone hard, the high-friction surface is completely safe and remains so. For your own safety, please observe the following simple precautions during application. As with all chemicals, keep them off your skin by using the gloves supplied, and avoid getting them on clothing which touches the skin, such as cuffs. Ensure adequate ventilation. Keep them out of your eyes - don't splash. Avoid any chance of swallowing by not smoking, eating, or drinking whilst working, and wash your hands afterwards. If you do get any on your skin, clean it off immediately, using a solvent-free hand cleanser. For splashes in the eyes, wash with lots of water, and seek medical attention, if necessary. Keep chemicals away from food and children.

IMPORTANT POINTS

In cold weather, if possible, keep the rollers (or area being coated) at 15-21°C (60-70°F) throughout the work. Curing will work down to below 5°C, but more slowly. Surface moisture on cold, damp days can reduce adhesion. Screen to prevent draughts, & heat with infra red, space heaters etc. Tube heaters, lead lights etc in the pit will help overnight. Remember, it's the roller or floor temperature that matters, not the air temperature!

Store the kit in a warm room before use.

Avoid starting with cold or hot chemicals - 12 to 15°C is best for speed & pot life. Use a bowl of water to adjust. For periodic brush cleaning, use cellulose thinners, epoxy thinners, or trichloroethylene. **The Surface or Rollers MUST NOT BE USED until the coating is HARD.**

To check, make a test piece (metal or wood, say 2"x2") when the coating is complete. Put a 'dab' of coating on it (do not grit) and leave next to the gritted area. Test by first thumb pressure and then with a screwdriver before using. When hard, the coating still continues to gain strength over several days, so build up the work load. To save grit, make a simple catcher. Take a piece of cardboard the width of the pit and fold and tape the lower end to form a trough. Remove the side plates on Brake Rollers, & fit the catcher. If an area is being coated, obtain a long brush-type draught excluder as used on the bottom of internal doors. Half provides an excellent levelling brush.

After a very long period of storage, (several years), the Bonding Agent may stiffen. If so, place the tub in hot water (60°C), and stir until liquid again.

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DETAILED INSTRUCTIONS

Stage 1: SURFACE PREPARATION

It is extremely important that the surface is prepared properly before applying coating. A shot blasted surface is ideal, preferably using chilled slag. A needle descender or angle grinder is also effective. Remove dust

with a dry brush, hot air blower or vacuum. After any degreasing use an angle grinder to remove a final thin surface layer of metal & expose clean material. Any rust pitting must be cleaned using either a hand held shot

blaster or fine wire brush. Cleanliness & roughness are essential to maximise bonding.

Stage 2: MIXING THE BONDING AGENT

Wear gloves. Ensure ALL surfaces to be coated are FULLY prepared and CLEAN BEFORE mixing chemicals.

Stir Bonding Agent before use. Take one measure (brown) of Bonding Agent (50ml), and one measure of Hardener (25ml) and mix well in a paper cup, using one of the spatulas supplied. The correct mixture is important, so make sure the measures are filled and emptied completely. Use separate spatulas to remove the last of the Bonding Agent & Hardener measures. Mix in a measure (100ml white) of Thickener until smooth. This may need increasing slightly in hot weather or decreasing in cold. Adjust after the first mix. Once mixed, the material **must be used within 15-20 minutes.**

Stage 3: APPLYING THE 1ST COAT

Brush an even, smooth, coat onto the surface. If carrying out a repair, brush to the edge of, but not on top of the existing coating. The coating thickness should be thicker than that of domestic paint, and should be inspected carefully for thin or thick areas, which should be corrected. Brushing is more difficult than for paint. If runs occur when the roller is turned, more thickener is needed. If brushing is almost impossible use less. When a convenient area has been coated, lightly brush in both directions to further even the thickness. Dip the brush in cleaner periodically, (see previous page), and wipe after each mix is applied to prevent it hardening. Apply Ceramic Grit frequently, say after every two mixes, or complete roller. This ensures the strongest bonding. (For non-slip coatings only make a test piece (above) from final Bonding Agent mix.)

Stage 4: APPLICATION OF THE 1ST CERAMIC GRIT COATING

For Rollers, fit the grit catcher (above). Apply an excess of grit to the coated area, making sure the surface is fully coated after 'settling'. Apply 2nd coat as soon as first is stiff for maximum intercoat bonding.

Stage 5: MIXING & APPLYING THE 2ND BONDING AGENT COATING & GRIT

When the first coat has stiffened, mix & apply a further coat (repeat sections 2, 3 & 4). Application of the final grit coat requires care. Too little results in grit 'sinking', leaving insufficient on the surface for correct grip. Gently broadcast grit over the surface ensuring complete coverage. Allow a little time for the grit to settle in. Following application, check for any spots with two light a coating, and carefully correct to ensure a heavy coating of grit. Apply Sealing Coat as soon as 2nd coat is stiff for maximum intercoat bonding.

Stage 6: MIXING THE SEALING COAT

As soon as the first coat has stiffened, the Sealing Coat should be applied to ensure maximum strength. Stir Bonding Agent Sealer (BL5) before use. (Measures previously used with BL1 are OK.) Take one measure (50ml) of Sealer BL5) and one measure (25ml) of Hardener (H1) and mix well in a paper cup, using one of the spatulas supplied. The correct mixture is important, so make sure the measures are filled and emptied completely. Use separate spatulas to remove the last of the Sealer & Hardener.

Stage 7: APPLICATION OF THE SEALING COAT

Brush the Sealing Coat over the Ceramic Grit, ensuring an even coating, and making sure that the gaps between the grit are filled without excess material being able to run. Make a test piece (above) from this coat.

Stage 8: CURING

Allow the surface to cure for as long as possible (upto 16 hours at 65oF (19oC), longer at lower temperatures). Where applicable brush off any excess Ceramic Grit and retain. When the TEST PIECE IS HARD, (see above) the surface is ready for use. Allow the workload to build up as the surface continues to get stronger still for up to a week.

HEALTH & SAFETY DATA

ONECOAT & ONEDAY ROLLER KITS (Sheet 5B)

The product comprises a Bonding Agent, Hardener, & Thickener which are mixed in correct proportions, and brush applied to bond a Ceramic Grit to the required substrate.

COMPOSITIONS

BONDING AGENT: Dark brown viscous blend of Liquid Epoxy Resins with non-hazardous additives & fillers to improve application, performance, & storage. Flash Pt: >100oC.

HARDENER: Straw coloured, medium viscosity blend of liquid amines. Flash Pt: >100oC.

THICKENER & CERAMIC GRIT: Non Hazardous.

HEALTH HAZARDS

BONDING AGENT: Irritating to eyes and skin. May cause sensitization by skin contact.







HARDENER: Corrosive in contact with skin and if swallowed. Causes burns.

PRECAUTIONS IN USE & FIRST AID

GENERAL: Avoid contact of chemicals with skin & eyes. To avoid ingestion, do not eat, smoke or drink whilst working until hands have been washed. Keep chemicals away from children. Wear impervious (polythene and/or rubber) gloves. Wear glasses if splashing is likely. Avoid contact of chemicals with clothing which touches the skin, such as cuffs etc. In case of skin contact, wash immediately with a solvent-free hand cleanser. Do not use solvent. Remove contaminated clothing. Ensure adequate ventilation, especially if using in confined warm conditions, or use a mask suitable for light fumes. In case of eye contact, irrigate with water for 15 minutes & seek medical attention.

HARDENER: In case of ingestion seek medical attention. Drink 1 or 2 pints of water. Do not induce vomiting.

Full COSH Sheets available on request.

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| <p>Black Bonding Agent: Irritating to eyes and skin May cause sensitisation by skin contact.</p>  | <p>Liquid Resin Hardener/Curing Agent: Harmful by inhalation, in contact with skin and if swallowed Causes burns & May cause sensitisation by skin contact. Possible risk of irreversible effects.</p>  | | |
|  |  <p>Eye protection must be worn</p> |  |  <p>Hand protection must be worn</p> |

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