

Dual Cure 306

Organic Zinc-Rich Primer



U.S. Patents:
6,833,424 & 7,169,876

Description:

Dual Cure 306 is a proprietary organic zinc rich urethane primer. It is formulated for ease of application as a two component system that enables low temperature cure, fast recoat times and resistance to mud-cracking. A self-priming and corrosion resistant primer, DualCure™ 306 is proven to protect steel in the harshest environments. This product was designed for production environments that require fast recoat times. Unlike typical zinc coatings on the market, DualCure™ 306 provides a very smooth, near automotive quality finish at a low VOC.

Advantages:

- Extreme Corrosion Resistance
- Versatile Single or Dual-Component System
- Superior Adhesion
- 86% Zinc in the dried film
- 45 Minute Recoat
- No Heat Cure
- Easy to Mix and Apply
- Superior Impact Resistance

Uses:

- Heavy-Duty Machinery
- Piping
- Structural Steel
- Manufacturing Equipment
- Vehicles

Material Properties

Gloss Level	Matte
Density	20.10 lbs/gal 2.40 kg/ltr (mixed)
Volume Solids	63% (mixed)
VOC	3.2 lbs./gal 383 grams/ltr. (mixed)
Dry Film Thickness	3.0-5.0 mils
Pot Life	2-hours mixed @ 68°F/20°C uncovered. May be extended by sealing against moisture
Theoretical Coverage	336 ft ² /gal @ 3.0 mils DFT <i>*Excess millage may cause blistering. 7 Mils max DFT</i>

Surface Preparation:

New or Unfinished Surfaces:

Ferrous Metal: For best performance, application to abrasive blasted surface is recommended. "Commercial Blast Cleaning" (SSPC-SP6) is recommended as the minimum for blast cleaning. Proper blast media and blasting equipment shall be used to produce a minimal profile depth of 1.5 mils, 2 mils is ideal. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs. If blasting is not possible, use another Baril high performance primer.

Galvanized Metal: For best performance, application to abrasive blasted surface is recommended. "Brush Blast Cleaning". (SSPC-SP7) is recommended as the minimum for blast cleaning. Comply with the instructions from the applicator of the galvanizing for the proper time frame from when the galvanizing is applied until the blasting process should be performed. Proper blast media and blasting equipment shall be used to produce a minimal profile depth of 1.5 mils. Do not reuse abrasive media. Remove blasting dust and grit from surfaces before painting. Blasted surfaces should be coated within 8 hours after blasting or before rusting or other contamination of the surface occurs.

Aluminum: Not recommended

Previously painted surfaces: Not recommended

Mixing Instructions:

Thoroughly mix product preferably using a mechanical mixing device. The temperature of the mixed product should at least be 45°F during application. Maintain agitation during application. Mix 4 parts of Dual Cure 306 ZRU Series Part A with 1 part of ACC-910 Part B.

Application Instructions			
Spray Method	Airless	Air Assisted Airless	Air Spray / HVLP
Thinner	MAK	MAK	MAK
Quantity	0-25%	0-25%	0-25%
Nozzle or Tip Size	0.013-.017	0.013-.015	1.1-1.8
Fluid Pressure	2000 - 3000 PSI	1000 - 1500 PSI	15-25 PSI
Air Pressure	50 lbs.	50 lbs.	50 lbs.
Dry Film Thickness	3.0 - 5.0 Mils	3.0 - 5.0 Mils	3.0 - 5.0 Mils

Performance Characteristics	
Accelerated Weathering: ISO 11507 / ASTM G154	N/A
Impact (Direct & Indirect) ASTM D-2794	180 in lbs / 160 in lbs
Chemical Resistance	100 Double MEK Rubs
Flexibility: ISO 1519 / ASTM D522	Cylindrical Mandrel 10mm ISO 1520 Cupping 5-7 mm
Abrasion Resistance: ASTM D4060	Taber CS-17 / 1kg 400 cycles: 150 mg loss
Salt Spray: ASTM B-117 (3 mils 306 ZRU, 3 mils DualCure 174 Topcoat	9600 Hours
Acid Resistant:	Spills: Good, Fumes: Excellent
Chlorine Resistant:	Spills: Good, Fumes: Excellent

Dry Times: 70°F @ 3-5 mils DFT	
To Touch:	30 mins.
To Handle:	1-hr
To Re-Coat:	15 mins. to 30 mins
To Topcoat:	45 mins. min. to 8 hrs. max. Sanding required > 8 hrs.

**Applying topcoat prior to DualCure™ 306 drying may result in solvent pop. Relative humidity will assist in curing process. High humidity may cause a reduction in maximum available re-coat window.*

Health & Environmental:

In accordance with OSHA regulations on hazardous materials, harmful and irritating if in contact with skin, eyes and by inhalation. Observe safety information from MSDS sheets. Always wear proper protective suits, gloves and eye protection. In case of eye contact, immediately wash with large amounts of water and contact a medical expert. If spraying, always wear proper NIOSH approved respirators. Fresh air fed respirators are preferred. Do not eat, drink or smoke during application. Discharge, treatment or disposal is subject to federal, state, commonwealth, provincial and local laws. Since empty containers retain product residue, follow label warnings even after container is emptied. Residual vapors may explode on ignition; do not cut, drill, grind or weld on or near this container.

Cleaning Instructions:

Cleaning tools: Clean immediately after application using MEK.

Warranty / Disclaimer:

The technical data and other printed information furnished are true and accurate to the best of our knowledge. The products are warranted pursuant to acceptance of limited warranty. A copy of which can be obtained from Baril Coatings, which is the exclusive warranty with respect to the sale of this product. The modification of any component or uses not outlined in this bulletin nullifies the warranty unless advance written confirmation is obtained from Baril Coatings. No other warranties expressed or implied shall apply. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, shall be to supply replacement materials as set forth in the limited warranty.