



Nap-Gard®

7-2719 WM

Wire Mesh Rebar Fusion Bonded Epoxy

Revised: 6 March 2014

DESCRIPTION

Nap-Gard® Product No. 7-2719WM is a thermosetting epoxy powder designed to coat steel reinforcing wire mesh and other sundry parts to provide corrosion protection and has been certified to meet requirements of A775-97 and AASHTO M-284 by Independent Labs.

TYPICAL POWDER PROPERTIES

Color:	Green	Theoretical Coverage:	143 Ft ² /lb/mil
Specific Gravity:	1.35 ± .05	Shelf Life:	12 months
		@ 25°C (77°F)	
Typical Gel Time:	15 - 21 Sec		
@ 205°C (401°F)			
CSA Z245.20-10			

Transportation: The material is stable during transportation at temperatures below 25°C (77°F) and 50% RH.

TYPICAL PROPERTIES OF APPLIED FILM*

<u>TEST / REQUIREMENT</u>	<u>METHOD</u>	<u>CRITERIA</u>	<u>RESULT</u>
Flexibility	TM 10.227	@ 7-11 mils	Pass 4d bend on #4 bar (@23°C)
Knoop Hardness Number	AASHTO M284 a.1.4.8	> 12	15.0 average @ 10 mils
Chemical Resistance Test*	ASTM G20	45 days @ 24°C (75°F) in 3 Molar NaCl and 7% NaCl	

*No holidays developed, there was no softening, blistering or loss of bond at intentional holiday.

TESTING OF COATING TO A775-97 (Annex A1)

8.1 Film Thickness	90% of readings / 7-12 mils	7.6-12.2 (avg. 10.8) mils	
A1.2.5 Flexibility	(Bend #6 rebar/round 6 in. mandrel)	No cracking on outside radius	Pass, no cracking @ 24°C
A1.2.7 Abrasion Resistance	ASTM D4060-95 / CS17, 1 Kg weight, 1000 cycles	<100 mg removal per 1000 cycles	14 mg average removal
A1.2.8 Impact Test	ASTM G14 9 Nm (80in/lb)	No cracking /shattering except @ impact area	No cracking/shattering
A1.2.2 Cathodic Disbondment	7 days, 1.5V, 3%NaCl, 23°C	<4.0 mm avg. Disbondment	3.2 mm avg. radial Disbondment

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A1.2.3 Salt Spray	800 hours, ASTM B117	<3.0 mm avg. Disbondment	2.1 mm avg. radial Disbondment
A1.2.5 Chloride Permeability	FHWA A-RD-74-18	<1.0x1.04 moles/liter	1.3x10 ⁻⁵ moles/liter
A1.2.6 Relative Bond Strength To concrete	ASTM A944	>85%	121% relative bond strength

GENERAL APPLICATION PARAMETERS

- Clean the surface of the steel reinforcing bar by abrasive blast cleaning to a near white finish in accordance with SSPC-SP10 or to NACE #2. The cleaning shall remove all visual mill scale, rust and other foreign matter, and shall achieve a uniform anchor profile of 2.0-4.0 mils over the surface of the bar.
- Pre-heat the bars to (177°C) 350°F to 463°F (239°C) 463°F.
- Apply Nap-Gard® 7-2719WM powder coating to the film thickness required by electrostatic spraying.
- Follow recommended cure schedule (see below).
- Cure should be verified by DSC or other methods.

CURE SCHEDULE GUIDELINES

Application Temperature	Minimum Post Cure Time
177°C (350°F)	12 minutes
204°C (400°F)	8 minutes
232°C (450°F)	5 minutes

****CAUTION**** Minimum post cure times will vary with application parameters and rebar sizes. Therefore, the above information shall be used only as a guideline by the applicator to develop proper application temperature and post cure times. Cure should be verified by DSC or other methods.

Always consult product Material Safety Data (MSDS) prior to handling.

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