

Application Instructions

An application instruction video is available at www.gentoo coating.com. Some users may find it beneficial to watch the video prior to reading through the instructions.

Read through all instructions prior to opening or using Gentoo.

FOLLOW ALL WARNINGS AND CAUTIONS

DO NOT open Part A unless inert gas is available or unless the entire container will be used immediately after opening.

DO NOT mix Part A and Part B, unless Part A has been mixed on its own first.

DO NOT use mixing equipment that has not been rated for flammable liquids.

DO NOT leave Gentoo uncovered when it is mixing or when it is not being applied.

DO NOT spray Gentoo without sufficient engineering ventilation controls or without making a minimum of supplied-air respirators available to all those exposed to Gentoo spray.

DO NOT wait to clean equipment. Cleaning of equipment must be performed as soon as possible after Gentoo is applied and equipment is no longer in use.

DO NOT mix Part A and Part B by volume.

DO NOT add Part A to Part B. Do add Part A to the mixing vessel, and then add Part B to Part A.

DO mix Part A thoroughly before adding Part B.

DO apply a blanket of inert gas to the headspace of partially used containers of Part A immediately after the material to be used has been poured off.

DO use mixing equipment that is rated for flammable liquids.

DO cover the Gentoo vessel as often as possible, including when it is mixing and when it is not being applied.

DO clean all equipment with acetone immediately after use.

DO add Part B to Part A at a 1:1 ratio by weight.

Personal Protective Equipment

Flow, Dip, Brush or Roller Coating: always wear the following minimum personal protective equipment: safety goggles and nitrile gloves. A paint suit / Tyvek suit is recommended. If engineering ventilation controls are not available or sufficient, use a respirator (NIOSH/MSHA approved half-face respirator with an organic vapor cartridge) to protect from solvent vapors. Refer to Safety Data Sheets (SDSs) for both Part A and Part B before beginning to apply Gentoo.

Spray Coating: **DO NOT** spray Gentoo without sufficient engineering ventilation controls or without making a minimum of supplied-air respirators available to all those exposed to Gentoo spray.

If engineering ventilation controls are not available or sufficient, wear a minimum of a hooded supplied-air respirator and nitrile gloves. A paint suit / Tyvek suit is recommended. Refer to Safety Data Sheets (SDSs) for both Part A and Part B before beginning to apply Gentoo.

Preparation

Surface Preparation:

1. Remove all oil, grease, dust, dirt, loose rust, and other foreign materials to ensure adequate adhesion.
2. Clean smooth surfaces with 99% isopropyl alcohol (IPA) and microfiber cloths or other lint-free cloths. If the surface is incompatible with IPA, the application of Gentoo to the surface is not recommended. Highly porous surfaces will likely not benefit from being cleaned with IPA.
3. Gentoo may not bond to all types of plastic without further preparation. Corona treatment, flame treatment or abrasive surface preparation may be required in order to attain adequate adhesion on plastics. The use of a rubber primer may improve adhesion of Gentoo to rubber.
4. Plasma treatment (after the surface has been cleaned with IPA) may improve the adhesion of Gentoo on glass, ceramic, or metal surfaces.

Preparation (Continued)

5. Adhesion to some surfaces may improve if they are abraded, but this is not required for all surface types.
6. Surfaces with existing coatings, including Gentoo, may exhibit a reduction in adhesion without additional surface preparation, such as abrading.
7. For best results when applying Gentoo to painted surfaces, apply Gentoo when the paint is still "green" (dry to the touch, but not fully cured). If paint is fully dried and cured before Gentoo is applied, it may need to be wet-sanded or otherwise prepared in order to promote adhesion. If neither method is possible, it may be beneficial to try an adhesion promoter or tie-coat on top of the paint before applying the Gentoo.

Notes:

- Mix and apply Gentoo in a clean, well-lit environment. Dust, dirt, or other particles may influence the appearance of the coating if Gentoo is not mixed and applied in a clean environment.
- Apply Gentoo in a controlled space, free from wind. Applying Gentoo outdoors could result in significant coating defects.
- Use only glass, stainless steel, or high density polyethylene mixing vessels.
- Ensure all mixing vessels are clean. For best results, rinse with 99% IPA to remove any dust from mixing containers prior to mixing Gentoo.

Mixing

NOTICES:

- Mix so that a vortex is produced, but not faster.
- Air should not be forced into the mixture as a result of mixing at excessively high speeds or by any other means.
- If the entire container of Part A will not be used, inert gas (preferably argon, or nitrogen) must be used to blanket the headspace of the remaining liquid in the container. If this is not performed, Part A will be rendered unusable.
- After the blanket of inert gas is applied to Part A, put the lid back on the container.
- After Part B is used, put the lid back onto the container of Part B to prevent evaporation of solvents.
- Cover the mixing vessel with a lid, film or other covering as much as possible to prevent evaporation of solvents during the mixing process. If this is not possible, as in certain production processes, occasional addition of 99% IPA may be required to maintain original density.

Part A and Part B need to be combined to complete a hydrolysis reaction (this is where some of the components of Part A and Part B react together to form a new component) before the coating is ready to be applied. If hydrolysis is not complete, the chemistry will not bond to the surface or give proper performance.

STEPS:

1. Mix or shake Part A thoroughly.
 - a. Shake quarts of Part A for 30 seconds.
 - b. Mix 5-gal and 50-gal containers of Part A for 5 minutes.
2. When step one is complete, add Part A to the mixing vessel and turn on the mixer.
3. Add Part B to Part A at a 1:1 ratio, by weight (not by volume).

All containers of Part A and Part B have been filled by weight. To use a complete pair of new, unopened Part A and Part B containers, use all of Part A and all of Part B. For example:

Use one complete quart container of Part A + one complete quart container of Part B

-OR-

Use one complete 5-gal pail of Part A + one complete 5-gal pail of Part B

-OR-

Use one complete 50-gal drum of Part A + one complete 50-gal drum of Part B

Follow all other mixing instructions.

NOTES:

- **From this point forward, "Gentoo" refers to the mixture of Part A and Part B.**
- Ideally, Gentoo should be mixed above 65 °F (18 °C).
- Mix Gentoo for 120 minutes if between 65 °F and 75 °F (18 °C and 24 °C).
- Mixing at temperatures above 75 °F (24 °C) may shorten the required mixing time to potentially as little as 90 minutes.
- Mixing at temperatures below 65 °F (18 °C) may require mixing times of 3 hours or longer.
- A video showing how to check if mixing (hydrolysis) is complete can be found here: <https://youtu.be/hcNoeA3Jxx4>

After mixing (hydrolysis) is complete, proceed to filtering Gentoo. (Filtering Gentoo will remove gel bodies formed and contaminants introduced during the mixing stage. If appearance and small imperfections are not important, filtration may not be necessary.)

Filtering

Filter Gentoo using 1 µm (micron) glass fiber filters into a clean vessel, separate from the mixing vessel.

NOTES:

- It is important to use glass fiber filters, and not other materials, as they may dissolve into the Gentoo and adversely affect performance.
- The pot life of filtered Gentoo is dependent on environmental conditions:
 - At 85 °F (30 °C), the pot life may be under 4 hours.
 - At standard conditions (70 - 75 °F / 21 - 24 °C), the pot life will be close to 6 hours.
 - If Gentoo is chilled (at 40 °F / 5 °C), pot life may be over 16 hours.
 - The pot life is dependent on how quickly the solvents evaporate. As the solvents evaporate, the secondary condensation reaction begins, and the Gentoo begins to solidify.
- When the mixing and filtering processes are complete, continue to cover the vessel of Gentoo to ensure that the loss of solvents due to evaporation is minimized.
- For easiest cleaning, it is best to clean all vessels and equipment as soon as possible after use.

See cleanup section for more information.

Application Methods

For best results, all equipment should be glass, stainless steel or high density polyethylene.

Flow Coating

- In essence, flow-coating is controlled pouring.
- Flow coating by hand is not complicated but takes practice to attain an even coating.
- Very small objects can be coated using plastic droppers.
- Objects smaller than a few square feet can be flow coated using a squeeze bottle.
- For large objects, a recirculation pump attached to a hose with an in-line filter can be used.

- The object to be coated should be inserted into or suspended above a collection vessel, so the excess Gentoo can drain off of the object and be collected, filtered, and re-used.
- Please see the application video at www.gentoo coating.com or <https://youtu.be/xJ4pAx-aaPo> for more information.
- Once Gentoo has already been applied to an area, even if not fully cured, do not apply additional Gentoo over it, or lines will be visible in the re-coated area.

After the object has been coated, refer to the drying and curing sections.

Dip Coating

- Use a clean vessel of sufficient size that holds enough Gentoo to completely coat the desired portion of the object. Dip the object only once.
- After the object has been coated, refer to the drying and curing sections.

Brush/Roller Coating

- Foam brushes and rollers designed for solvent-based or oil-based paints may be used with Gentoo.
- Applying Gentoo with brushes or rollers may result in bubbles within the coating. This can be avoided by using a slower application speed and less pressure. A larger quantity of product may be required in order to obtain uniform coverage using a foam roller due to the amount of pickup required in order to saturate the foam roller.
- IPA may be used to rinse/store the brush between Gentoo applications. Gentoo allowed to begin to dry on the brush will create undesirable defects in the coating during application.
- Avoid overcoating any area of the Gentoo coating that has begun to dry. This will adversely affect the appearance, and may adversely affect the adhesion.
- After the object has been coated, refer to the drying and curing sections.

Spray Coating

- The appearance of Gentoo as applied by HVLP (high volume low pressure) sprayers may contain defects. This may include very small gel bodies, orange-peel, slight mottling and/or dust.
- Proper engineering controls or personal protective equipment are required when spraying Gentoo.

NOTICE: Engineering controls include a fume hood or other sufficient ventilation, which must be available to remove all Gentoo vapors from the working environment. If engineering controls are not available, a minimum of a supplied-air respirator must be used to protect all those exposed to the spray application.

Spray Coating (continued)

HVLP parameters:

1. An in-line particle filter and moisture trap is recommended for the HVLP gun.
2. A 1.0 mm needle/tip is recommended for HVLP sprayers.
3. Use gun pressure of less than 20 psi.
4. Ensure spray gun is clean before spraying Gentoo.
5. Pre-flush gun with 99% IPA after gun has been cleaned.
6. Avoid overcoating any area of the Gentoo coating that has begun to dry. This will adversely affect the appearance, and may adversely affect the adhesion.
7. When spraying is complete, immediately flush the spray gun with acetone.

For more information, please see the following document: <https://na19.salesforce.com/sfc/p/300000006jW/a/13000000MQuQ/P2RxmzNOrsk5KsQvgajRsefyyIFKsqTQePpyJzH2L9Q> After the object has been coated, refer to the drying and curing sections.

Drying and Curing

Drying: Allow objects with smooth surfaces to sit at room temperature for 10-15 minutes (or until dry to the touch) after they have been completely coated. Rough or porous surfaces may require more than 15 minutes to become dry to the touch.

Curing:

- For best performance, insert the object into a clean oven for 1 hour at 194 °F (90 °C), if this will not adversely affect the object.
- It is also possible to initialize curing at a temperature under 194 °F (90 °C). For example, cure in an oven at 122 °F (50 °C) for 1 hour, then cure at room temperature (68 - 77 °F / 20 - 25 °C) for 16 - 24 hours.
- If the coated object cannot sustain any elevated temperatures, it is possible to cure at room temperature (68 - 77 °F / 20 - 25 °C) in a clean environment for at least 24 to 48 hours. Some materials, for example - some plastics and some painted surfaces, may never achieve full properties with only a room temperature cure.

This is dependent on the type of material and/or substrate, the surface preparation method(s) and the environmental conditions of the application. However, in some cases achieving less than full performance may be acceptable.

- A heat gun or heat lamps may be used to impart heat onto the surface, but care must be taken to not exceed surface temperatures of 194 °F (90 °C).
- After curing, if the coated object is found to meet the needs of the end-user, it may be put into service. Performance may continue to improve over time at ambient conditions.
- A document and video showing three tests to determine if curing is complete can be found here:
 - Video: <https://youtu.be/3FIHYn-ARV0>
 - Document: <https://na19.salesforce.com/sfc/p/300000006jW/a/13000000MQij/sMu9o0mgxEKF6pkMMfJ6W3BH7eoMq7hl6SIZZqX77CE>

Cleanup

- When a vessel is no longer needed during the Gentoo mixing and application processes, remove excess Gentoo from the mixing vessel as soon as possible after taking the mixing vessel out of service.
- Excess Gentoo should be poured into a waste container, where it will turn into a gel over several hours. Completely gelled Gentoo is non-hazardous.
- Rinse the mixing vessel with acetone and wipe it clean.
- For pumps and spray equipment, flush the systems with acetone.
- Abrasive material and/or other strong chemicals may be required if cleanup is not performed immediately.
- Dispose of all unused Gentoo, cleaning solvents and cleaning materials such as rags in accordance with local, state and federal regulations.

Video Links

For more information, please see the following videos:

- Application Video: <https://youtu.be/xJ4pAx-aaPo>
- Checking Hydrolysis Video: <https://youtu.be/hcNoeA3Jxx4>
- Adhesion & Chemical Resistance Test Instructional Video: <https://youtu.be/3FIHYn-ARV0>
- Videos are also available at www.gentoo coating.com