

# BULLET ROOF MONO

## Cut Edge Corrosion Specification

### Preparation

All Edges

A sound, flake and contaminant free surface is required before applying any Bullet Roof liquids to any surface. Key surface to Swedish Standard ST2 ensuring the surface is keyed and not polished.

If any detergents have been used ensure these are fully washed/rinsed away before applying Bullet Roof liquids, as residual detergent/soap film may adversely affect adhesion. The same applies for grinding swarf, dust, grease and water as these may also affect the system if not removed prior to application.

Notes: Drying the laps can be achieved by using a mechanically driven blower to force water/moisture out of the gap/joint. If the gap between the sheets at the lap is greater than 5mm use a stitch fixing or rivet to close it.

If the underside of the lap is accessible or can be accessed in a correct and safe method, we recommend the same preparation method described above be employed wherever possible.

### Stage 1

Epoxy Primer AC

Epoxy primer AC is a 2 component high penetration primer with anti-corrosion properties which prevent the re-occurrence of rust and oxidation. All prepared surfaces must be coated with Epoxy Primer AC before any other Bullet Roof liquids are applied. This will ensure optimum bond and also that any further oxidation of the metal sheets is halted. A WFT (wet film thickness) of approximately 90 microns must be achieved and a window of 24 hrs must be allowed before applying any further Bullet products. Epoxy Primer has a large overcoating window of up to 15 days.

Notes: If the primer is rained on in this window prior to overcoating, Bullet Roof Quick Prime can be applied to regain optimum adhesion. This low viscosity primer can be overcoated in times from only 10 minutes meaning the project is not delayed.

### Stage 2

MM/MS Hybrid

The MM/MS Hybrid is available in cartridges for gun applicators. This high performance flexible sealant/adhesive is gun applied into the gap at the lap between the upper and lower sheets creating a bonded, bridged and flexible edge. Use MM/MS Hybrid to encapsulate any bolt heads or fixings within the area to be refurbished/protected. MM/MS Hybrid can be overlaid immediately and does not have to be cured before encapsulation with Bullet Roof Mono.

### Stage 3

Bullet Roof Mono

Apply the first coat of Bullet Roof Mono to encapsulate all previous stages at 1kg per m2 by brush or roller. Allow to cure overnight.

Apply second coat at 1kg per m2 to fully encapsulate the first coat and to extend a further 10mm onto the sheet. Due to the unique thixotropy of Mono it can be used on pitched surfaces without running.

Notes: Dependant on the gradient the Bullet Roof Mono can be applied in one thick coat. Care must be taken however to ensure the correct DFT (dry film thickness) is achieved. Neat edges can be achieved using masking tape but ensure the tape is removed before the mono has cured.

Do not use any form of thinners with Bullet Products unless instructed by our technical department as not all are compatible and may adversely affect the system performance.

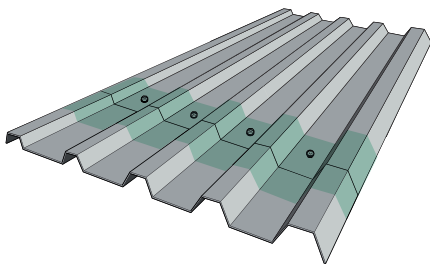
Recommended minimum treatment width is 120mm with the joint of the lap being centrally located.

We recommend that work commences at the furthest area from the roof access point to prevent uncured products being disturbed as the project commences.

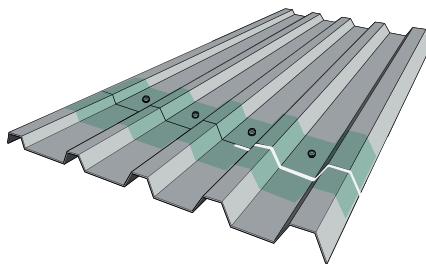
Ensure all grinding swarf is removed from the sheets after preparation to prevent rust staining.

**Note:** This is an outline specification for the general application of this system. For a bespoke specification to deal with site complexities, please contact us.

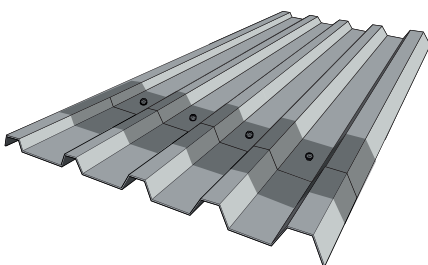
#### 1 Epoxy Primer AC



#### 2 MM/MS Hybrid Sealant



#### 3 Bullet Roof Mono Coat 1



#### 4 Bullet Roof Mono Coat 2

