



MADISON CHEMICAL INDUSTRIES INC.

APPLICATION INSTRUCTION BULLETIN

GALVAGRIP™

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Version 6, October 2010

INTRODUCTION

GalvaGrip is a proprietary Surface Preparation Compound which, when used on galvanized surfaces, greatly increases the adhesion of Madison coatings, thereby eliminating the need for blasting for virtually all applications, including embedded and immersion service. GalvaGrip also works well on weathering steel (sometimes referred to as Corten Steel). GalvaGrip is mentioned in various Technical Data Sheets and Application Instruction Bulletins where appropriate. The product is an aqueous emulsion that is easy to use and environmentally-friendly. It contains Madison's AP-50 Adhesion Promoter as well as a rust-dissolving agent, a powerful degreaser and an industrial-grade surface penetrating compound, all of which work synergistically to create adhesion comparable to that achieved with a commercial-grade sandblasting on weathering steel and with a near-white abrasive blast on galvanized structures. GalvaGrip comes in a low viscosity version (used for dipping small parts) and a foamy gel (used for all other applications).

STORAGE AND HANDLING OF PRODUCT

GalvaGrip is a non-hazardous and environmentally "green" product. Store in tightly sealed polyethylene or polypropylene (NOT metal) containers. This material is corrosive to Aluminum only. Do not store at temperatures above 40°C/100°F. Do not freeze. The recommended shelf life of the material is 12 months, but, when stored indoors, should remain acceptable for up to 2 years. Should the material be stored beyond 12 months, a Madison Representative should be consulted to determine usability.

APPLICATION EQUIPMENT

Plastic hand sprayers are ideal for occasional usage. For continuous usage, a pressure pot with a spray gun attachment is recommended. The pressure should be kept low (40-50 psi) and a (0.015"-0.019") spray tip. Alternatively, use a low pressure airless spray gun or transfer pump.

SURFACE PREPARATION

(A) For New Structures

File or grind any burrs, weld spatter or other surface roughness that may protrude through the subsequently-applied coating. Welds and other sharp edges should be rounded (ideally, this will have been done before the piece is galvanized). Then apply GalvaGrip as detailed in the Application Procedures section below. Weathering steel is prepared in the same way as galvanizing. However, adhesion will not be as great. In continuous immersion conditions, a commercial blast is recommended before applying GalvaGrip.



MADISON CHEMICAL INDUSTRIES INC.

The Technology Leader For Infrastructural Coatings™

490 McGeachie Drive, Milton, Ontario, Canada, L9T 3Y5

Tel: (905) 878 - 8863

Fax: (905) 878 - 1449

E-mail: sales@madisonchemical.com

Web site: www.madisonchemical.com

(B) For Old Structures

File or grind any burrs, weld spatter or other surface roughness that may protrude through the subsequently-applied coating. Welds and other sharp edges should be rounded. Remove loose rust, scale and/or old paint by manual or power wire brush. Then apply GalvaGrip as detailed in the Application Procedure section below.

APPLICATION PROCEDURES (GEL VERSION)

Do not apply GalvaGrip at temperatures below 10°C/50°F. GalvaGrip should be applied full-strength; do not dilute. Prior to use, GalvaGrip must be thoroughly mixed. Use a power agitator such as a Jiffy mixer. Apply GalvaGrip to a thickness of approximately 6-8 mils for a maximum effectiveness, and allow to penetrate into the surface for at least 30 minutes depending on environmental temperatures and condition of the substrate (on weathering steel, allow 40 minutes). Do not apply in direct sunlight or onto hot metal, as product will “cake” (dry out) before finishing its job. Keep wetting surface as necessary to prevent caking. If GalvaGrip has caked, it is too late to dampen the surface; remove GalvaGrip and re-apply fresh material. After recommended time, rinse GalvaGrip away with a high pressure stream of straight tap water using a power washer with a rating of 1,000 psi or higher. Add 3 to 5% baking soda to the rinse water to neutralize it. In this way, runoff is safe for ground absorption or sanitary sewer disposal (assuming the surface being prepared is not contaminated with a hazardous substance requiring special disposal precautions). Immediately after rinsing, thoroughly dry surface with clean, compressed air to remove all traces of moisture. Once dried, apply one of the following Madison coatings: GalvaClad II Aromatic, GalvaClad II Aliphatic or GalvaClad Liquid Zinc. The first two are instant setting products intended for shop use. The third is paint-like and can be used on its own (two coats in that case) or it can be topcoated with AcrylaThane or TufSheen PreCatalyzed. Metal should be coated within 8 hours of being conditioned. Equipment should be well rinsed after use and the tips cleaned to prevent build-up and plugging.

HEALTH AND SAFETY

GalvaGrip is non-hazardous and environmentally “green”. It can be used indoors or out. Take all normal precautions associated when handling mild industrial chemicals and operating a pressure washer, for example wear safety glasses or goggles, gloves and protective clothing. If swallowed, do not induce vomiting, give 3-4 glasses of water to dilute and get immediate medical care. Consult the MSDS for detailed information. This product is an aqueous solution of non-hazardous ingredients. Full strength, it has a low pH; if spilled on body, rinse with tap water to dilute.

NOTE: The following are Trademarks and/or Registered Trademarks of Madison Chemical Industry Inc.:
Madison, GalvaGrip, AP-50 Adhesion Promoter, GalvaClad, AcrylaThane and TufSheen.

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