

**DESCRIPTION:**

The NUKOTE CW two-step application process decontaminates surfaces at the molecular level, eliminating visually undetectable levels of highly corrosive substances, providing a uniform receptive surface prior to coatings application. The result is that protective coatings are more durable, more corrosion resistant and, therefore, substantially less likely to require frequent maintenance cycles - in other words; assets last longer and cost less to maintain. NUKOTE CW is simple, safe and straightforward.

**TYPICAL USES:**

- After Surface Preparation and Prior to Protective Coating - for use anywhere a protective coating will be applied to a metal substrate and extended coating performance is desirable. Coatings applied over a NUKOTE CW cleaned surfaces significantly outperform and extend coating service life when compared to coatings applied over substrates prepared according to conventional surface preparation standards. NUKOTE CW does not leave any residue and is not film-former; it can be used with any coating system.
- Before and After Welding – NUKOTE CW improves welding by removing contaminants that negatively affect puddling and weld porosity. NUKOTE CW also cleans weld flame residue and other surface contamination after welds have cooled.
- New Construction / Fabrication – NUKOTE CW expedites new steel construction by aiding in the removal of mill scale so that blasting time and blast media usage can be minimized.

*\*\*Note - NUKOTE CW may be applied before or after oxidation of the steel occurs. Contact NCSI for further information.*

**COLORS:**

Clear to slightly opaque liquid gel.

**PACKAGING:**

NUKOTE CW1 P1-G is supplied as a powder in clear plastic bags and packaged in plastic pails. Each bag makes 5 gallons of useable material.

**COVERAGE:**

100 ft<sup>2</sup>: per 1US gallon / 2.5 m<sup>2</sup> per liter of mixed, NUKOTE CW1. Be sure to allow for normal loss factors during mixing, handling and application when estimating practical coverage.  
 Typical Thickness: 12 to 16 mils / 0.30 TO 0.40 mm

<b>PROCESSING PROPERTIES (Under standard lab conditions)</b>	
Mix Ratio	One (1) five (5) pound / 2.3 kg bag per 5 gallons / 19 liter of activated carbon filtered or good quality chlorine free water
Dry to Touch	Dry to touch within 20 – 30 minutes depending on relative humidity, wind and air movement, air temperature and substrate temperature.

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**MIXING:**

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NUKOTE CW1 is supplied as a powder in clear plastic bags and packaged in plastic pails. Each bag makes 5 gallons / 19 Liters of useable material. Empty one bag into a 5-gallon /19 Liter clean plastic or metal pail filled with 2-½ gallons / 9.5 Liters activated carbon filtered water, RO water or chlorine free potable water. Do not use galvanized buckets. Blend with Jiffy mixer style powered mixing tool until all white granules have dissolved, the mixed liquid is clear and lump free, and a gel forms. Add the remaining 2-½ gallons / 9.5 Liters of activated carbon filtered water, RO water or chlorine free potable water and blend all materials until completely mixed. Continue mixing as needed until the mixed material forms a gel. At temperatures between 32° F. (0° C.) and 50° F. (10° C.) allow one-hour induction time; at temperatures between 50° F. (10° C.) and 70° F. (21° C.) allow one-half hour induction time. If gel does not form while mixing NUKOTE CW1 at higher temperatures, simply allow induction time until gelling occurs.

**Mix Ratio** One (1) five (5) pound / 2.3 kg bag per 5 gallons / 9.5 Liters of activated carbon filtered or good quality chlorine free water.

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**SURFACE PREPARATION:**

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Substrates to be treated must first undergo a cleaning process to remove mil scale, pit rust and other visible surface interference materials. A pre-cleaning process of an SSPC SP-1 solvent cleaning to high-pressure water washing, UHP, abrasive blast cleaning, etc. is typically necessary prior to the application of NUKOTE CW1

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**APPLICATION:**

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NUKOTE CW1 may be applied by airless or conventional spray, using clean equipment suitable for waterborne, mild acid product. Use new fluid hose or hose that has been dedicated to the use and application of NUKOTE CW1 After use, flush pumps and hoses thoroughly with the mixed NUKOTE CW2.

(Alternate) Airless sprayer. If airless spray equipment, hoses and gun have been used previously for applying paint, flush with strong solvent, then with potable water and last with a single rinse of deionized water. When possible, use new fluid hose. Use a large wide-fan tip, and hold the gun close to the surface being prepared. For Airless spray, use the minimum pressure required producing a working fan; tip sizes and fan width may range from .017 to .025, depending on size and complexity of surfaces to be coated. For Conventional spray, use a plastic pot liner whenever possible. Use a gun, needle and tip combination suitable for spraying light bodied paints. Use 20-35 PSI minimum pot pressure and sufficient atomization pressure to produce a uniform fan. Test spots or small areas of NUKOTE CW1 may be removed using NUKOTE CW2 in a hand spray bottle, or by scrubbing with a clean scrub brush dipped in NUKOTE CW2 and then rinsing the area with additional NUKOTE CW2.

NUKOTE CW1 may be applied using wet abrasive blast equipment as part of a wet abrasive blast surface preparation process, where the wet abrasive blast application equipment is compatible. *Contact NCSI for further information.*

NUKOTE CW2 prepared surfaces may be painted as soon as the substrate is fully dry.

NUKOTE CW prepared surfaces will not “rust back” or “flash rust,” if contaminants have been thoroughly removed, but atmospheric contaminants may settle on the NUKOTE CW prepared surface if left exposed and uncoated. NUKOTE CW2 only areas, which can be coated soon after the substrate is dry, preferably during the same shift or the same workday.

After drying, carbon steel surfaces prepared with the NUKOTE CW two step system the surface may exhibit a wide variety of appearances, from a bright mirror-like finish to a dull gray appearance. Such variation is normal and depends on the composition of the steel, method of surface preparation, anchor profile (if any) and other factors. Effectiveness of the NUKOTE CW process may be confirmed by testing the surface for residual iron salts using Potassium Ferricyanide impregnated paper.

**EQUIPMENT CLEAN UP:**

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Thoroughly flush all equipment with potable water according to normal maintenance procedures. Dispose of cleanup waste in accordance with all local ordinances.

**LIMITATIONS:**

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Do not coat surfaces prepared with NUKOTE CW1, which have not been properly prepared with NUKOTE CW2.

Do not coat surfaces prepared with NUKOTE CW1 with tap water or with anything other than NUKOTE CW2 treated water.

In cool, humid conditions increasing airflow over the substrate may speed up drying time. Be careful not to contaminate the surface.

**WARRANTIES AND DISCLAIMERS:**

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*Nukote Coating Systems International, a Nevada, USA Corporation warrants that this product shall conform to the technical specifications published in the product literature. The quality and fitness of the product is dependent upon the proper mixture and application of the components by the applicator. Nukote Coating Systems has no role in the application of the finished polymer other than to manufacture and supply its two components. It is vital that the person applying this product understands the product and is fully trained and certified in the use of plural component equipment and application of plural component materials. There are no warranties that extend beyond the description on the face of this instrument, except when provided in writing, directly by Nukote Coating Systems International and executed under seal by a company officer.*