

Guidance for Protecting Cut Edges

It is recommended to use PPG MULTIPRIME 4160 or Fast Dry 4190 coating, following the instructions on their data sheet.

PPG MULTIPRIME 4160 – Rust-inhibitive alkyd primer for corrosion protection

Learn more: www.ppgpmc.com/products/multiprime-4160

PPG Fast Dry 4190 - Quick-dry universal primer with zero HAPS

Learn more: www.ppgpmc.com/products/fast-dry-4190

Why is primer recommended for touch-ups and not epoxy?

1. Speed: Primer cures in minutes/hours, allowing immediate assembly. Factory epoxy takes days to fully cure.
2. Surface Tolerance: Primer adheres better to field-cleaned surfaces (e.g., wire brush). Epoxy requires specialized blast cleaning for proper adhesion.
3. Function: Primer prevents flash rust. The joint's long-term seal is actually provided by the coupling gasket, making the high-performance epoxy unnecessary at that specific cut location.



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Surface Preparation

1. Field cuts shall be made using approved cutting tools (snap cutter, saw, or other method per manufacturer).
2. Remove all burrs and sharp edges.
3. Clean the cut surface using a wire brush or abrasive pad to remove loose metal, scale, and debris.
4. Thoroughly wipe the cut end to remove oil and residue. Surface shall be clean and dry prior to coating.

Application

1. Apply a uniform coat to the exposed iron at the cut end.
2. Extend PPG primer approximately 0.5 inches onto the factory coating to achieve full overlap and continuous corrosion protection.

Curing

1. Allow coating to cure until the surface has reached a dry and tack-free condition.
2. Cure times vary depending on temperature, humidity, and air movement:
 - a. Dry to touch: ~20 minutes at 70°F
 - b. Full cure: ~60 minutes