

# 914 VINYL MASTIC EPOXY

**Description**

Two component epoxy coating modified specifically with vinyl resins to provide excellent adhesion and corrosion protection even in poorly prepared metal and cement surfaces (i.e., without sandblasting, unpainted for long periods of time etc.). It contains zinc phosphate as an active anticorrosive pigment (free from lead and chrome compounds). Exhibits excellent adhesion to metals, such as galvanized steel, stainless steel and non-ferrous metals such as aluminum and light alloys. It is ideal for painting industrial structures as a primer or intermediate or as a final topcoat (where gloss, color retention and cosmetic effect are of less importance), providing long-term protection. Suitable also as a self-primed coating. Ideal for heavy duty industrial applications, chemical plants, for costal, offshore and marine applications.

**Technical Information**

Shade Any RAL upon request (Unavailable on light shades or white)

Specific Weight A component 1,40 - 1,50 kg/lt (depending on the base)  
B component 0,95 kg/lt  
A+B 1,30 ±0,05 kg/lt (EN ISO 2811)

Theoretical Coverage 4,75 m<sup>2</sup>/kg, (100µm)

Temperature resistance Up to 120°C (service temperature)  
In temperatures higher than 80°C, change of color may appear.

Solids content (A+B) 62 ±2% per volume  
75 ±2% by weight (EN ISO 3251, non-volatile)

Adhesion GT 0 (steel) – GT 1 (galvanized steel, stainless steel, aluminum)

Mixing ratio A:B-4:1 by weight (A:B - 2,65:1 by volume)

Pot life 5 hr (25°C) Temperature increase reduces the pot life.

VOC\* (A+B) 349 g/lt  
Ready for use (+10% thinner): 402 g/lt  
EU LIMITS (2010): 500 g/lt  
SUBCATEGORY: j – two pack performance coatings, primer coat for ferrous substrates, anticorrosion finish, Type SB

**Drying Time**  
100 µm, 60% RH

(5°C)  
(15°C)  
(25°C)  
(35°C)

Pot life	Touch dry	Dry	Dry to recoat (Min)	Dry to recoat (Max)	Full Dry
		30 hr	32 hr	6 days	16 days
		18 hr	20 hr	3 days	9 days
5 hr	4-5 hr	12 hr	12 hr	56 hr	6 days
		11 hr	11 hr	48 hr	5 days

*The above times are indicative and depend on the thinning percentage, substrate conditions, film thickness, weather conditions (e.g., relative humidity, wind, sunshine).*

**Oven force Drying times**

- 40 min / 60°C, touch dry
- 50 min / 60°C, dry to recoat (ready to recoat, recoating time max 20 hr/25°C)
- 60-65 min / 60°C, hard dry (ready to recoat, recoating time max 16 hr/25°C)

Do not heat more than 90 min

Flash off time before oven: 5-10 min 25°C, 100µm DFT

**Surface preparation**

All applications on steel, including welding, cut with flame and smoothing, must be terminated before the preparation of the surface. Cleaning of the surface from dust and other materials like oil, grease etc using special detergent and fresh water under high pressure. The alkaline remnants of the recent welding joints as well as the traces of soap, must be removed with fresh water and rubbing. For better results, sandblast is recommended at least Sa 2 ½, ISO 8501-1. For galvanized surfaces, it is recommended to degrease and treat the surface with sanding or other mechanical means. Cleaning the surface with soft sandblasting (sweep blasting) is the most reliable method for achieving

**Application**

good adhesion of coating to the surface.

Thoroughly mixed components A: B-4: 1 (by weight).

**Application: approximately 20 minutes after mixing.** Proposed use mechanical stirrer. It is important to stir both around the walls and at the bottom of the mixing container, so the hardener is evenly distributed.

It is applied with:

AIRLESS after 5% thinning with thinner (nozzle 0,43-0,58mm, 0,017-0,023in)

AIR PISTOL (nozzle: 1,8-2,2 mm) after thinning 5% with thinner.

Suggested film thickness 50-150 µm

Application temperature 5-35°C

Substrate temperature 5-35°C

Due point The substrate temperature must be at least 3 °C higher than the dew point.

Relative humidity < 80%

Suggested thinners 1120–1131

The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company.

The above conditions must be followed both during the application process and throughout the drying.

It should not be applied when rain is expected (at least 24h).

It is necessary to protect the coating from the moisture (>80%) and the rain for about 24 hours after the application. Moisture can cause white or/and sticky surface and can affect drying and recoating time. The surface where the product will be applied on must be clean and dry. **If you exceed the maximum recoat time, the surface should be mechanically treated before repainting.**

**NOTE:**

**When applicable, products primarily meant for use as primers may have slight color variations from batch to batch.**

**Like all epoxy coatings (at the external use), at prolonged exposure to weather conditions, may present chalking and colour alteration. This incident occurs on the surface and doesn't affect the anticorrosive and protective properties of the product.**

**During curing procedure (natural or forced), slight colour change may occur. This is normal and does not affect the properties and/or performance of the coating.**

**If the color stability and the aesthetic result are important, recoating with polyurethane finish coat is required.**

**Storage**

Up to 12 months in a dry and cool place. (5-35°C) protected from direct solar radiation and adverse weather conditions, stored in the original unopened containers.

**Safety**

Please consult the Material Safety Data Sheet. Available upon request.

This Technical Data Sheet replaces and cancels every previously issued. The information, instructions, recommendations and specifications mentioned in this data sheet, represent the results and experience obtained from testing under controlled or specially adapted conditions. The accuracy and relevance of these results to the actual conditions, in which you apply the product, must be determined and depend only on the purchaser and/or applicator.