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. It is also available in winter grade (B component) which is specially designed for low temperatures applications and faster curing.

Properties

- Excellent adhesion to critical metals
- Surface tolerant - Heavy duty
- Moisture tolerant

Additional properties of 914 winter grade:

- Faster curing times
- Cures down to -5°C
- Fast recoat
- Faster hardness development
- Moisture tolerance at extreme conditions

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	0,92 ±0,02 kg/lt
	A+B	1,30 ±0,05 kg/lt (EN ISO 2811)
Theoretical Coverage	4,75 m^2/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 - 2,45:1 by volume)	
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 60% RH, 100 µm

	Pot Life	Touch Dry	Hard Dry	Overcoating Min	Overcoating Max	Full Dry
	STANDARD GRADE					
10°C	6 hr	6 hr	10 hr	12 hr	5 days	12 days
20°C	5 hr	3 hr	7 hr	9 hr	52 hr	8 days
30°C	3 hr	2 hr	6 hr	8 hr	40 hr	6 days
	WINTER GRADE					
-5°C	-	-	-	-	-	-
0°C	-	-	-	-	-	-
5°C	-	-	-	-	-	-
10°C	5 hr	3 ½ hr	6 hr	8 hr	4 days	9 days
20°C	4 hr	1 ½ hr	3 hr	4 hr	2 days	6 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 good adhesion of coating to the surface.

Application

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
Dew point	The substrate temperature must be at least 3 ºC 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.**

NOTES:
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.
914 winter grade is capable of curing below 0°C. However, it is recommended not to be

	applied at subzero temperatures (below 0°C) because of the possibility of ice formation on the substrate. If maximum recoating time is exceeded, the surface must be mechanically treated to ensure proper intercoat adhesion.
Storage	Up to 24 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.