916 EPOXY MASTIC

Description

Two component high solids epoxy coating, polyamide adduct cured. It forms a hard and durable film with mechanical and chemical resistance (surface tolerant epoxy). It is ideal for protecting industrial structures as self-primed or intermediate or topcoat (where gloss, color retention and cosmetic effect is of less importance), providing long-term protection. It contains zinc phosphate as anticorrosive additive. Ideal for metallic and cement industrial constructions that demand strong chemical resistance. Suitable also as a self-primed coating. It is offered after request in MIO (micaceous iron oxide), which contains organometallic iron oxide (micaceous) for extra anticorrosion protection. Ideal for heavy duty industrial applications, chemical plants, for costal, offshore and marine applications, buried metallic structures, for soil-immersion use, etc.
It is also available in winter grade (B component) which is specially designed for low temperatures applications and faster curing.

Properties

- Surface tolerant - Heavy duty
- High solids
- Excellent anticorrosive properties
- Multi-purpose use as self-primed, Intermediate or topcoat

Additional properties of 916 winter grade:

- Faster curing times, especially in low temperatures
- Cures down to -5°C
- Fast recoat
- Excellent moisture tolerance

Technical Information

Shade	Any RAL upon request	
Gloss	Semi-gloss	
Specific Weight	A component	1,57 - 1,65 kg/lt (depending on the base)
	B component	1,00 ±0,02 kg/lt
	A+B	1,45 ±0,05 kg/lt
	A component (MIO)	1,79 kg/lt
	A+B (MIO)	1,58 ±0,05 kg/lt (EN ISO 2811)
Theoretical Coverage	5,51 m^2/kg (100µm)	
Temperature resistance	Up to 120°C (service temperature)	
Solids content (A+B)	80±2% by volume	
Mixing ratio	A:B-5:1 by weight (A:B - 3:1 by volume)	
VOC*	(A+B) 201 g/lt Ready for use (+5% thinner): 231 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 150 µm, 60%RH

	Pot life	Touch dry	Dry	Overcoating (Min)	Overcoating (Max)	Full Dry
	STANDARD GRADE					
5°C	-	-	36 hr	40 hr	12 days	18 days
10°C	-	-	24 hr	28 hr	7 days	12 days
20°C	2 hr	3 ½ hr	8 hr	11 hr	5 days	6 days
30°C	1 hr	2 ½ hr	5 hr	10 hr	4 days	5 days
	WINTER GRADE					
-5°C	-	36 hr	76 hr	84 hr	16 days	60 days
0°C	-	22 hr	44 hr	52 hr	12 days	26 days
5°C	3 ½ hr	11 hr	28 hr	32 hr	8 days	14 days
10°C	2 ½ hr	5 hr	16 hr	20 hr	6 days	10 days
20°C	1 hr	2 ½ hr	5 hr	7 hr	3 days	5 days

The above pot lifetimes refer to material without addition of thinner. After adding thinner, a small increase in the pot life is expected. The above times are indicative and depend on the thinning percentage, substrate conditions, film thickness, weather conditions (relative humidity, wind, sunshine).

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. If it is necessary, the surface could be treated with a two-component anticorrosive primer (i.e., 812 EPOXY PRIMER or 751 EPOXY ZINC PRIMER or 851 INORGANIC ZINC PRIMER).

Application

Thoroughly mix components A: B-5: 1 (by weight).

No induction period is required for applications in temperatures above 15°C.
Induction period for applications in temperatures below 15°C: 10-15 min.
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 (nozzle 0,43-0,58mm (0,017-0,023in)) after 5% thinning with thinner.
AIR PISTOL (nozzle: 1,8-2,2mm) after 5% thinning with thinner.

Suggested film thickness	100-200μm
Application temperature	-5-35°C
Dew 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 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 also can affect drying and recoating time. The surface where the product will be applied on must be clean and dry.

NOTES:
Like all epoxy coatings (at the external use), prolonged exposure to weather conditions may present chalking and color alteration. This incident occurs on the surface and doesn't affect the anticorrosive and protective properties of the product.
916 EPOXY MASTIC 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 (5-30°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.