ROPOXY MASTIC 88

Description

This is a two-component poly amine cured epoxy mastic coating. It is a surface tolerant, high solid, high build product. Specially designed for areas where optimum surface preparation is not possible or desired. Provides long lasting protection in environments with high corrosivity. Can be used as primer, mid coat, finish coat or as single coat system in atmospheric and immersed environments. Suitable for properly prepared carbon steel and aged coating surfaces. It can be applied at subzero surface temperatures.

Principal Characteristics

- Primarily designed for maintenance and repair.
- Outside hulls, exterior and interior areas, including water ballast tanks.
- Easy to apply by spray, roller or brush.
- General purpose epoxy finish in protective coating systems for steel metals to be used in immersion and atmospheric exposures.
- Recommended for off shore environments, including splash zones, refineries, power plants, bridges, buildings, mining equipment and general structural steel.
- Good water resistance
- Resistant to splash and spillage of mild chemicals and solvents.
- Good adhesion properties on steel and concrete structures.
- Suitable on wet blast cleaned substrates.

Technical data

Color & gloss	As the customer request / semi-gloss.
Flash point (DIN 53213)	Base 32ºC hardener 31ºC.

Mass density	Approx. 1.65 gm. / cm3
Solid content	Approx. 85 % ± 2 by volume
Theoretical spreading rate	2.7 m2/ltr for 200 microns D.F.T.
Touch dry after	Approx. 3 - 4 hours
Recommended dry film thickness	150 – 200 ums (per one coat)
Over coating interval	Min. 10 hours. (at 25 ºC & 60 % R.H.) max. 3 months. (at 25 ºC & 60 % R.H.)
Full cure after	7 days
Shelf life (cool and dry place)	At least 12 months in original containers.

Instruction for use

Mixing ratio by weight: base to hardener **6 : 1**

- the temperature of the mixed base and hardener should be above 15 ºC otherwise, extra solvent may be required to obtain application viscosity.
- Too much solvent results in lower sag resistance and slower cure.
- Thinner should be only added after proper mixing of the base and hardener.

Pot life at 20 C	8 hours
Recommended thinner	Roots thinner No. RO10455 (flash point 26 °C)

Airless spray

Volume of thinner	0 - 5 % depending on required D.F.T.
Nozzle orifice	approx. 0.48 mm (= 0.019 inch)
Nozzle pressure	0. 5 MPa (= Approx. 150 at; 2100 p.s.i)

Air spray

Volume of thinner	5-10 % depending on required D.F.T.
Nozzle orifice	1.5 – 3 mm
Nozzle pressure	0.3 – 0.4 MPa (= Approx. 3-4 at; 43-57 p.s.i)

Brush / Roller

Volume of thinner 0-5 %

Cleaning solvent Roots thinner No. RO1003 (flash point 26 °C)

Additional data

Over coating table with Epoxy paint

Substrate temperature	20 ºC	30 ºC	40 ºC
Min interval	10 hrs.	8 hrs.	6 hrs
Max interval	3 months	2 months	1 month

Curing table

Substrate temperature	**Dry to handle**	**Full cured**
20 ºC	10 hrs.	4 days
30 ºC	7 hrs.	3 days
40 ºC	5 hrs.	2 days

Pot life (at application viscosity)

20 ºC	8 hrs.	the figures are valid for quantities of 5 liters approx.
30 ºC	6 hrs.	
40 ºC	4 hrs.	