



## Top Mastic Epoxy 450

### Product Description

It is a high-solids, rust-inhibitive, surface-tolerant epoxy mastic for professional use in industrial and commercial applications. Ideal for protection of steel and concrete. Excellent for use on ferrous and non-ferrous metals, and when properly top-coated, exhibits excellent chemical and moisture resistance. Resists solvents, dilute acids and alkali attack

### Product uses:

- Designed as an epoxy primer or build coat in protective coating systems.
- Excellent resistance to saline, marine and chemical environments.
- Ferrous Metal, Galvanized, Aluminum, concrete, Aged Coatings.
- Intended for use on hand prepared rusty ferrous metal, abrasive blast cleaned and hydro-blasted ferrous metal, blasted concrete, and over a wide range of intact aged coatings.
- Use in industrial maintenance, coastal structures, pulp and paper plants, food and beverage plants, structural steel, tank exteriors, bridges, offshore, marine and immersion in fresh or salt water.
- To repair of existing coating on steel in Coating Systems when environmental conditions do not allow blast-cleaning, and for brush application when a dense coat is required in a single operation. The paint is also suitable for application in engineering shops.

### Properties

- Good adhesion to wire-brushed steel.
- Good resistance to chemicals and water.
- Provides good adhesion for top coats.
- Good adhesion on steel and aged epoxy coatings.
- High solids and high build – excellent for corners, crevices, welds and as a concrete filler.
- Excellent for secondary containment.
- Hard scratch- and impact-resistant coating.

### TECHNICAL PROPERTIES

<i>Appearance/Color</i>	Semi flat / RAL color card
<i>Density:</i>	1.48 kg/liter (Mixed)
<i>Volume solids %:</i>	75 %
<i>Theoretical spreading rate:</i>	10 m <sup>2</sup> /ltr / 6.75 m <sup>2</sup> /kg (75 micron DFT)
<i>Consumption:</i>	0.100-.0.150 ltr/ m <sup>2</sup> (150-200 g/m <sup>2</sup> )
<i>Recommended DFT: (Dry Film thickness)</i>	100-200 micron
<i>Flash Point:</i>	32° C. /89.6°F
<i>Pot Life:</i>	2 hours (23°C and 50% R.H.)
<i>VOC:</i>	10 g/ltr
<i>Surface dry:</i>	1 approx. hour(s) 23°C/73.4°F 50% R.H
<i>Light foot traffic</i>	12-14 hours (23°C and 50% R.H.)
<i>Full dry:</i>	24 hours (23°C and 50 % R.H.)
<i>Full cure time:</i>	7 days (23°C and 50 % R.H.)
<i>Application temperature:</i>	+8 °C/46.4° F and +35 °C/ 95°F
<i>Min. cure temperature:</i>	+10°C/50°F



## Application Details

<i>Mixing Ratio:</i>	Component A: 6– Component B: 1 (By weight)
<i>Application method:</i>	Brush – Roller – Airless Spray
<i>Thinner:</i>	Epoxy Thinner
<i>Thinner Amount:</i>	Brush (Do not thin) – Roller (10 %)- Airless spray ( 5-7 %)

## Surface Preparation:

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the primer.
- Oil and grease should be removed as per SSPC-SP1 solvent cleaning with aromatic solvents.
- Surface should be checked and treated in accordance with ISO 8504 prior to priming.
- Blast Cleaning:
  - Steel, abrasive blast clean to min. Sa 2 1/2 (ISO 8501-1: 200) or SSPC –SP6.
  - In case oxidation has occurred between blasting and application of Top Mastic Epoxy , the surface should be re blasted.
  - A blasting profile of (Rz) 30 - 50 microns is recommended
  - If blast cleaning is impractical, remove loose rust/ scale using power tools/ hand tools to achieve St3/ St2 grade of surface preparation as per Swedish standards
  - Damaged Area:
    - Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting in small area is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable.
    - The product should be applied over a surface that is dry and free from all contamination and must be applied within the over coating intervals specified (refer to application section for details).

## PRECEDING COAT:

Nothing

## Important Remarks:

- Surfaces must have enough structural strength.
- Concrete should have minimum of 25 N/mm<sup>2</sup> compression resistance and minimum 1, 5 N/mm<sup>2</sup> tensile strength.
- Applications below 10°C should be avoided.
- High temperatures lower the pot life of the product, while low temperatures extend cure time and consumption.
- Be careful about product mixing ratios.
- The surface should be protected from moisture and rain for 8-10 hours after application.
- All application tools and equipment should be cleaned with thinner immediately after the use. Cured material can only be removed mechanically.
- Use only where application and drying can proceed at temperatures above: 10°C/50°F. The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a Temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
- The natural tendency of epoxy coatings to chalk in outdoor exposure.



### ***Shelf life & Storage:***

24 months from date of production if stored properly in original, unopened and undamaged sealed packaging in dry conditions at temperatures between +5°C and +30°C.

### ***Safety:***

For information and precautions on the safe handling, transportation storage and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

### ***Mixing:***

Before mixing with the curing agent, stir the base thoroughly in order to prevent any possible settling after storage. After mixing it is equally important to maintain stirring to keep the wet paint as a Homogeneous mixture.

### ***Legal Notice:***

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