

APCOGLASS MASTIC 2000

Surface tolerant epoxy

PRODUCT DESCRIPTION

Two component, high built, high solids, glass flake reinforced polyamine cured epoxy surface tolerant coating

FEATURES AND RECOMMENDED USE

- High performance coating for highly aggressive aqueous/ chemical environment
- Excellent corrosion and chemical resistance
- Excellent impact and abrasion resistance
- Compatible with various aged sound oleoresinous, epoxy and polyurethane coatings
- Self-priming coating, tolerant to lower grades of surface preparation
- Very low water permeability, due to glass flake barrier
- Low volatile organic content

TECHNICAL DATA

Colour	Range
Gloss	Semi Glossy
Volume Solids	Approx. 90%
Recommended DFT / Coat	150 - 250 microns
Theoretical Coverage Capacity	6.0 sq.mtr/ ltr @ 150 microns DFT 3.6 sq.mtr/ ltr @ 250 microns DFT
Drying Time at 30°C	Surface Dry : 5 hours Hard Dry : 16 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 16 hours Max. : 1 Month, provided surface is dry and clean from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances
The volume solids indicated are as per ASTM D 2697 air drying method
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30°C and 65% relative humidity

DIRECTIONS FOR USE

Surface Preparation

General:

- 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 coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming
- Weathered steel; power tool cleaned to St 3 or hand tool cleaned to St 2 grade of surface preparation as per Swedish standards
- Existing sound epoxy coating system and sound alkyd coatings; intact areas to be roughened. Damaged and rusty areas to be de-rusted to minimum. St3/ St2 by power tool/ hand tool cleaning. High pressure water washing and scrubbing to remove loose paint and contamination

Blast Cleaning:

- New Hot Rolled 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 Apcoglass Mastic 2000, the surface should be reblasted
- A blasting profile of (Rz) 50-75 microns is recommended

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcoglass Mastic 2000 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer (at lower RPM) for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 4 : 1
Induction Time	15 minutes
Pot Life at 30°C	90 minutes

Application

Airless Spray	
Recommended thinner	T 131
Volume of thinner	5 - 15%
Nozzle orifice	0.58 - 0.71 mm (23 – 28 Thou)
Nozzle pressure	20 – 24 MPa (= approx. 200 – 240 atm; 2900 – 3500 p.s.i.)
Cleaning Thinner	T 141
Brush / Roller (Only for Touch up)	
Recommended thinner	T 131
Volume of thinner	5 - 20 %
Cleaning Thinner	T 141

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 141. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- Maximum film build in one coat is best attained by airless spray. . Air spray (pressure pot) may require a multiple cross spray pattern to achieve optimum film build. By brush application 50-75 microns is achieved in one coat and multiple coats will be required to achieve the total specified thickness
- The maximum performance is achieved after complete curing
- As common to all epoxy, the product will chalk and discolour on exterior exposure. However these phenomenon are not detrimental to anti-corrosive performance

PACK SIZE	20 ltrs (Base : 16 ltrs & Hardener : 4 ltrs)
STORAGE	Shelf Life: Atleast 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash Point: Base : Not less than 24°C Hardener : Not less than 24°C VOC: Approx. 100 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.40 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product



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