

# Technical Data Sheet

## EPOXYMASTIC IB

Serie 139200

### PRODUCT DESCRIPTION

Two components solvent free epoxy paint, surface tolerant, abrasion resistant, with no limit to recoat.

### INTENDED USES

Particularly suitable for applications where steel blasting may not be possible, or on hydrojetted surfaces still being moist. Gives excellent corrosion protection both in salt and fresh water as well as buried structures. Excellent resistance to cathodic disbonding (according to ASTM G95). EPOXYMASTIC IB can be used for exposures category Im1, Im2 and Im3 (according to standard ISO 12944).

### TECHNICAL INFORMATION

Product type	Solvent free epoxy			
Colours	Gray, Dark gray, Red oxide, Off white, Green			
Solids (% +/- 2)	85 (by Volume)	92 (by Weight)	SOV/VOC (g/liter)	<105 Directive 2004/42/CE
Specific Gravity (g/liter +/- 100)	1300		SOV/VOC (g/liter) (calculated)	<100 Directive 2010/75/CE
Flash Point (°C +/- 2)	not flammable			
Appearance	glossy			
Temperature Resistance (°C)	100 (constant dry) - 120 (peak dry) - <40 (immersion in water)			

### APPLICATION DATA

Application Range (min - max) Typical	Film thickness per coat in micron		Theoretical spreading rate		Consumption
	Dry	Wet	m <sup>2</sup> /l	m <sup>2</sup> /kg	g/m <sup>2</sup>
	200 - 500	236 - 589	4.3 - 1.7	3.3 - 1.3	-
	<b>300</b>	<b>353</b>	<b>2.8</b>	<b>2.2</b>	<b>459</b>

Room Temperature	min 5°C	Max 40°C	Relative Humidity	min 5%	Max 80%
Mixing Ratio	2 - 1 (by weight)		1,5 - 1 (by volume)		
Pot life	1 h (Reduced at higher temp.).				
Thinner/Cleaner	Thinner for epoxy paint				

Application methods Use airless spray with high compression ratio (min. 60:1). Remove all filters. Brush is recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

### Guideline for airless spray

Pressure at nozzle	20 MPa (200 kp/cm <sup>2</sup> , 2800 psi)
Nozzle tip	0.021-0.031" (0.53-0.79 mm)

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**EPOXYMASTIC IB**

**Series 139200**

**SURFACE PREPARATION**

Surfaces must be clean, free of various contaminants. Oil and grease must be completely removed through the use of appropriate solvents. Power tool cleaning to min. St 2, mill scale free. Improved surface treatment (blast cleaning to Sa 2,5 - Sa3) will improve the performance.

**CONDITION DURING APPLICATION**

The temperature of the substrate should not be less than 5°C and at least 3°C the dew point of air, with measuring of temperature and humidity in the vicinity of the substrate.

**DRYING TIMES**

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with: good ventilation (outdoor exposure or free circulation of air), recommended film thickness, one coat on top of inert substrate.

Substrate temperature	Surface Dry <sup>1</sup>	Hard Dry <sup>2</sup>	Cured <sup>3</sup>	Dry to recoat <sup>4</sup>	
				minimum <sup>5</sup>	Maximum <sup>6</sup>
10°C		32h	14g	32h	-
20°C		9h	7g	9h	-
30°C		4h	3g	4h	-

- 1
- 2 Data provided by the laboratory and practices experiences.
- 3 Data provided by the laboratory and practices experiences.
- 4 Data provided for the covering with the same generic type of paint.
- 5 In the case of application of several coats, the drying time will be affected by the number of hands in sequence, and the total thickness reached.
- 6 The surface should be dry and free from contamination before applying the next coat.

Given data must be considered as guidelines only. Actual drying time can only be decided at site, depending on age of existing system, generic types, numbers of coats, thinning, temperature, ventilation, etc.

**THIS PRODUCT IS INTENDED FOR PROFESSIONAL USE ONLY**

The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Ti.Pi.Ci.'s technical documentation.

**STORAGE AND PACKAGING**  
**STORAGE**

the product should be stored in accordance with national regulations. The best storage conditions are to keep the packages in a dry space provided with adequate ventilation.

SHELF LIFE 24 months  
PACKAGING 8 kg comp. A and 4 kg comp. B (12 kg KIT A+B)

**HEALTH AND SAFETY**

**For detailed information on the health and safety hazards and precautions for the use of this product, we refer to the Material Safety Data Sheet.**

**Disclaimer**

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we can not guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*