

SIPOXY HB MASTIC 230

High Solids Polyamide Cured Epoxy Mastic

Product No. 6230

Features

- Designed for use as a primer/finish one coat system or as a primer in a high build multi coat system.
- Compatible with lower surface preparation standards.
- Special formulation provides optimum wetting and penetration of tightly adhering rust.
- Contains optimum amounts of inhibiting zinc phosphate pigment for prevention of rust under cutting.
- Can be applied over most aged alkyds and other tightly adhering aged paint systems.

Recommended Use

- As a high build primer in a coating system over pitted or rough steel surfaces.
- As a high build primer/finish maintenance coating on structural steel, pipe lines, tank exteriors, bridge structures etc. in all atmospheric and marine exposures.
- For upgrading aged existing coating systems.

Physical Data

Finish : Semi-Gloss

Colours : Various

Volume Solids : 85%

Recommended Film Thickness:
100 microns dry = 118 microns wet

Theoretical Coverage:
8.5 m²/ltr. at 100 microns

Density (mixed) : 1.4 kg/ltr.

Drying & Recoating Times at 125 microns (25°C/65% RH):

Dry to Recoat : 12 Hours
Hard Dry : 24 Hours
Maximum Recoating Time : Not Limited

Heat Resistant : 120°C Dry

Flash Point : 27°C

Specification Data

Preparation

For immersion service in marine environment "near white metal" blast cleaning in accordance with SSPC-SP10 or ISO 8501-1 Sa 2.5 is recommended.

For atmospheric service one of the following surface preparation methods can be used:

- Abrasive blast cleaning to standard SSPC-SP7 (brush-blast) or Swedish Standard Sa1.
- High pressure water washing with or without the addition of abrasive material (hydroblasting).
- Mechanical power tool cleaning to standard SSPC-SP3 or Swedish Standard CSt.3 or hand tool cleaning to standard SSPC-SP2 or Swedish Standard CSt 2.

It is important that the substrate is free from oil, grease, loose rust, dirt or other contaminants before painting.

Application Data

Mixing Ratio by Volume	Base : 4 parts Hardener : 1 part															
Mixing Advice	Prior to application, stir the A-component, add B-component and mix thoroughly to obtain a homogeneous mixture. Use a mixer for this, which is powered by air or a flameproof electromotor.															
Thinning	When mixed, the paint is ready for brush or airless spray application. If the paint is too thick, in cold weather for example, then add a small amount of Thinner 730 to obtain the suitable viscosity. The amount of thinner that may be added is dependent on the application conditions and methods. Over thinning will lead to poor results. Add thinner only after mixing of the components.															
Induction Time	Sipoxy HB Mastic 230 requires a 15 minutes induction time.															
Pot Life	4 hours at 20°C.															
Application Conditions	Application temperature: 5 - 50°C. The minimum temperature required for satisfactory drying is 10°C. The surface temperature must be at least 3°C above the dew point to prevent condensation. Never apply paint under adverse weather conditions. In confined spaces, constant purging of the air during application and drying is necessary to eliminate solvent vapours for reasons of health and safety as well as to assist drying.															
Application Methods & Details	<table border="0" style="width: 100%;"> <thead> <tr> <th></th> <th style="text-align: center;"><u>Airless spray</u></th> <th style="text-align: center;"><u>Conventional Spray</u></th> </tr> </thead> <tbody> <tr> <td>Recommended thinner :</td> <td style="text-align: center;">Type 730</td> <td style="text-align: center;">Type 730</td> </tr> <tr> <td>Thinner addition :</td> <td style="text-align: center;">0 - 20 vol.%</td> <td style="text-align: center;">0 - 20 vol.%</td> </tr> <tr> <td>Nozzle orifice :</td> <td style="text-align: center;">0.019" - 0.023"</td> <td style="text-align: center;">----</td> </tr> <tr> <td>Working pressure :</td> <td style="text-align: center;">140 - 160 bar</td> <td style="text-align: center;">----</td> </tr> </tbody> </table> <p>The recommended method of application is by airless spray. However brush or roller may also be used. The spray fan should be adjusted depending on the nature and the shape of the substrate to be painted, in order to ensure that over spray can be restricted to a minimum.</p>		<u>Airless spray</u>	<u>Conventional Spray</u>	Recommended thinner :	Type 730	Type 730	Thinner addition :	0 - 20 vol.%	0 - 20 vol.%	Nozzle orifice :	0.019" - 0.023"	----	Working pressure :	140 - 160 bar	----
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Cleaning of Equipment	Use Thinner 730.															

Storage Information

Pack Size	5 and 20 ltr. two component kits
Storage	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
Shelf Life	1 Year

Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SIPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.