

PRODUCT

INFORMATION



Steeltech®

Epoxy Mastic Prime or Finish

S3608 - Part A

S3698 - Part B (Activator)

DESCRIPTION :

Steeltech® Epoxy Mastic Prime or Finish is a two component, high solids, aluminum filled, polyamide bisphenol epoxy mastic coating formulated to provide a high performance over marginally prepared surfaces. **Must be used with part B Activator, S3698.** It may be used as a primer over marginally prepared steel, an intermediate coat over existing old coatings without lifting that coating, or a finish coat where high film build and a flat finish is desired

Steeltech® Epoxy Mastic Prime or Finish's high volume solids and special "wetting" characteristics enable it to cling to sharp edges, angles, welds, and penetrate pitted steel, providing extra corrosion protection in these hard-to-protect areas. Steeltech® Epoxy Mastic Prime or Finish is formulated to be lead and chromate free, and meets the requirements of USDA for incidental food contact.

USES :

Marine applications	Pipelines
Structural steel	Storage tanks
Machinery	Refineries

SIZES : S3608 - Part A & S3698 - Part B are available in gallons. Mix Ratio 1:1 (Activator/Base required to make the complete product.)

SURFACE PREPARATION :

Surface must be free of dirt, oil, grease, and rust. Ferrous Metal-Clean according to SSPC SP-2 or SP-3, hand or power tool cleaning. For optimum performance in severe environments, clean according to SSPC SP-6, commercial blast. Galvanizing-Prepare according to SP-2 or SP-3. Chromate pretreatments must be removed by blasting. Concrete-abrasive blast.

MIXING: (1:1 ratio) Mix base component and activator separately. Add activator to base component and mix until completely blended.

TECHNICAL DATA

Vehicle: Polyamide Epoxy
Components: Two (color: Aluminum)
Sheen: Flat
Flash Point: 102°F, PMCC, mixed
% Solids: By Volume: 80.0%
VOC Level: 1.43 lbs./gal. (180 gm/l max.)

Rec. Film: 5.0 - 10.0 mils dry film (approx. 120 – 240 sq. ft./gal. theoretical)

Mix Ratio: 1:1

Pot Life: 4 hours (@ 77°F/50%RH)

Shelf Life: 2 years

Induction Time: 30 Mins.

Application: Apply by airless spray or conventional spray. For brush and roller, thinning not recommended.

Drying Time @ 77°F (25°C): Set to touch 2 hrs. Dry to handle 6 hrs. Dry recoat min. 8 hrs; max. 6 months.

Topcoats: See systems recommendation on back page.

Thinning: Not Recommended

Cleanup: Techgard Reducer #3 < 80°F
Techgard Reducer #4 > 80°F

Limitations: Do not apply when surface temperature is less than 5°F above the dew point. Concrete must be cured for 28 days prior to painting. Do not apply when surface temperature is less than 35°F.

Heat Resistance: Up to 250°F dry heat 121°C)

FOR INDUSTRIAL USE ONLY

Technical Information Line:
1-800-BUY-PRAT (1-800-289-7728)

Website Address:
www.prattandlambert.com

PHYSICAL TEST DATA

- Adhesion (ASTM D4541) Passes 400 psi
- Salt Fog (ASTM B-117) Passes 4000 hours
- Taber Abrasion (ASTM D4060) 84mg Loss
(CS-17 wheel, 1000gm load, 1000 cycles)
- Condensation (ASTM D4585) Passes 6 months
- Perm Rating (ASTM D1653) .154 g/m²
- Chemical Resistance: (24 hr. Spot Test)
 - 50% Sodium Hydroxide Very Good
 - Motor Oil Excellent
 - Water Excellent
 - 10% HCl Good
 - 10% Acetic Acid Good
 - 10% Phosphoric Good

Application:

Airless: .019 - .023 orifice tip
2500 - 2800 psi
30:1 unit

Conventional: 55 - 65 psi atomization pressure
10 - 20 psi fluid pressure
Aircap; 67PB
Fluid Cap; 67

Brush/Roller: Thin with S3522 Epoxy
Brush/Roller Additive

RECOMMENDED SYSTEMS

STEEL, ALUMINUM, GALVANIZING:

(INTERIOR EXPOSURE- moderate environment)

- 1 or 2 coats Steeltech® Epoxy Mastic Prime or Finish at 5.0 - 10.0 mils DFT/coat

(EXTERIOR EXPOSURE- moderate environment)

- 1 or 2 coats Steeltech® Epoxy Mastic Prime or Finish at 5.0 - 10.0 mils DFT/coat

(and)

- 1 coat Techgard® HS Acrylic Urethane @ 4.5 - 9.0 mil dft

FERROUS METAL:

- 1 or 2 coats Steeltech® Epoxy Mastic Prime or Finish at 5.0 - 10.0 mils DFT/coat

(and)

- 1 coat Techgard® HS Acrylic Urethane @ 4.5 - 9.0 mil dft

CONCRETE, MASONRY, BLOCK:

- 1 or 2 coats Steeltech® Epoxy Mastic Prime or Finish at 5.0 - 10.0 mils DFT/coat

(and)

- 1 coat Techgard® HS Acrylic Urethane @ 4.5 - 9.0 mil dft

For Additional Recommended Coating Systems Contact Your Pratt & Lambert Sales Executive.

