

PRODUCT

INFORMATION



Techgard®

Hi-Build Epoxy Mastic

S5861 - White/Tint Base, S5864-Neutral,

S5815 - Gloss Activator

Description:

Techgard® Hi-Build Epoxy Mastic is a high solids, high build, two component, polyamide epoxy coating formulated to protect steel and concrete in industrial exposures. Its high build feature ensures adequate protection on welds, corners and sharp edges. It may be applied to marginally prepared steel surfaces. **Must be used with part B Gloss Activator, S5815.** This system may be used by itself or topcoated with Palgard® Epoxy or Techgard® High Solids Acrylic Urethane. Techgard® Hi-Build Epoxy Mastic meets the requirements of USDA. It provides excellent chemical and abrasion resistance while maintaining a low VOC content.

USES :

Fabrication shops	Offshore platforms
Structural steel	Storage tank exterior
Water treatment plants	Hand rails

USES :

Available in Gallons and Fives; (2 gallon kit or 10 gallon kit)

SURFACE PREPARATION :

Surface must be free of dirt, oil, grease, and rust. Ferrous Metal - must be primed prior to painting. Hand tool clean according to SSPC SP-2, and remove oil, grease and contaminants by solvent cleaning, SSPC-SP1. For better performance commercial blast clean per SSPC-SP6. Galvanizing - Clean according to SSPC-SP1 or if surface has been treated with chromate, brush blast per SSPC-SP-7. Rusty galvanized requires a minimum preparation of hand tool cleaning, SSPC-SP2. Minimum Aluminum: Remove oil, grease and contaminants with solvent clean per SSPC-SP1. Concrete: Refer to NACE 6/SSPC-SP13.

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

TINTING: Use 844 Colorants

TECHNICAL DATA

Vehicle:	Polyamide Epoxy
Components:	Two (colors: white/tint base, neutral)
Colorant:	844 Colorants
Sheen:	Semi-gloss
Flash Point:	60°F
% Solids:	By Volume: 72.0%
VOC Level:	1.96 lbs./gal. (239 gm/l) max. activated
Rec. Film Thickness:	7.0- 13.0 mils wet film (approx. 116 – 232 sq. ft./gal.)
Rec. Film Thickness:	5.0 - 10.0 mils dry film
Pot Life:	4 hours (@ 77°F/50%RH)
Shelf Life:	3 years
Induction Time:	30 Minutes
Application:	Apply by airless, spray, brush or roller.
Drying Time @ 77°F (25°C):	Set to touch 2 hrs. Tack free: 8 hours. Dry recoat min. 8 hrs; max. 3 months.
Thinning:	Not required
Cleanup:	Techgard Reducer #2
Limitations:	NOT INTENDED FOR IMMERSION SERVICE. Do not apply when surface temperature is less than 5°F (3°C) above the dew point. Primer required when painting ferrous metal in moderately corrosive environments. Do not apply to surface temperatures below 40°F. Concrete must be cured for 28 days prior to painting.
Heat Resistance:	Up to 250°F dry heat (121°C)

Technical Information Line:
FOR INDUSTRIAL USE ONLY

Website Address:
www.prattandlambert.com

APPLICATION

Airless:

Pump:	30:1
Pressure:	2800-3000 psi
Hose:	1/4" I.D.
Tip:	.017"-.023"
Filter:	60 Mesh
Reduction	up to 10% by volume (as needed)

Conventional:

Gun :	DeVilbiss MBC-510
Fluid Tip:	E
Air Nozzle:	704
Atomixation:	60-65 psi
Fluid Pressure:	10-20 psi
Reduction	up to 10% by volume (as needed)

Requires oil and moisture separators

Brush/Roller: Nylon/Polyester or Natural Bristle
Thinning not required

PHYSICAL TEST DATA

- Abrasion (ASTM D4060) (CS-17 wheel, 1000g load, 1000 cycles)
Result: 84 mg Loss
- Adhesion (ASTM D4541)
Result: 1,037 psi
- Flexibility (ASTM D522,) 180° ben, 3/4" manfrel
Result: Passes
- Direct Impact Resistance (ASTM D2794)
Result: 30 in. lb.
- Pencil Hardness (ASTM D3363)
Result: 3H
- Dry Heat Resistance (ASTM D2485)
Result: 280°F
- Exterior Durability
Method: 1 Year at 45° F South
Result: Excellent, Chalks
- Permeability (ASTM D1653)
Result: 0.154 mg
- Salt Fog (ASTM B117, 6,500 hours)
Result: Rating 10 per ASTM D610 for rusting
Rating 9 per ASTM D1654 for corrosion
- Slip Coefficient (ASTM A325) or ASTM A490 Bolts
Result: Class A, 0.36

RECOMMENDED SYSTEMS

FERROUS METAL, GALVANIZING, ALUMINUM: (mild environment)

INTERIOR EXPOSURE

- 1 Techgard® Hi-Build Epoxy Mastic at 5.0 - 10.0 mils DFT/coat

FERROUS METAL (moderate environment)

INTERIOR OR EXTERIOR EXPOSURE

- 1 coat: Techgard® Hi-Build Epoxy Mastic at 5.0 - 10.0 mils DFT/coat

(and)

- 1 or 2 coats Palgard Epoxy S3400 series at 1.5 - 2.0 mils DFT/coat

*note: epoxies chalk in exterior exposure

or

- 1 coat Techgard® High Solids Acrylic Urethane @ 3.0 - 6.0 mil dft

GALVANIZING, ALUMINUM: (moderate)

INTERIOR OR EXTERIOR EXPOSURE

- 1 coat: Techgard® Hi-Build Epoxy Mastic at 5.0 - 10.0 mils DFT/coat

*note: epoxies chalk in exterior exposure

MASONRY, BLOCK:

- 1 or 2 coats Enducryl Z8465 Heavy Duty Block Filler at recommended DFT/coat

(and)

- 1 Techgard® Hi-Build Epoxy Mastic at 5.0 - 10.0 mils DFT/coat

CONCRETE :

- 1 coat: Techgard® Hi-Build Epoxy Mastic at 5.0 - 10.0 mils DFT/coat

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