



EPIREZ®

TECHNICAL DATA

Epoxy Mastic Metal Primer

Primer for Structural Steel

Epoxy Mastic Metal primer is a high build epoxy primer specially formulated to provide good adhesion and protection to poorly prepared steel surfaces.

Epoxy Mastic Metal Primer provides an anti-corrosion protective barrier to structural steel surfaces subject to ultra-violet weathering, industrial pollution and precipitation. It can be applied over sound, aged coatings and has the ability to protect sharp edges, bolts, angles and other similar areas due to excellent high build characteristics.

In situations where only minimal surface preparation is allowable, **Epoxy Mastic Metal Primer** will provide the best protection under the circumstances.

Epoxy Mastic Metal Primer may be coated with various **EPIREZ** topcoats.

Areas of application

- Bridges
- Storage tank exteriors
- Chemical industry plants
- Marine installations
- Mining industry equipment
- Cranes
- Oil industry plants
- Silos
- Reservoirs
- Conveyors

Features

- High build per coat
- Minimal surface preparation
- Equal part mix ratio
- Excellent chemical resistance
- High abrasion resistance
- Excellent bond

General Properties

The information contained in this Technical Bulletin is as up to date and correct as possible as at the time of issue. The data provided should be used as a guide only as the performance of the product will vary depending on differing operating conditions and application methods.

The sale of any product described in this Technical Bulletin will be in accordance with ITW Polymers & Fluids Conditions Of Sale, a copy of which is available on request. To the extent permitted by law, ITW Polymers & Fluids excludes all other warranties in relation to this product.

Shelf Life	: 2 Years
Mixing Proportions by Volume	: Equal parts
Colour	: Aluminium Grey
Solids Content	: 83% v/v
Work Time	: 1½ hours at 25°C
Tack Free Time	: 6 hours at 25°C
Recoating Time	: 12-48 hours at 25°C
Cure Time	: 7 days at 25°C
Coverage (Theoretical)	: 6.6m ² /litre at 125 micron DFT
Weathering Resistance	: Excellent
Chemical Resistance	: Very good to all but strong alkalis
Solvent Resistance	: Very good
Abrasion Resistance	: Excellent
Temperature Resistance	: Up to 120°C dry heat

Estimating Data

1 litre Epoxy Mastic Metal Primer = 6.6m² @ 125 µm dft

Application Directions

Surface Preparation

Even though **Epoxy Mastic Metal Primer** has good bond to steel surfaces with minimal surface preparation, the following surface preparation techniques will result in the highest adhesion.

Steel

Abrasive blast clean to **AUSTRALIAN STANDARD AS1627:4 -2005** to a class 2 ½ near white metal finish. Apply **Epoxy Mastic Metal Primer** within 3 hours. For reinforcing steel, remove rust by abrasive blasting or power wire brush. For previously painted steel, whip-blast or abrade to remove rust. Solvent wash and sand all aged paint. A test patch should be applied if aged paint composition is unknown.

Galvanised Steel, Zincalume, Aluminium

Remove outside layer by whip-blast or power wire brush. Solvent degrease. Do not use detergents.

Surface preparation guidelines cannot cover all site or field contingencies and it is always recommended that an on-the-spot adhesion test be performed as part of the Standard Quality Assurance audit for the project.

Application

Thoroughly mix Hardener and Compound separately with a suitable mixing paddle fitted to a low speed (400 rpm) mechanical mixer. Combine Hardener and Compound and mechanically mix again until a uniform colour develops.

Epoxy Mastic Metal Primer can be thinned with up to 15% v/v **Epirez Epoxy Thinner**. It may be applied by airless spray with a pump ratio of at least 40:1 at 17.2 MPa and a 0.5 mm tip. Conventional spray or other equivalent equipment may be suitable.

The mixed product can be applied by roller in two coats to achieve the recommended dry film thickness. It may be directly brushed on to reinforcing steel and small areas using two coats.

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Top Coating

Epoxy Mastic Primer when applied is aluminium grey in colour, but while this may change to bronze upon exposure to sunlight, the aluminium colour reappears on weathering. Where a colour other than aluminium is required, topcoat with **Epirez** High Performance Coatings such as **Supatuff Heavy Duty Epoxy Coating**. Results may vary with weathering period between coats.

To obtain a highly reflective, uniform appearance over rough surfaces, such as a badly rusting tank, a thin second coat may be desirable for appearance only.

Cleaning

Tools and equipment may be cleaned before hardening commences by washing with **Epirez Clean Up Solvent**. Do not use for cleaning hands or mixing with product.

Limitations

Epirez Epoxy Mastic primer should not be applied under extreme weather conditions.

Storage and Shelf Life

Store in dry conditions between 10⁰C and 30⁰C, away from sources of heat and naked flames. Protect from frost. When stored in original sealed containers the minimum shelf life is 2 years.

Packaging

Epoxy Mastic Metal Primer is available in 1 litre packs. Each pack contains Hardener and Compound in correct proportions for use.

Ordering Information: 1 litre - #902154

Safety Precautions

Follow normal coating precautions. Contents are flammable. Keep away from fire or naked flame. Keep contents away from children. If swallowed, call a Doctor or Poisons Information Centre. When mixing or using avoid skin contact or breathing of vapours. If splashed on skin, wash with soapy water. During applications, wear protective clothing and where necessary, goggles and mask, or respirator. Provide adequate fresh air ventilation.

TDG Code: Hardener UN 2924
Compound - UN 1993

Note

The figures quoted for work time, tack free time, recoat time, cure time and coverage are not definitive. They are dependent on job site conditions and will vary accordingly. In all cases we endeavour to provide typical figures for use as a guide.

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