

## STEELMASTIC 168

### HIGH BUILD ALUMINIUM MODIFIED EPOXY MASTIC

#### DESCRIPTION

Steelmastic 168 is a surface tolerant, self-priming, direct-to-rust, high build Industrial Maintenance epoxy Coating. Its superior adhesion properties allow it to be applied over marginally prepared rusted steel and old existing coatings. Steelmastic 168 exhibits an affinity towards covering and protecting edges and corners where most coatings have a tendency to pull away. Its high build formulation allows it to obtain a high performance barrier up to 625 microns thick in a one-coat application.

#### APPLICATIONS

Excellent maintenance coating for bridges, pipes, fences, machinery, structural steel or tank exteriors, especially when corrosion of the steel has taken place. Ideal for offshore structures, marine, piping and exposed steel structures. May be applied over most old coatings, inorganic or organic zinc rich primers where optimal performance is desired. Not recommended for immersion in acids, alkalis and solvents.

#### ADVANTAGES

- U.S.D.A. acceptable for incidental contact in food processing and packaging plants
- Excellent water, chemical resistance, and excellent corrosion protection against a wide variety of substances
- Minimum number of coats required
- Proven field performance
- Minimum substrate preparation
- High film build
- Minimal VOC content

#### TECHNICAL DETAILS

##### CHEMICAL RESISTANCE

Exposure	Immersion	Slash/Spill	Fumes
Acids	Fail	Fair	Very good
Alkalies	Fail	Good	Excellent
Solvents	Fail	Good	Excellent
Salt water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

##### TEMPERATURE RESISTANCE

Continuous:	82°C
Non-Continuous:	121°C
Volume Solids:	85%
Weight Solids:	90%
Flash Point:	27°C
Pot Life:	30 – 60 min
Thinner Reduction:	30% max
Colour:	Aluminium
VOC:	150g/L
Coverage:	40m <sup>2</sup> /kit
Drying Time	
Touch:	8-10 hours
Recoat Time:	24 hours
Full cure:	7 days

#### DIRECTIONS

Steel surfaces must be clean and free from oil, grease, moisture and loose matter. Clean by using a degreaser and rust cleaner with the use of a power tool cleaning been preferred in order to remove all loose rust or mill scale. For severe environments, dry abrasive blast in order to remove loose rust, mill scale, paint and other foreign matter from the surface. Remove all dust. Galvanised surfaces must be clean and free from all oil, grease, moisture and loose matter.

For white rust or weathered (red-oxide rusting) galvanized steel, prepare by hand or power tool cleaning in order to remove any loose rust or scale. Remove any dust. Apply Steelmastic 168. Do not apply over moist or damp surfaces.

Apply Steelmastic 168 only over clean, sound coatings. If the existing coating is brittle, eroded, or under film rusting exists, or if less than 75% of the film is intact, the coating must be totally removed by brush-blasting or other specified method. For sound existing coatings that are greater than 75% intact, remove any oil, grease, dirt or foreign matter. Remove any remaining gloss or loose existing coating by hand or power tool cleaning. Spot prime bare areas with Steelmastic 168 and allow to dry. Apply Steelmastic 168 over the entire existing coating and spot-primed areas per label instructions. Do not apply over moist or damp surfaces. Clean all tools and equipment with Solidkote 505 Epoxy Thinners.

#### MIXING METHOD

Mix the Steelmastic 168 resin and hardener separately with a mechanical mixer before combining the two components and again power mixing for a period of 3 minutes. Avoid mixing at too high a speed to ensure no bubble formation. Thin down the mixed product with Steelmastic 168 diluent as supplied or alternatively for a high build film apply the mixed product alone. Up to 30% thinning is allowable.

#### APPLICATION PROCEDURES

Steelmastic 168 may be applied by brush and/or medium nap phenolic core roller working the product into the surface irregularities. Alternatively Steelmastic 168 may be spray applied with suitable spray equipment such as Binks, DeVilbiss and Graco. Conventional pressure pot equipment may also be used but must be tested to access suitability. Airless spray methods may be used and calibrated to a 1:2 (Part B : Part A) volume ratio.

#### MAXIMUM RECOAT TIME

30 Days – Epoxies and waterbased

90 Days – Polyurethane

If maximum recoat time has been exceeded the surface must be abraded by sanding or sweep blasting prior to the application of any additional coats.

#### VENTILATION AND SAFETY

When used as a tank lining or in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. Fresh air respirators or solvent respirators must be worn by application staff. Wear protective clothing, gloves and goggles at all times.

#### CLEANING

Clean all tools and equipment with Solidkote 505 Epoxy Thinners.

#### SHELF LIFE

36 Months minimum when stored at 25°C

#### Gauteng

#### Kwa-Zulu Natal

#### Western Cape