

# INERTA MASTIC Epoxy Coating

<b>PAINT TYPE</b>	INERTA MASTIC is a two-pack, low-solvent content epoxy reactive paint.
<b>USAGE</b>	To repair of existing coating on steel in Coating Systems K41, K46, K56 and K60 when environmental conditions do not allow blast-cleaning, and for brush application when a dense coat is required in a single operation. The paint is also suitable for application in engineering shops.
<b>SPECIAL PROPERTIES</b>	<p>Good adhesion to wire-brushed steel. Good resistance to chemicals and water. Provides good adhesion for top coats.</p> <p>For the product there is also available a WINTER-hardener INERTA MASTIC WINTER HARDENER, which is used when the painting is done in temperatures below +10°C.</p> <p>Also INERTA MASTIC-01 HARDENER can be used in order to have a longer overcoating interval. Please see the technical data sheet of INERTA MASTIC-01 HARDENER for detailed information.</p>

<b>TECHNICAL DATA</b>			
<b>Mixing ratio</b>	Base (Comp. A):	2 parts by volume	
	Hardener (Comp. B):	1 part by volume	
<b>Pot life, +23 °C</b>	pot life using <u>standard hardener</u>	pot life using <u>WINTER-hardener</u>	
	2 h	2 h	
<b>Solids</b>	80 ±2% by volume standard hardener INERTA MASTIC HARDENER		
	75 ±2% by volume WINTER-hardener INERTA MASTIC WINTER HARDENER.		
<b>Total mass of solids</b>	abt. 1200 g/l		
<b>Volatile organic compound (VOC)</b>	abt. 210 g/l		
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
	120	150	6,7 standard hardener
	120	160	6,3 WINTER-hardener
	160	200	5,0 standard hardener
	160	213	4,7 WINTER-hardener

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

**Practical spreading rate** The values depend on the application technique, surface conditions, overspray, etc.

**Drying time at +23°C / 50% RH**

standard hardener / WINTER hardener

- dust free (ISO 9117-3:2010) 4 h / 3 h  
- touch dry (ISO 9117-5:2012) 6 h / 5 h

**Overcoating intervals**

The lowest usability temperature of the top coat has to be checked from the appropriate Data sheet.

\* Maximum overcoating interval without roughening.

**Overcoating intervals using the STANDARD HARDENER:**

surface temperature	by itself		by TEKNOPLAST top coats, INERTA 50 or TEKNOCHLOR 90		by TEKNODUR 0050		by other TEKNODUR top coats	
	min.	max. *	min.	max. *	min.	max. *	min.	max. *
+10°C	1 d	7 d	1 d	7 d	1 d	7 d	1 d	7 d
+23°C	6 h	after 2 months	6 h	7 d	6 h	after 2 months	6 h	7 d

**Overcoating intervals using the WINTER HARDENER:**

surface temperature	by itself		by TEKNOPLAST top coats, INERTA 50 or TEKNOCHLOR 90		by TEKNODUR 0050		by other TEKNODUR top coats	
	min.	max. *	min.	max. *	min.	max. *	min.	max. *
-5°C	2 d	14 d						
0°C	28 h	7 d						
+10°C	16 h	7 d	16 h	7 d	20 h	7 d	20 h	7 d
+23°C	4 h	after 2 months	4 h	7 d	6 h	after 2 months	6 h	7 d

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

**Finish**

Semi-matt

**Colours**

Aluminium and white, other colours by order.

**SAFETY MARKINGS**

See Safety Data Sheet.

**PTO**

**DIRECTION FOR USE****Surface preparation**

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows:

**STEEL SURFACES:** Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

**ZINC SURFACES:** Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos.

If it is needed to paint zinc surfaces at low temperatures, we recommend using INERTA MASTIC WINTER-01 HARDENER as a hardener.

**OLD PAINTED SURFACES SUITABLE FOR OVERCOATING:** Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating. From the bare steel surfaces the rust is removed to preparation grade St 2 (ISO 8501-1).

An alternative method to dry cleaning is high-pressure water jetting with a pressure of over 70 MPa. This water-jetting can be used on intact, well adhering paint coats and/or on steel. After the water jetting the intact paint coats must have a rough surface structure. The cleanliness of the steel surface must be Wa 2 (ISO 8501-4:2006) or according to the specification. A flash-rust degree of maximum M (ISO 8501-4:2006) is allowed before application.

The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.

**Prefabrication primer**

KORRO E Epoxy, KORRO SE Zinc Epoxy and KORRO SS Zinc Silicate Prefabrication Primers can be used, when required.

**Mixing of the components**

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

**Application conditions**

The surface to be painted must be dry and the relative air humidity below 80%. When painting with the standard hardener the temperature of the ambient air, the surface to be painted and the paint shall be above +10°C during the application and drying period.

Additionally the temperature of the surface to be painted and the paint must be at least 3°C above the dew point of the ambient air.

When using INERTA MASTIC WINTER HARDENER the temperature of the ambient air and the surface to be painted shall be over -5°C. The temperature of the paint during mixing and application shall be above +15°C. The surface to be painted must be free from ice.

**Application**

Apply by brush or roller. Airless spraying is possible for painting blast-cleaned steel, use nozzle size 0.015 - 0.021".

Clean the equipment immediately after use with TEKNOSOLV 9506.

The paint can also be used alone without a top coat.

**ADDITIONAL INFORMATION**

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).



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