

PRODUCT DATA SHEET

Product Code 7551

MARIPOXY 850

HP HS EPOXY MASTIC COATING

A Surface Tolerant Epoxy

Description	Maripoxy HPHS Epoxy Mastic is a very low VOC, two component high build, high solids and High Performance surface tolerant epoxy coating. It is cured with Polyamide adduct, on curing it forms extremely hard and tough coating. It has excellent wetting property thereby making it an ideal surface tolerant epoxy coating. A faster drying version also available suitable for application at low temperatures in winters.
Uses	A surface tolerant paint system which can be used as- <u>Primer, Intermediate Coat or finishing coat where low VOC and high film build is required.</u> It is suitable for use at both new construction and in maintenance offering excellent corrosion resistance. May be used directly on cured zinc silicate. It can be over coated with Polyurethane coatings to get excellent outdoor durability.

PHYSICAL PROPERTIES

Colour	Grey, MIO, Aluminium and other selected range of colours.
Finish	Semi Glossy, Smooth and Free from any surface defects
Density	1.44 Kg/Liter
Volume Solid %	85±2
Theoretical Coverage	About 8.5 Sq. Meter / Liter at 100 Micron DFT(without loss factor)
Flash Point	28 °C
Touch Dry	2.0 Hours at 30 Degree C
Hard Dry	Overnight
Full Cure	7-10 days depending upon atmospheric temperature
VOC	180 ± 3 Grams /Liter
Shelf Life	2 Years when stored in shade below 35 Degree Centigrade.
Service Temperature	120° C.

APPLICATION DETAILS

Mixing Ratio - Base: Hardener	4:1 by Volume
Application Method	Airless Spray, Brush and Roller.
Pot Life	1.0 Hour/ 30°C (Pot Life I decreases with increase in room Temperature)
Nozzle Size	0.017"-0.025"
Pressure by Airless Spray	240-250 Bar
Dry Film Thickness (DFT)	100- 200 Microns (viscosity can be adjusted to achieve required DFT but thinning not to exceed more than 5% of thinner no 055)
Wet Film Thickness (WFT)	120- 240 Microns
Over coating Interval	Minimum – 5 Hours at 30 Deg. C and Maximum Six Weeks.

MARIPOXY 850 - HIGH SOLID HIGH BUILD EPOXY MASTIC COATINGS

SURFACE PREPARATION	<p>New steel: Surface should be free from all dust, dirt, oil and grease etc. Salts and other contaminants can be removed by high pressure fresh water wash. Substrate to be blasted to Sa 2 ½ or ST 2-3. A surface profile of 50-75 microns (2-3 mils) is recommended.</p> <p>Maintenance of old painted structure: Clean already painted surface with detergent to remove dust, dirt, oil and grease etc. Salts and other contaminants can be removed by high pressure fresh water wash. Remove all rust and loose material preferably by dry abrasive blasting. Minor areas may be power tool cleaned.</p> <p>Concrete: Surface impurities to be removed by emulsion cleaning followed by high Pressure fresh water hosing. Loose matters can be removed by abrasive blasting or by wire brushing. Use Epoxy sealer to fill the pores of surface before applying Epoxy Mastic</p>
APPLICATION CONDITIONS	Avoid use of paint when atmospheric temperature is below 5 Deg. C. Temperature of Paint to be sprayed need to be maintained above 15 degree centigrade.
PREVIOUS COAT	Can be used Direct on Metal or on Maripoxy HB ZP Primer, Zinc Silicate, Epoxy Zinc Primer
SUBSEQUENT COAT	Marithane PU Topcoat
CAUTION	Epoxy Paints are prone to Chalking and Fading on direct exposure to Sunlight. It is recommended to overcoat Epoxy primer/Mid Coat with PU Paint to get good outdoor durability and maintain aesthetics.
SAFETY	Maripoxy Epoxy Paints are solvent based products, user need to take safety precaution which are applicable to all the petroleum based inflammable products. Painting should be done in open and ventilated place. Use Foam based fire extinguishers in case of fire. Keep it away from direct fire/ flame and store the product under the shade below 35 degree Centigrade.

Issued By Marigold Paints Private Limited,

The Product is for Industrial use only. Product data given here *is correct to the best of our knowledge but their accuracy may vary depending upon the quality of the substrate, application parameters and atmospheric conditions affecting the performance of the product. Therefore the users* are advised to make their own tests to determine the suitability of products for their own purposes under present conditions.

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