

COATING DATA

DESCRIPTION:

A high build surface-tolerant semi-gloss epoxy coating formulated for excellent adhesion to clean steel, rusted steel, weathered galvanized steel, wood, concrete, and most existing cured coatings. Two coats of Induramastic 85 applied to hand tool and/or power tool cleaned rusted steel, will outperform many conventional coating systems that routinely require costly blast cleaning. Available in a variety of colors.

PERFORMANCE:

SYSTEM: One coat Induramastic 85 at 6.0 mils Dry Film Thickness

TEST	METHOD/CONDITIONS	SUBSTRATE	RESULTS
ADHESION	ASTM D 3359 Method B	Hot Rolled Steel Rusty Steel Aged Alkyd Coating	5 Rating, No Failure 5 Rating, No Failure No Wrinkling or lifting, 5 Rating, No Failure
SOLVENT RESISTANT	Methyl Ethyl Ketone		75 Double Rubs. No Softening
IMPACT RESISTANT	ASTM D 2794	Hot Rolled Steel	Pass 90 in./lbs.
HARDNESS	ASTM D 336		4H
SALT SPRAY	ASTM B 117 (Scribed)		1,000 Hours, No effect < 1/16" Undercut @ Scribe

USE:

This product is especially designed to provide long-term protection to unpainted or previously painted steel without requiring costly sandblasting. It may be used to extend the life of structures previously painted with lead and chromate containing coatings and thus avoid the generation of toxic by-products that sandblasting would entail. This product is ideal for protecting and extending the life of metal buildings, fences, piping, process equipment, tanks, bridges and structural steel.

RECOATABILITY:

Induramastic 85 may be used as a single coat, recoated with itself or topcoated with Induron Perma-Clean II Epoxy, Induron Armorguard Epoxy, Induron Indurethane, or Induron Aquanaut© finishes.

LIMITATIONS:

Not recommended for dry service temperatures exceeding 200°F, or immersion service at temperatures exceeding 120°F. Do not use when substrate temperature is below 45°F.

SURFACE PREPARATION:

Corroded Steel (Non-immersion)—Remove loose rust scale and poorly adhered old paint using water blast and/or hand and power tools. Remove oil and grease per SSPC-SP 1 Solvent Cleaning. For severe industrial exposures, a brush off blast cleaning is recommended. **Weathered Galvanized Steel and Aluminum (Non-immersion)**— Remove oil and grease per SSPC-SP 1 Solvent Cleaning. **Old Paint**— Remove all peeling and poorly adhered paint using water blast and/or hand and power tools. Remove oil and grease per SSPC-SP 1 Solvent Cleaning. A test patch is recommended over existing coatings.

COVERAGE:

Theoretical—1,171 ft² per gallon at 1.0 mil dry.

DRY FILM THICKNESS:

3.0 to 7.0 mils per coat.

WET FILM THICKNESS:

4.1 to 9.6 mils.

APPLICATION DATA

BLEND RATIO:

One part Induramastic 85 Part A to one part by volume Induramastic 85 Part B. Blend components thoroughly using power agitation. Allow components to stand 15 minutes prior to beginning application.

POT LIFE:

Three hours at 90°F.

APPLICATION:

Airless Spray—Use 0.015-0.017 tip; 30:1 Pump ratio at 80-100 psi operating air pressure. **Conventional Spray**—Follow equipment manufacturer's instructions for the application of epoxy coatings. **Roll**—Use lambswool cover. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

THINNING:

For airless spray applications, use unthinned. If required, thin up to 10% with Induron K-1012 Industrial Thinner.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 45°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid condensation occurring on wet paint

DRY TIME:

TO HANDLE—18 hours at 80°F

TO RECOAT—48 hours or second day at 45°F to 55°F; 24 hours or overnight above 55°F. **Note:** Lower temperature, higher film build, and/or poor ventilation will retard dry time.

PHYSICAL DATA:

ALL PURPOSE TAN

VOLUME SOLIDS: 73% ± 1%

SOLIDS BY WEIGHT: 86% ± 1%

WEIGHT PER GALLON: 13.5 ± 0.4 lbs/gallon (mixed)

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.0 lbs/gallon; < 240 grams/liter

Mixed thinned 10% - < 2.4 lbs/gallon; < 290 grams/liter

COLORS

VOLUME SOLIDS: 75% ± 1%

SOLIDS BY WEIGHT: 85% ± 1%

WEIGHT PER GALLON: 11.3 ± 0.5 lbs/gallon (mixed)

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.0 lbs/gallon; < 240 grams/liter

Mixed thinned 10% - < 2.4 lbs/gallon; < 290 grams/liter

SAFETY DATA:

See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.