

COATING DATA

DESCRIPTION:

Induramastic 85 is a high build, surface-tolerant epoxy formulated for excellent adhesion to clean steel, rusted steel, weathered galvanizing, wood, concrete, and most existing cured coatings. It is ideal for overcoating projects. Two coats of Induramastic 85 applied to hand tool or power tool cleaned rusted steel, will outperform many conventional coating systems that routinely require costly blast cleaning.

USE:

This product is especially designed to provide long-term protection to unpainted or previously painted steel without requiring 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 produce. 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 AquaClean, Perma-Clean II, Indurethane, PermaGloss, Indurlux and 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 high pressure water blasting and/or hand and power tools. Remove oil and grease per SSPC-SP 1 Solvent Cleaning. For corrosive exposures, SSPC-SP 7/NACE 4 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 high pressure water blasting and/or SSPC-SP 2/SSPC-SP 3 hand and power tool cleaning. 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 Induramastic 85 Part B by volume. Blend components thoroughly using power agitation. Allow components to stand 15 minutes prior to beginning application.

POT LIFE:

6 hours at 90°F, 12 hours @70°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 dew point for a period of at least two hours after application to avoid condensation occurring on wet paint

DRY TIME:

TO HANDLE—12 hours @ 90F, 24 hours @ 70F, 48 hours @ 50F.

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.

Note: E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 technical data sheet for more information.

PHYSICAL DATA:

COLORS: TAN AND OFF-WHITE

VOLUME SOLIDS: 73% ± 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

SAFETY DATA:

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