

## COATING DATA

### DESCRIPTION:

Induramastic AL is a high build, surface-tolerant, aluminum filled epoxy coating specially formulated for outstanding adhesion to properly prepared clean steel, rusted steel, weathered galvanized steel, wood, concrete, and most existing cured coatings. Its special pigments form a dense film that greatly improves resistance to atmospheric corrosive elements.

### USE:

This product is especially designed to provide long-term protection to unpainted or previously painted substrates without requiring costly sandblasting or extensive surface preparation. It may be used to extend the life of structures previously painted with lead and chromate containing coatings, avoiding the generation of toxic by-products that abrasive blast cleaning would produce. This product is ideal for protecting and extending the life of aged galvanized towers, metal buildings, fences, piping, process equipment, tanks, bridges and structural steel.

### RECOATABILITY:

Induramastic AL may be used as a single coat, recoated with itself or topcoated with Induron Indurasil 80, AquaClean, Perma-Clean II, Indurethane, Permastic Polyurethane, Perma-Gloss Fluorourethane, Indurlux 7600 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 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—1,283 ft<sup>2</sup> per gallon at 1.0 mil dry.

### DRY FILM THICKNESS:

3.0 to 7.0 mils per coat.

### WET FILM THICKNESS:

3.8 to 8.8 mils.

## APPLICATION DATA

### BLEND RATIO:

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

### POT LIFE:

Three hours at 90°F, 5 hours @ 70F, 8 hours @50F.

### APPLICATION:

**Airless Spray**—Use 0.015-0.019 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 a high quality, synthetic cover with a solvent resistant core. Additional coats may be required to achieve desired film thickness. **Brush**—Use a high quality, 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:

VOLUME SOLIDS: 80% ± 1%

SOLIDS BY WEIGHT: 89% ± 1%

WEIGHT PER GALLON: 12.75 ± 0.4 lbs/gallon (mixed)

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 1.35 lbs./gallon; < 165 grams/liter

Mixed thinned 10% - < 1.8 lbs./gallon; < 220 grams/liter

HAZARDOUS AIR POLLUTANTS (HAPS):

Mixed unthinned - 0.074 lbs./gallon solids;

Mixed thinned 10% - 0.074 lbs./gallon solids

COLOR: Low sheen metallic gray.

### SAFETY DATA:

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