HIGH BUILD EPOXY MASTIC 100

K-S373 Bases
K-S3715 Hardener

This high-solids, fast-drying formula with less than 100 g/l ensures protection of sharp edges, corners and welds. It is chemical and abrasion resistant to allow for direct application on marginally prepared steel surfaces.

- ✓ High solids, high build
- ✓ Chemical and abrasion resistant
- ✓ Provides adequate protection of sharp edges, corners, and welds
- ✓ Meets or exceeds the performance requirements of SSPC Paint Spec 22
- ✓ Suitable for use in USDA inspected facilities
- ✓ Interior/Exterior use

INDUSTRIAL USE ONLY!
AS OF 01/01/17 COMPLIES WITH:

- ☑ OTC
- ☑ EC
- ☑ SCAQMD
- ☑ CARB
- ☑ LADCO
- ☑ UTAH

krylonindustrial.com
1-800-247-3266

Revised January 2017

RECOMMENDED USES

Use this product on interior and exterior surfaces of steel, concrete and metal.

SPECIFICATIONS

STEEL, CONCRETE, METAL:
2 coats Krylon® Industrial High Build Epoxy Mastic 100

CONCRETE BLOCK:
I coat Krylon® Industrial Acrylic Block Filler
2 coats Krylon® Industrial High Build Epoxy Mastic 100

SURFACE PREPARATION

WARNING! Removal of old paint by sanding, scraping or other means may generate dust or fumes that contain lead. Exposure to lead dust or fumes may cause brain damage or other adverse health effects, especially in children or pregnant women. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as a properly fitted respirator (NIOSH approved) and proper containment and clean-up. For more information, call the National Lead Information Center at 1-800-424-LEAD (in U.S.) or contact your local health authority.

Surface must be clean, dry and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign materials to ensure adequate adhesion.
Do not use hydrocarbon solvents tor cleanlng.

STEEL:
Minimum surface preparation is Hand Tool Clean SSPC-SP2. Remove all oil and grease from surface per SSPC-SPI. For better performance, use Commercial Blast Cleaning per SSPC-SP6/ NACE 3. Primer recommended for best performance.

METAL
Surface should be exterior weathered for 6 months prior to painting. Remove all oil and grease per SSPC-SPI. Rusty galvanizing requires a minimum of Hand Tool Cleaning per SSPC-SP2. Prime cleaned area the same day with Krylon Industrial Iron Guard Primer.

CONCRETE:
For surface preparation, refer to NACE 6/SSPC-SP13 or ICRI 03732, CSP 1-3. Surface should be thoroughly clean and dry. Surface temperatures must be at least 55°F before filling. If required for a smoother finish, use Krylon® Industrial Acrylic Block Filler. Filler must be thoroughly dry before topcoating per label instructions. Weathered masonry and soft or porous cement board must be brush blasted or power tool cleaned to remove loosely adhering contamination and to get a hard, firm surface. Apply one coat Krylon® Industrial Masonry Surface Conditioner, per label instructions.

PREVIOUSLY PAINTED SURFACES:
If in sound condition, clean the surface of all foreign material. Smooth, hard or glossy coatings and surfaces should be dulled by abrading the surface. Apply a test area, allowing paint to dry one week before testing adhesion. If adhesion is poor, additional abrasion of the surface and/ or removal of the previous coating may be necessary. Retest surface for adhesion. If paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface.

CLEAN UP

Clean spills, spatters and tools immediately with Xylene. Follow manufacturer's safety recommendations when using any solvent.

TECHNICAL DATA

Vehicle	Polyamide Epoxy		
Finish	Semi-Gloss (30-50 units @ 60°F)		
Flash Point	61°F, PMCC, mixed		
Volume Solids	73 ± 2% (mixed)		
Weight Solids	83 ± 2% (mixed)		
Weight Gallon	13 ± 2% (mixed)		
VOC (Calculated)	79 g/L; .66 lb/gal as per 40 CFR 59.406		
Mix Ratio	1:1 by volume of Part A to Part B (S3715)		
Rec. Film Thickness	Wet mils: 7.0 - 13.5		
	Dry mils: 5.0 - 10.0		
Spread Rate	116-232 ft2/gal		
Application	Apply by airless spray, brush or roller		
Drying Schedule	@ 50% RH @ 7.0 mils wet:		
	@ 40°F	@ 77°F	@ 100°F
To touch	4-5 hours	2 hours	1-5 hours
To handle	48 hours	8 hours	4.5 hours
To recoat			
min	48 hours	8 hours	4.5 hours
max	1 year	1 year	1 year
To cure	10 days	7 days	4 days
	Note: If maximum recoat time is exceeded, abrade surface		
	before recoating. Dry time is temperature and humidity dependent.		
Pot Life	10 hours	4 hours	2 hours
Sweat-In Time	30 min	30 min	30 min
Reduction	Xylene		
Clean Up	Xylene		
Tinting	Tint Part A with 844 Colorants.		
	Mix minimum 5 minutes on mechanical shaker		
Sizes	1 gallon		

APPLICATION

Temperature	(air, surface and material) 40°F min. 140°F max. at least 5°F above dew point
Relative humidity	85% maximum
Reducer/Clean-up	Xylene
Airless Spray	
Unit	30:1 pump
Pressure	2800–3000 psi
Hose	1/4" ID
Tip	.017"–.023"
Filter	60 mesh
Reduction	As needed up to 10% by volume
Conventional Spray	
Gun	DeVilbiss MBC-510 (or equivalent)
Nozzle/Tip	704/E
Atomization Pressure	60–65 psi
Fluid Pressure	10–20 psi
Reduction	As needed up to 10% by volume
	Requires oil and moisture separators
Brush	Nylon/polyester or Natural Bristle
Reduction	Not recommended
Roller	3/8" woven with solvent-resistant core
Reduction	Not recommended

PHYSICAL TEST DATA

System Tested	
Substrate	Steel
Surface Preparation	SSPC-SP10
Finish	1 coat High Build Epoxy Mastic @ 6.0 mils DFT
Abrasion Resistance	
ASTM D4060, CS17 wheel, 1 kg load	84 mg loss @ 1000 cycles, I kg load
Adhesion	
ASTM 04541	1,037 psi
Direct Impact Resistance	D2494 > 30 in-lb
Dry Heat Resistance	ASTM D2485 250°F
Exterior Durability	
I year at 45° South	Excellent, chalks
Flexibility	ASTM 0522, 180° bend, 3/4" mandrel
	Passes
Pencil Hardness	\ASTM D3363 3H
Water Vapor Permeance	ASTM 01653, Method 8
	1.16 grains/day