

ROCK MASTIC 477D

Epoxy – based paint

477D

Product description

ROCK MASTIC 477D is a self-priming, high-build, pure epoxy paint providing both abrasion and corrosion resistance.

Designed For:

ROCK MASTIC 477D is recommended as a high-build primer, intermediate and/or self-primed finish for high performance, heavyduty coating systems. ROCK MASTIC 477D is fast curing and therefore suitable when high productivity is key - such as in open yard application and required aesthetic object

Product Features: -

Heavy duty abrasion resistant coating.

Overcoatable by wide range of epoxy and polyurethane coating – Low VOC

Applicable by standard heavy duty airless spray equipment in a wide range of film thickness

Technical characteristics

Shelf life: 36 months	Density: 1.5 ± 0.2 g/ml	Theoretical spreading rate: 5.33m ² /l at 150 µm
Colour: RAL 7032	Volume solid 80 ± 2 %	Texture: semi matt

Pre-treatment

Surface preparation

Blast cleaning the performance of this paint will depend on the degree of surface preparation. All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.

The surfaces shall be blast-cleaned to min. st 2, preferably Sa 2½ (ISO 8501-1:2007). The surface profile and the anchor pattern shall be between 40 µm and 70 µm. The abrasives shall be free from oil, grease, moisture, chloride contamination etc.

Power tool Cleaning

The performance of this paint will depend on the degree of surface preparation. Surfaces should be treated in accordance with ISO 8504:2000.

The surface shall be cleaned by high pressure steam/detergent cleaning to remove dirt, grease and/or salt deposits in accordance with SSPC SP1. Power-tool cleaning to min. St 2, preferably St 3 (ISO 8501-1:2007).

Care shall be taken to ensure that power-tool cleaning does not polish the steel surface. If the surface being prepared lies adjacent to a coated surface, the power tool cleaning shall overlap the coated surface by at least 25 mm and the coated surface shall be feathered

Coated substrates

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system. When recoating aged coated substrates, damaged areas must be removed back to a firm edge.

Light abrade or sweep-blast the surface in order to provide a physical key for adhesion. When recoating zinc primed products, ensure the primer has been fully cured.

Zinc salts products shall be removed by high pressure fresh water cleaning. Contact your local ROCK COATING office for more information

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules.
The products are suitable for professional use only.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

ROCK MASTIC 477D

477D

Application.

	Mixing ratio	Stir well before use. compound A 80 (vol.) D477 Compound B 20 (vol.) 246 - 477
		Ideal application conditions for two-component EPOXY products: 20°C and relative air humidity below 80%. Application not possible in temperatures below 10°C
	Spray guns	Application method
		Tools Thinning max Volume applications parameters
		Airless : 5% nozzle pressure 250 spray Nozzle orifice 0.021-0.028
		Brush: 5% multicoated are required to achieve the thickness
	No of coats	Roller: 5% multicoated are required to achieve the thickness
		Thinner ROCK COATING Thinner 845, 700, 721
		Cleaner ROCK COATING Tool Cleaner 966
	Drying time	

Pot life:-

Product temperatures	15°C	20°C	30°C	40°C
Pot life for curing 246	120min	80min	60min	25min
Pot life for curing 477	60min	45min	20min	10min

TYPICAL PAINT SYSTEM

A typical system for this product is shown below and should be taken for guidance only

ROCK MASTIC 477D	150 µm
ROCK THAN 333	80 µm

For further information about full system specification consult your **ROCK COATING** supplier

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules.
The products are suitable for professional use only.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

ROCK MASTIC 477D

477D

APPLICATION CONDITIONS

The temperature of the substrate should be at least 3°C above the dew point. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life.

Ambient temperature

25°C [77°F]

35°C [95°F]

Base	36 month	24 month
Curing agent	12 month	10 month

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators. As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer.

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

Please refer to the EU Material Safety Data Sheet for product labelling as required by Directive 1999/45/EC and the respective national rules.
The products are suitable for professional use only.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.