

Rock Mastic AL

Epoxy – based paint

C 222

Product description.

Epoxy based paint with good adhesion properties for used over primer coat on the substrates (steel, aluminium, galvanised steel as per quality standard of the automotive industry). epoxy based paint is used for passive protection over the anticorrosive primer.

Designed For.

General: Primarily designed for maintenance and repair.

Marine: Outside hulls, exterior and interior areas.

Protective: Recommended for offshore environments, refineries, power plants, bridges, buildings, mining equipment and general structural steel.

Technical characteristics

Shelf life: 36 months	Density: 1.35 ± 0.2 g/ml	Theoretical spreading rate: $6.1 \text{ m}^2/\text{l}$ at $120 \mu\text{m}$
Colour: silver	Volume solid 80 ± 2 %	Texture: semi-gloss

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. Sa 2, preferably Sa 2½ (ISO 8501-1:2007). The surface profile and the anchor pattern shall be between $40 \mu\text{m}$ and $70 \mu\text{m}$. 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.

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Application:-

 Mixing ratio	Stir well before use. compound A 100 (vol.) Compound B 20 (vol.) Ideal application conditions for two-component EPOXY products: 20°C and a relative air humidity below 80%. Application not possible in temperatures below 10°C
 Sprayguns	Airless: 180-150 Bar nozzle size 0.48 - 0.66 mm with thinner 5% Brush: Multicoat are required to achieve the specified dry film thickness. Volume of thinner: 0 - 10% Roller: not recommended

THEORETICAL SPREADING RATE TSR

	DFT µm	WFT µm	TSR
RANGE	100 - 350	125 - 400	2 - 8 M2
RECOMMENDED	120	150	6.1

DRYING AND RECOATING TIMES

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat
10.°C	8 Hours	14 Hours	10 Days	24 Hours
25 °C	3 Hours	10 Hours	7 Days	12 Hours
30 °C	2 Hours	4 Hours	4 Days	8 Hours

TYPICAL PAINT SYSTEM

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

ROCK POXY ZINC 811	50µm
ROCK MASTIC AL 222	125 µm
ROCK THAN 355	50µm

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

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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

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

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.

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