

## PRODUCT SPECIFICATIONS

### Product Description

A two component, high build surface tolerant polyamide adduct cured epoxy coating.

### Design Feature

- Suitable for Mild steel, Galvanise steel, Aluminium and concrete substrates.
- A tough, hard wearing maintenance primer / sealer coat for metal substrates in situations where blasting is impractical and only power or hand tool surface preparation is possible. Excellent anticorrosive performance with outstanding tolerance to moisture.
- Outstanding fresh & seawater resistance. Suitable for use in immersed applications.
- Able to cure under adverse conditions and at temperatures down to 8°C.
- The recommended tie coat for antifouling paints.
- Good hardness and abrasion resistance.
- An ideal tar free replacement for coal tar epoxies.

### Physical Characteristics

Recommended Application Data		Wet [μm]	Dry [μm]	m²/l
Theoretical Coverage		150	100	7.0
Volume Solids	:	70% (based on ASTM D2697)		
Dry Film Thickness Range	:	75 μm to 200 μm		
Flash Point	:	28 °C		
Finish	:	Semi-Gloss		
Colour Range	:	Red-Oxide & Grey		
Standard Packing Size	:	20 L Set (16 L Base : 4 L Hardener)		
Mix Ratio (by volume)	:	4 Base : 1 Hardener		

### Application Method

AIRLESS SPRAY	:	Tip Size	:	0.53 – 0.63 mm ( 21 – 25 thou )
Recommended method of application	:	Pressure	:	110 –160 kg/cm² (1600 – 2300 psi)
CONVENTIONAL AIR SPRAY	:	May be used. May require additional dilution to achieve good atomisation.		
BRUSH OR ROLLER	:	May be used. However, additional coats may be required to achieve the recommended film thickness. Suitable for stripe coating, weld-seams, edges, corners, rivets, etc.		

### Drying & Curing Time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Min.	Max.	
15 °C	6 hours	12 hours	24 hours	Indefinite	4 hours
25 °C	4 hours	8 hours	12 hours	Indefinite	3 hours
35 °C	3 hours	6 hours	8 hours	Indefinite	2 hours

### Useful Information

THINNER	:	SOLVALUX 7-45 or 7-33 (Maximum 5% addition)
CLEANER	:	SOLVALUX 7-77
STORAGE	:	Store in a cool dry shaded area.
SHELF LIFE AT 25 °C	:	24 months when stored as prescribed in the MSDS.

## Surface Preparation

The service life span and the service performance of EPIMASTIC 3100 is directly related to the degree of surface preparation.

### STEEL

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1. Soluble salts, dirt and dust must be removed by dry brushing and freshwater washing. Remove scale by chipping, needle gun or spot blasting. Any loose or flaking coatings should be taken back to a firm edge.
- Mechanically clean the surface using hand or power tools to a minimum standard of St 2 (ISO 8501-1:1988) or SSPC-SP2 taking care to avoid polishing the surface.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to smooth surface.
- For best performance abrasive blasting should be used. Abrasive blast clean to a minimum surface preparation standard of Sa2½ (ISO 8501-1:1988) or SSPC-SP10, with an average surface profile of 50 – 75 microns. Apply Epimastic 3100 immediately after blasting to prevent oxidation and recontamination of the steel surface. In case of oxidation or recontamination, re-blast to the required standard.

### GALVANISED STEEL

- Ensure that white zinc salts and other surface contaminants are removed by abrading with abrasive paper or suitable mechanical tools.
- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1.
- The surface to be coated must be clean and dry.

### ALUMINIUM

- Solvent cleaning according to SSPC-SP1 followed by light blast cleaning with a fine grade abrasive or by chemical etching.

### CONCRETE

- New concrete should be left for at least 28 days to cure before coating.
- The moisture content of the concrete surface should be checked and ensured to be below 6% when measured with a reliable moisture meter, such as the Sovereign Moisture Meter.
- The surface should be dry, free from surface contaminants, sound and undamaged.

To avoid condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above Dew Point.

## Suitable Finish Coats

Luxathane 5075, Luxathane 5150HS, Luxathane 5000 HB, Epilux 4, Epimastic 5100, Luxol 5000, Epilux 82, Steelshield 1200, Steelshield 1100, Epimastic 3000HS, Epilux 58HS, Epilux 218, Navilux 1500, Navilux 1300, Navilux 1100, Navilux 4900, Navilux 4100.

## Notes

- The coating specifications given above are typical. For specific recommendations to suit individual applications, please refer to your Berger Paints representative.
- Common to all epoxies this product will experience yellowing and chalking on prolonged exposure to sunlight. However, this phenomenon is not detrimental to coating performance. As such, for atmospheric exposure where gloss and colour is important this product should be over coated with a suitable weather resistant finish coating.
- Exposure to very low temperatures, high humidity or water ponding during and/or immediately after application may result in incomplete cure and/or discolouration that may compromise subsequent intercoat adhesion.

## Safety Precaution

- Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe in vapour or spray mist.
- This product is flammable. Keep away from sources of ignition. Do not smoke.
- Take precautionary measures against static discharge.
- In case of fire, blanket flames with foam, carbon dioxide or dry chemicals.

**First Aid**

- Eyes** : In the event of accidental splashes, flush eyes with warm water immediately and seek medical advice.
- Skin** : Wash skin thoroughly with soap and water or approved industrial cleaner. Do Not Use solvents or thinners.
- Inhalation** : Remove to fresh air, loosen collar and keep patient rested.
- Ingestion** : In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention.

For further safety information, please refer to our **Material Safety Data Sheet (MSDS)**

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.

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