

Chemcolor corrosion protection system

Epoxykolor mastic CH 800

Two-component high-solids epoxy mastic or alumatic coating for metal

Intended use

EPOXYKOLOR MASTIC CH 800 is a two-component epoxy anticorrosive coating with an amine adduct. It has a high solids content and therefore a low solvent content, excellent penetration properties and can be applied in thick films. It can be applied to all types of substrates, including poorly prepared metal surfaces, and is particularly suitable for renovating old coating systems. EPOXYKOLOR MASTIC CH 800 provides long-term corrosion protection under severe conditions and can be used as a primer, intermediate coat, topcoat or single-coat system.

Properties Areas of application

- high-solids coating
- can be applied to all types of substrates, including refurbishment of deteriorated coating systems
- can be used as a primer, intermediate coat or topcoat
- the coating can be used as a primer, intermediate coat or finishing topcoat
- highly resistant to chemicals
- can be applied to all types of substrates, including renovation of deteriorated coating systems
- for the protection of structures, machinery, frames and equipment
- substrates: steel and all types of metal surfaces, including galvanised metal and aluminium
- good penetration properties allow use on poorly prepared surfaces (at least St 2) and for renovation of deteriorated coatings with sufficient adhesion

Technical data*

Packaging	A	24 kg
	B	3 kg
Mixing ratio	By weight	A : B = 8 : 1
	By volume	A : B = 5,5 : 1
Pot life	Temperature	10 °C 20 °C 30 °C
	Time [h]	3 1,5 1
Application temperature		3 °C above the dew point
Application humidity		Minimum 30 and maximum 85 % relative air humidity
Thinning		EPOXY THINNER
Drying time	Temperature [°C]	10 °C 20 °C 30 °C
(dust dry / touch dry)	Time [h]	8 / 24 h 6 / 20 h 3 / 10 h
through dry	Time [days]	14 d 7 d 4 d
Recoating interval	Minimum	10 h - 25 °C
	Maximum	168 h - 25 °C
Film thickness	Wet	180 / 250 / 370 µm
Min/recommended/max	Dry	150 / 200 / 300 µm
Theoretical coverage	200 µm dft	4.0 m ² /L 2.9 m ² /kg
Shades		alu and others
Gloss		semi-matt
Solids content	By weight	86 ± 2 %
	By volume	81 ± 2 %
Density	Mixture	1.38 g/ml
Viscosity	ISO 2431	100 s F6 (20 °C)
Adhesion		ISO: 0 / ASTM: 5B
VOC content		IIA(i), 500 g/l (2010); product contains: max. 100 g/l

(*All technical data stated in this technical data sheet are based on laboratory tests. Actual data may vary depending on application conditions beyond our control. dft-dry film thickness)

Surface preparation

Good practice

The surface must be dry, clean and free of dirt, grease, rust, slag residues, poorly adhering old paint, salts, or other contaminants that could prevent good adhesion. Welds, repaired areas, joints and surface damage identified during surface preparation must be properly cleaned and treated before painting.

Surfaces that have oxidized after preparation and before painting must be treated in accordance with the appropriate standard. Consult the specified standards. For further advice, contact Chemcolor technical service.

Metals

Before preparing the surface for coating, solvent-clean it to remove contaminants such as oil, grease, salts, dirt and markings. Highly exposed surfaces or surfaces intended for immersion must be prepared using the ISO 8504-2 method or blast-cleaned to ISO 8501-1 Sa 2.5. After cleaning, the surface must be clean with a roughness of 25-50 microns.

Degrease aluminium and galvanized surfaces, then lightly abrade or blast-clean them.

Refurbishment of old coatings

Prepare the surface by solvent cleaning to remove contaminants. Use manual cleaning to ISO 8501-1 St 2 or power-tool cleaning to ISO St 3 to remove corrosion and poorly adhering paint and prepare the surface in accordance with the standard. Overlap the edges of sound, well-adhering paint by 5-10 cm with the new paint or primer. Abrade glossy surfaces to provide a profile for adhesion. Apply a test area to verify compatibility between the old and new coatings.

Application conditions

The substrate temperature must be at least 3°C above the dew point during application.

Temperature: 5° - 30°C

This temperature applies to the air, surface and material. The surface must be visibly dry.

Relative air humidity: 30% - 85%

Material preparation and application

We recommend bringing both containers to room temperature before use (20 °C, minimum 15 °C). The mixing ratio is 8 : 1 by weight and the pot life is approximately 1,5 h (20 °C and normal working conditions, with an induction time of 10 minutes). Do not apply the coating after the pot life has expired, as adhesion, drying or gloss problems may occur.

Add component B to component A in the exact specified ratio and mix thoroughly with an electric mixer for 2-3 min at low speed (300-400 min⁻¹). To avoid mixing errors, we recommend pouring the mixture into a clean container and briefly mixing it again.

Epoxykolor mastic CH 800 can be applied by brush, roller or airless spray. Stir thoroughly before application. In opened containers, cover the paint with thinner, seal tightly and use within a short period.

Brush/roller

Brush: Natural fibres

Roller: Natural or synthetic fibre cover

Thinning by volume: up to 5 % Epoxy thinner

Airless

Pressure: 150-200 bar

Nozzle: .017-.021

Thinning by volume: up to 5 % Epoxy thinner

Brush or roller application is suitable for small areas and local repairs. Compared with spraying, brush application requires more coats to achieve the specified dry film thickness. Thinning depends on the application conditions and paint temperature.

Cleaning

Epoxy or Nitro thinner. If the specified thinners are unavailable, use MEK, MIBK, xylene, a 50:50 mixture of xylene and MEK or MIBK, or acetone for cleaning only.

Coating systems

Epoxykolor mastic CH 800 can be used as a standalone coating system or finished with one- and two-component varnishes and enamels.

Vinilacryl emajl Epoxykolor emajl Purkolor emajl

Cleaning tools and surfaces

Clean tools and equipment immediately after use with Epoxy thinner, acetone or Nitro thinner, or mechanically.

Storage

The shelf life of the product in tightly closed, undamaged original packaging, stored in a dry place at temperatures between +5°C and +25°C, is 12 months from the date of manufacture.

Notes

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Chemcolor's liability for any claim, including negligence or strict liability for loss or damage arising from work performed, related to or resulting from the use of the products, shall in no case exceed the purchase price of the products or the portion of the products giving rise to the claim. Chemcolor shall in no case be liable for consequential or incidental damage.

Protective measures:

- Forced ventilation must be provided when applying the product in enclosed, unventilated spaces. The material must not be applied near open flames or welding operations.
- Wear protective equipment during work, including gloves, safety glasses and other necessary protection.
- Before eating and after work, change contaminated clothing and wash your hands.
- Observe the safety warnings on the packaging label.

Important warnings:

- Dispose of uncured or unbound material in accordance with applicable regulations. Fully cured material may be disposed of at municipal landfills in accordance with applicable regulations.
- Detailed safety precautions and physical, toxicological and ecological information for the product are provided in the safety data sheet, available from the Chemcolor sales department or at www.chemcolor.si.

This information is based on our experience to date and careful research. Site conditions and knowledge of the work influence the quality of application. Successful work depends on professional assessment of the substrate at handover and practical experience in selecting the appropriate product. Please also follow the manufacturer's recommendations and the safety data sheet for this product.