



TRIOCOR MASTIC 4500 (MIO)

Modified epoxy primer

DESCRIPTION: A two-pack high-build modified epoxy MIO-pigment primer.

TYPE AND RECOMMENDED USE: Multi-functional epoxy coating is suitable for the protection of steelwork in a range of exposure environments from C1 to C5 as defined in ISO 12944, including industrial, oil&gas and infrastructure facilities exposed up to C5-I, C5-M as defined in ISO 12944-2. Not for immersion service.

PHYSICAL CONSTANTS:

Colour: Grey.

Volume solids: 70±5 %

Theoretical spreading rate: 0.107 ltr/m² - 75 microns DFT.

Film thicknesses:

Typical thicknesses

| Film thicknesses | WFT, microns | DFT, microns |
|------------------|--------------|--------------|
| Minimum | 107 | 75 |
| Maximum | 393 | 275 |

Drying times:

| Drying times for 75 microns DFT | | | | | | | | |
|---------------------------------|----------|----------|-----------|-----------|-----------|---------|------------|---------|
| Substrate temperature | 0°C | 5°C | 10°C | 15°C | 20°C | 25°C | 30°C | 35°C |
| To touch | 9 hours | 5 hours | 2 ½ hours | 1 ½ hours | 1 ¼ hours | 1 hours | 55 minutes | ¾ hours |
| To recoat: | | | | | | | | |
| TRIOCOR MASTIC 4500 (MIO) | 32 hours | 16 hours | 8 hours | 5 hours | 4 hours | 3 hours | 2 ½ hours | 2 hours |
| TRIOCOR FINISH 5500 | 32 hours | 16 hours | 8 hours | 5 hours | 4 hours | 3 hours | 2 ½ hours | 2 hours |

Drying time is thickness dependent. These figures are given as a guide only. Factors such as air movement and humidity must also be considered.

SURFACE PREPARATION: Apply only on a dry and clean surface with a temperature at least 3°C above the dewpoint. There are following surface preparation stages: remedy imperfections to P2 in accordance with ISO 8501-3; remove oil and grease (if necessary); remove salt if necessary; blast clean to Sa 2½ in accordance with GOST R ISO 8501-1-2014 with average surface profile in the range 50 - 75 microns, if maintenance clean damaged areas thoroughly to minimum P St 3; dust, blast abrasives shall be removed from the surface after blast cleaning such that the particle quantity and particle size do not exceed rating 2 of ISO 8502-3.

Technical Data Sheet



APPLICATION DETAILS:

| | | | |
|--|--|-------------------|----------------|
| Material preparation: | A two component material. Before mixing with the Additive stir the Base and the Additive separately. Mixing Ratio is given in product certificates of quality. | | |
| Pot life: | 2 ½ hours – 15 °C | 1 ½ hours – 20 °C | 1 hour – 35 °C |
| Application method: | Airless Spray / Manual application. | | |
| Thinner: | TRIOSOLV 0002 (if necessary), up to 5% by volume for airless spray. Contact your O3-Coatings representative for additional data. | | |
| Nozzle size (recommended): | .013" -.019" | | |
| Operation pressure (recommended): | Not less than 150 bar. | | |
| Cleaning of tools: | Thinner TRIOSOLV 0002 (other solvents may be used in consultation with O3-Coatings). | | |
| Application conditions: | Should be applied at temperatures above -10°C; Relative humidity: 90% maximum; (In confined spaces provide adequate ventilation during application and drying). | | |

RECOMMENDED SYSTEMS:

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|---------------------------|--|
| Preceding coat: | TRIOCOR ZINC 1700. Contact your O3-Coatings representative for additional data. |
| Subsequent coat: | TRIOCOR FINISH 5500. Contact your O3-Coatings representative for additional data. |
| STORAGE: | 24 months from date of manufacture. Store in dry, shaded conditions at temperature between 0°C and +30°C in hermetic original package away from UV rays and other sources of heat. |
| ADDITIONAL NOTE: | Numerical values quoted for physical data may vary slightly from batch to batch. |
| PACKAGE: | Set "Base – Additive" 20L. |
| HEALTH AND SAFETY: | Refer to the Safety Data Sheet before use. |