Technical Data Sheet

TRIOCOR MASTIC 4500

Modified epoxy primer

DESCRIPTION:

A two-pack high-build modified epoxy zinc phosphate primer.

TYPE AND RECOMMENDED USE:

Multi-functional epoxy coating is suitable for the protection of steelwork, including industrial, oil & gas and infrastructure facilities exposed up to C5 as defined in ISO 12944.
May be used at temperature up to plus 120 °C.
Not for immersion service.

PHYSICAL CONSTANTS:

Colour:

Grey.

Volume solids:

75±5 %

Theoretical spreading rate:

0,1 ltr/m² - 75 microns DFT.

Film thicknesses:

Typical thicknesses

Film thicknesses	WFT, microns	DFT, microns
Minimum	100	75
Maximum	367	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	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 dew point.
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 $2^1/_2$ 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.

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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 7,5 % 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 minus 10 °C; Relative humidity: 90% maximum; (In confined spaces provide adequate ventilation during application and drying).

RECOMMENDED SYSTEMS:

Preceding coat:	The primer is applied directly to the prepared metal surface. It can be used as an intermediate layer in coating systems for other primers: epoxy, epoxy with zinc addition, zinc silicate, etc. For more information, please contact O3-Coutings.
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 plus 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.