TRIOCOAT MASTIC 4700

Epoxy primer

Description: Two-component epoxy primer containing anti-corrosion pigments.

Coating purpose: A universal anti-corrosion solution for the manufacture of process and electrical equipment, in general industrial and transport engineering, where resistance to extreme operating conditions is required. The primer is especially effective in combination with topcoats, ensuring a long service life even in aggressive environments. The primer is used for the protection of both new and repaired equipment. Not for use under immersion. Operating temperature of the primer coating: from minus 60 to plus 120 °C.

Physical characteristics:

Color: Grey, shade — not standardized.

Volume solids: 58–63 %

Theoretical spreading rate: 0.167 l/m² at DFT 100 µm

Coating thickness: Recommended minimum thickness of one dry film layer of TRIOCOAT MASTIC 4700: 50 µm. Recommended number of coats — 1–3. Non-sagging layer thickness (WFT): not less than 250 µm.

Theoretical consumption: Theoretical consumption of the primer when applied by pneumatic spraying to obtain a coating with DFT = (50–150) µm is (119–360) g/m².

Drying time of the coating with DFT = (50–150) µm:

Drying temperature	(12±2) °C	(20±2) °C	(60±2) °C
Relative air humidity	(75±5) %	(65±5) %	—
Drying to degree 3, according to GOST 19007, not less	6 h	4 h	0.5 h
Drying to resistance to mechanical impact (stacking, assembly)	14 h	8 h	Holding of the coating dried to degree 3 at temperature plus (20±2) °C
			1 h
Full drying to resistance to mechanical and chemical impacts (before operation of the product)	14 days	7 days	Holding of the coating dried to degree 3 at temperature plus (20±2) °C
			1 h

When assessing and calculating the actual drying time, it is necessary to take into account the presence of air flows and relative air humidity.

Surface preparation: The surface to be painted must be dry and clean. The material is applied to a prepared and dry surface with a temperature at least 3 °C above the dew point. The preparation process includes the following operations: elimination of surface defects to grade P3 according to ISO 8501-3; degreasing of the surface (if necessary); surface cleaning to grade Sa 2.5 according to GOST R ISO 8501-1. Recommended roughness profile Rz (20–50) μm. Dust removal of the surface to grade 2 with a particle size of not more than class 2 according to ISO 8502-3. The primer must be applied immediately after cleaning of the surface to be coated.

Application:

Material preparation: The material is two-component; before application, the base and the hardener must be mixed separately. The mixing ratio of the base and hardener to obtain a ready-to-apply mixture is 10.8 : 1 by volume.

Pot life at (20±2) °C: Not less than 4 h.

Application method: Airless spraying / Pneumatic spraying / Manual application. The duration of intercoat drying at a temperature of (20±2) °C is 15 min.

Thinner: Thinner TRIOSOLV 0002 (if necessary), up to 25 % by volume for pneumatic spraying. For more detailed information, contact O3-Coatings.

Process parameters:

Application method	Working viscosity, s	Amount of thinner, %	Pressure, atm	Nozzle diameter
Brush, roller	—	0.5	—	—
Pneumatic spraying	35–70	0–25	2–3	1.8–2.2 mm
Airless spraying	50–70	0–10	160–200	0.015–0.020 inch

Equipment cleaning: Thinner TRIOSOLV 0002 (other solvents may be used in agreement with O3-Coatings).

Environmental parameters: Air temperature not lower than minus 10 °C. Relative air humidity not higher than 80 %. In closed rooms, provide supply-and-exhaust ventilation in the appropriate volume for the period of application and drying.

Recommended systems:

Previous coat:	The primer is applied directly to the prepared metal surface. It may be used as an intermediate coat in coating systems over other primers: epoxy, zinc-modified epoxy, zinc-silicate, etc. For more detailed information, contact O3-Coatings.
Subsequent coat:	Acrylic polyurethane materials TRIOTOP FINISH. For more detailed information, contact O3-Coatings.
Storage:	24 months from the date of manufacture. It is recommended to store in a dry dark place in sealed factory packaging at a temperature from 0 to plus 30 °C, avoiding direct exposure to UV rays and other heat sources.
Transport packaging:	Kit "base — hardener" — 20 l.
Health and safety:	Refer to the Safety Data Sheet for the material.