

## **TECHNICAL DATA SHEET**

# **ARMAMASTIC**

### **Description**

A two-pack, high solids epoxy resin based coating designed for application to steel substrates prepared to the standard ST2 minimum, mill scale free. The product will cure down to -10°C and can be brush or spray applied.

Ready packed in 1.5L, or 20L packs.

### **Uses**

For the corrosion protection of the externals of steel structures in aggressive environments. Provides good resistance to water, sea water and dilute acids for offshore platforms, pipelines, valves, tanks for refineries, petrochemical & chemical units.

### **Features**

- Brush or Spray applied
- Fast curing
- Solids (vol %) 88 ± 2
- Water resistance Very good
- Salt Water resistance Good
- Chemical resistance Very good over wide range
- Substrate wetting Good
- Flexibility Excellent
- Abrasion resistance Good
- UV resistance Good

## **Surface preparation**

Steel surfaces must be clean from all contamination, such as grease, dirt, oil and salt. Grease and oil must be removed with a suitable degreaser. Cleaning can be carried out using hand or power tool e.g. needle guns, to ST2, minimum.

Refer to Armamastic Method Statement.

## **Mixing and Application**

The product is supplied in pre-weighed kits, Part A Base and Part B Hardener. Mix Part A & Part B thoroughly for at least two minutes, using a mechanical mixer until homogenous. Do NOT thin or split packs.

First apply Armamastic Weld Coat (see Technical Data Sheet and Application Method Statement) to all sharp edges, exterior weld areas, bolt areas, etc. before application of the first coat of Armamastic. Allow to dry (1-2 hours) before application of next coat.

May be spray or brush applied. When spraying use a 68:1 airless spray machine, Tip size 521-535.

During application the steel substrate temperature must be at least +10°C and at least 3°C above the dew point. Humidity must be below 90%.

When applying the product carry out regular wet film thickness tests with a film thickness comb to ensure even thickness.

Ensure adequate ventilation of enclosed areas during application.

### **First Coat**

Colour	Grey
Film Thickness dry (um)	200 (typical)
Film Thickness wet (um)	250 (typical)
Application rate (m <sup>2</sup> /l)	2.5 to 5 depending on surface roughness

### **Subsequent coats:**

As first coat

## Application

Mixed density (23°C)	1.2
Pot life at 30°C	60 mins
Drying time at 30°C -touch dry	3 hrs
Overcoating time at 30°C	4 hrs
Maximum humidity	90%
Minimum dewpoint/substrate Differential (steel)	Dewpoint +3°C

## Properties

TEST METHOD	STANDARD	UNIT	VALUE
Shore D hardness	ASTM D2240		86
Volume Solids		%	88
Tensile strength	ASTM D638	MPa	4.2
Flexural strength	ASTM D790	MPs	Pass
% Elongation	ASTM D638	MPa	28.0
Taber Abrasion	ASTM D4060	mg	65
Water vapour permeability test	ASTM D1653	MPa	0.13
Pull off adhesion on rusted sample	ASTM D4541	MPa	6.2
Pull off adhesion on Polyester coated sample	ASTM D4541		8.6
Salt Spray test 2000 hrs	ASTM B117	hrs	Pass
Humidity test 2000 hrs	ASTM D2247	hrs	Pass
Cathodic disbondment	ASTM G-8	mmr	1.2
QUV resistance 1000 hrs	ASTM G-53	hrs	Pass

### **Thinning and Cleaning**

Clean tools with Diacetone alcohol or styrene. Do not thin.

### **Storage**

Store in a dry, well ventilated area, away from direct sunlight, maximum temperature 35°C.

### **Packaging**

Armacoat standard packing size.

### **Health and safety**

Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes.

Refer to material Safety Data Sheet.

### **Contact Information**



<http://armaccoat.in>

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