

**A surface tolerant, two component, anticorrosive high solids modified epoxy based aluminium mastic. Modified aluminium Epoxy mastic on ST-2 cleaned surfaces, hand prepared steel and old paint systems, as well as SA½ blasted substrates. Fast water resistance and good wetting properties makes it suitable for application during high relative humidity. Good curing at low temperatures (-10°C). For unmatched levels of barrier protection and corrosion resistance. For specific information please consult your Baril Advisor.**

- extreme adhesion;
- extreme barrier properties;
- extreme corrosion resistance;
- extreme flexibility;
- resistant to water spill, various solvents and chemicals;
- also suitable as a rust-resistant primer on steel, galvanized steel and aluminum.

## PROPERTIES

Gloss	Silky
Gloss disclaimer	The final gloss level is partly determined by the structure of the substrate and the applied layer thickness and may in some cases deviate from the above values.
Colour	Aluminium
Volume solids	ca. 72 vol.% (mixed product, depends on colour)
VOC	≤ 264 g/l
Density	At 20 °C ± 1.45 kg/l (mixed product)
Dry film thickness	Standard: 60-140 µm (depends on application process)
Theoretical coverage	At a dry film thickness of 80 µm: 8.8 m <sup>2</sup> /l
Practical coverage	The performance in practice depends on various circumstances. As a guideline for airless spraying: For large dimensions: 70% of the theoretical coverage. For small dimensions: 50% of the theoretical coverage.
Packaging	20 litre cans and 200 litre drums. Thinner in 25 litre jerry cans.
Shelf life	In original well shut packaging 12 months, stored inside at temperatures between 5 °C and 40 °C.
Heat resistance	Maximum 150 °C (dry load). In Aluminum RAL9006/9007 up to 200 °C (dry load).
Activator	959V
Thinner	EP5800

## DRYING TIMES

	10 °C	20 °C
Dust free	3 hours	1.25 hours
Manageable	8 hours	3 hours
Recoatable	5 hours	2 hours

Dry times with Activator 959V at a standard dry film thickness of 80 µm. (method: BYK Drying recorder).

During drying and curing the relative humidity should remain under 90%. Furthermore, any contact with moisture must be avoided during this period. In case of water spillage during the curing cycle white spots may occur

## PRE-TREATMENT

Untreated steel	Modified aluminium Epoxy mastic on ST-2 cleaned surfaces, hand prepared steel and old paint systems, as well as SA½ blasted substrates.
Hot dip galvanized	The surface needs to be pretreated according ISO12944 part 4 §6.2.3.4.1 (sweep blast, with inert grit). See also NEN5254 for Duplex systems. Remove grease, oil, dirt etc. using an appropriate cleansing agent, for instance ENVICLEAN PR (for use see product sheet). Lightly blast the entire zinc surface with an inert blasting agent (grain size: 0.3 - 0.5 mm, blasting pressure: 2.0 - 2.5 bar, nozzle opening: 6 mm minimum). After blasting, the entire surface must have a uniform flat appearance. Depending on the zinc layer thickness, in accordance with NEN5254, max. 5 - 10 µm of zinc can be removed. After blasting remove all dust from the entire surface with compressed air which is free of moisture and grease. Apply first coating layer within 2 hours.

## WORKING PROCESS

Mixture	16417 UniBar Mastic, 4 parts by volume. Standard: Activator 959V, 1 part by volume.
Mixing instructions	Mix base component and activator intensively, preferably using a mechanical mixing device. The temperature of the mixed product should at least be 5 °C during application.
Potlife	At 20 °C 6 hours (mixed product)
Thinning	The paint can be applied without thinning when using airless spray equipment (18-23 °C). The necessary amount of EP5800 depends on used equipment, application method and temperature of the mixed product. In case of electrostatic spraying, it is possible to adjust the electric resistance of the paint to 500-1000 Ω, by means of solvent ES5401.
Application conditions	The temperature of the substrate should be at least 3 °C. above dew point. Keep application area well ventilated during application and drying in order to reduce evaporated solvents. This is necessary to acquire good drying conditions and for the good of the applicators' health.
Application method	Preferably by means of airless or airmix spray equipment. When using brushes, a different film thickness and possibly inferior flow will be achieved.

## PROCESSING DATA

	<b>Airless spray</b>	<b>Airmix</b>	<b>Brush-roller</b>	<b>Airspray</b>
Thinner	EP5800	EP5800	S5102/EP5800	EP5800
Amount	0-10 vol.%	5-10 vol.%	0-5 vol.%	10-15 vol.%
Nozzle	0.015 inch	0.015 inch	n.a.	2.0-2.5 mm
Flow pressure	140-160 bar	70-100 bar	n.a.	3-4 bar
Dry film thickness	60-140 µm	60-140 µm	60 µm	60-140 µm

Cleaning tools: Immediately after application using thinner EP5800.

## TOUCH UP

Touching up of damages or untreated parts at the construction site. Remove grease, oil, dirt etc. using an appropriate cleansing agent, for instance ENVICLEAN PR (for use see product sheet). Remove the rust from all mechanical damage caused by transport and mounting, untreated welding strips and welding spots and burns with rotating steel wire brushes, sanding discs or steel wire brushes and coarse sandpaper to purity degree St3, in accordance with ISO 8501-1. Smooth the transition of cleansed parts to parts with intact coats of paint by sanding and scraping. After sanding, remove all dust from the entire surface with compressed air which is free of moisture and grease. Then touch up the object with the entire paint system, as described in this paint advice. Touch up light surface damages only with the product of the top coat, as described in the paint advice.