



Product & Application Specification
Pipelines & Fittings
DENSO ST EPOXY MASTIC

Product Description:

Denso Epoxy Mastic is a two-pack surface tolerant, high solids epoxy based primer / topcoat which may be applied in high film thickness. This product is a part of a complete system, which is certified not to spread surface flames.

Recommended Uses:

Steel where blast cleaning may not be possible, and where gloss retention is of minor importance. Can be used alone or in combination with other topcoats. Gives excellent corrosion protection both in salt and fresh water.

Technical Information:

Colour :	Limited range		
Solids (% by volume) :	82 ± 2		
Specific Gravity :	1.3 – 1.5 (After mixing)		
Flash Point :	35°C (Setaflash)		
Flexibility :	Good		
Gloss :	Semigloss	Gloss Retention :	Fair
Water Resistance :	Very Good	Chemical Resistance:	Very Good
Solvent Resistance :	Good	Abrasion Resistance :	Excellent

	Film Thickness per Coat in Microns		Theoretical spread rate m ² /l
	Dry	Wet	
Application Range :	170-340	200-400	5.0 – 2.5
Typical :	200	250	4.1

Application Data

Application Methods	Airless spray. Brush or roller may be used for smaller areas.
Mixing Ratio (by volume)	6 parts Component A to 1 part Component B
Mixing	10 minutes prior to use
Pot Life	2.5 hours (@20°C) reduced at higher temperatures
Thinner / Cleaner	Thinner No. 17
Guiding Data Airless Spray	
Pressure at nozzle	15 -20MPa
Nozzle tip	0.8 – 1.1 mm
Spray angle	40 - 80°
Filter	Remove all filters.



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Surface Preparation

Power tool cleaning to Min. St 2 (SI 8501-1:1988/SZ 05 5900). Improved surface treatment will improve the performance. When used over old coating systems, the surface must be clean and dry.

Condition During Application

The temperature of the substrate should be minimum 10°C and minimum 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. When used in confined spaces, good ventilation is necessary. Do not use heated air until the solvents have evaporated from the paint film to avoid surface drying and solvent entrapment. Denso S.T. Epoxy Mastic should not be exposed to mechanical strain before being fully cured.

Drying Time

The drying times are evaluated according to SB 3900 Part C2 and SB 3900 Part C3. Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation
- * Recommended film thickness
- * One coat on top of inert substrate

Substrate Temperature	Surface ¹ Dry	Hand ² Dry	Cured	Dry to recoat ³	
				Minimum	Maximum ⁴
10°C	8 hours	24 hours	14 days	24 hours	-
23°C	4 hours	10 hours	7 days	10 hours	-
35°C	2.5 hours	5 hours	3 days	5 hours	-

NB: Evaluated according to BS 3900 Part C2 & Part C3

1. Recommended data given for recoating with the same generic type of paint
2. The surface should be free from chalking and contamination prior to application. Best intercoat adhesion occurs when the subsequent coat is applied before the preceding coat is cured. If this time is exceeded it may be necessary to roughen the surface.

Typical Recommended Paint System

Denso ST Epoxy Mastic 2 x 200 microns Dry Film Thickness
 Weatherseal Acrylic 1 x 40 microns Dry Film Thickness



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Storage and Packaging

- Storage - The product must be stored in accordance with national regulations
Preferred storage conditions are to keep the containers in a dry space provided with adequate ventilation. The containers should be sealed tightly.
- Handling - Handle with care. Stir well before use.
- Packing Content - 5Litre Kit contains 4.28litre Component A and 0.714litre Component B
20Litre Kit contains 17.15litre Component A and 2.85litre Component B

Health and Safety

Please observe the precautionary notes displayed on the container. Spray under well ventilated conditions. Do not breathe or inhale mix. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleaner, soap and water. Eyes should be flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, please refer to the Material Safety Data Sheet.