



04.67 Masterbond Base & Hardener

PRODUCT DESCRIPTION & USES

A high solid epoxy primer/coating formulated with Masterbond binder technology.

04.67 Transpoxy Masterbond has excellent corrosion resistance and provides good flexibility and impact resistance.

PRODUCT FEATURES

- High solids primer / coating
- Excellent corrosion resistance
- Good flexibility / impact resistance
- Due to unique penetration properties tolerant to lower degree of surface preparation
- Good recoatability with variety of products
- Made in New Zealand for New Zealand conditions.

TECHNICAL DATA

Gloss Level: Semi Gloss

Primer: N/A

Wash Up: **06.03 Transmarine Thinners**

Colours: Light Grey

Product Size: 8L Pack

Storage Temperature: 10°C - 30°C

Shelf Life Minimum: 2 years

Flammability: flammable (>25C)

Toxicity: Toxic

VOC content: 168g/L

Volume Solids: 81%

Wet Film Thickness: 185 micron

Dry Film Thickness: 150 micron

Coverage: 5.4 m²/L

SUBSTRATE PREPARATION INSTRUCTIONS

Steel: Oil and grease should be removed by solvent cleaning. The steel substrate should be cleaned with fresh, clean water in order to remove salts, dirt and other contaminants. Remove weld spatter and smooth weld seams and sharp edges as applicable. Apply **04.67 Transpoxy Masterbond** directly after the steel surface has been abrasive blasted.

Abrasive blasting: min. Sa 2

Power tool cleaning: min. St 2

Repair: Corroded areas should be power tool cleaned to St 2 or blast cleaned to Sa 2 or better. Existing paint systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

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Concrete: Concrete must be at least 1 month old before applying coating over it. The concrete must be dry and free of any oil, grease, wax, silicone, dust and other contaminants.

Grinding the concrete surface will help to increase porosity thus improving adhesion to the concrete. Surface must be cleaned after grinding from residual dust.

Alternatively acid etching will assist to remove loose concrete materials hence improving adhesion. The surface must be rinsed with fresh water and dried before the coating application.

RECOMMENDED APPLICATION METHODS AND TECHNIQUES

Minimum Surface Temperature: 5°C

Maximum Relative Humidity: 80%

Temperature Range: 5°C - 35°C

Suitable Application Methods: Airless Spray

Touch up only: Brush/Roller

Thinners: **06.03 Transmarine Thinners**

Max, Volume Thinners: 5%

Pot Life: 75 min

Mixing ratio: base to hardener: 10:1 by weight

DRYING CHARACTERISTICS

All figures quoted are at 20°C and 65% relative humidity.

Drying will take longer at lower temperatures and/or at higher relative humidity.

Do not paint when temperature of surface is below 5°C, above 35°C or when humidity is very high.

Touch Dry: 3 hours

Hard Dry: 20 hours

HEALTH & SAFETY

Flammable, toxic. Wash off with rubbing alcohol when in contact with skin as the product may cause dermatitis. Take normal precautions for handling paint i.e. do not ingest, avoid contact with skin and protect eyes from splashes.

Use half-face mask.

Refer MSDS, available on request, for detailed safety instructions.

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