



Mascoat
250P EPOXY

HIGH SOLIDS EPOXY MASTIC PRIMER

Selection & Specification Data

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| Product Name | Mascoat 250P Epoxy |
| Product No. | M-250P |
| Description | Mascoat 250P Epoxy is a high solids aluminum epoxy mastic primer that provides excellent corrosion protection over marginally clean substrates up to 250°F (121°C). It is intended for use under Mascoat's insulating coatings, but can also be topcoated with epoxies and/or polyurethanes. It is predominantly used on structural steel, steel tanks, barges, refineries, petrochem plants, power plants, railcars, pulp & paper mills, and other facilities as recommended. |
| Features | <ul style="list-style-type: none"> ◆ Surface tolerant coating ◆ Excellent corrosion protection ◆ Good chemical resistance ◆ Extended recoat window ◆ Excellent flexibility ◆ Excellent edge protection ◆ Single coat capability ◆ Outstanding wetting & adhesion properties ◆ VOC Compliant |
| Color | Aluminum |
| Finish | Matte |
| Reducer | >70°F/21°C: Mascoat Reducer 1-250 <70°F/21°C: Mascoat Reducer 2-250 |
| Theoretical Volume Solids Content (mixed) | 80% ±1% |
| WFT per Coat | 5–9 mils (127–228 μ) |
| DFT per Coat | 4–6 mils (101–152 μ) |
| Theoretical Dry Coat Coverage | 257 ft ² /gallon @ 5 mils (6.3 m ² /liter @ 127 μ) |
| VOC Content | |
| Unthinned | |
| Reducer 1-250 @ 1 pint/gal | 1.48 lbs/gallon (179 grams/liter) |
| Reducer 2-250 @ 1 pint/gal | 2.13 lbs/gallon (258 grams/liter) |
| Limitations | Applications should not exceed 250°F (121°C). |

Substrates & Surface Protection

Remove oil & grease from the surface with solvent or a commercial cleaner, which does not leave a residue according to SSPC-SP1

Abrasive blasting to a Commercial finish per SSPC-SP6 to obtain a 1.5–3 mil profile is preferred. For non-abrasive environments, Hand Tool cleaning per SSPC-SP 2, Power Tool cleaning per SSPC-SP 3 or High Pressure Water cleaning per SSPC-SP12/NACE 5 WJ-4 is recommended.

Application Equipment

Listed below are the general equipment guidelines for the application of this product.

| | |
|-----------------------------|---|
| Conventional Sprayer | Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8" I.D. minimum material hose and a .070" I.D. fluid tip and air cap are recommended. |
| Airless Sprayer | Sprayer such as Graco's Bulldog with a 30:1 ratio and a 0.017–0.021" tip is recommended |
| Power Mixer | Use only explosion proof power mixers |
| Brush or Roll | Use a medium brush and short nap roller with solvent resistant fibers and core. |

Application Conditions

| | <u>Material</u> | <u>Surface</u> | <u>Ambient</u> |
|----------------|-----------------|----------------|----------------|
| Minimum | 50°F (10°C) | 50°F (10°C) | 50°F (10°C) |
| Maximum | 90°F (32°C) | 110°F (43°C) | 110°F (43°C) |

Special reducing and application procedures are required outside these temperatures. Surface temperatures should be 5°F (2.7°C) above dew point to prevent condensation.

Physical Data

| Item | Results | Test Method |
|---------------------|---|-------------|
| Cyclic Salt Fog | 1000 hrs – No blistering or rust | ASTM B-117 |
| Impact Resistance | 160 in-lbs – Direct Impact | ASTM D-2794 |
| Adhesion | 4,407 psi | ASTM D-4541 |
| Abrasion Resistance | 1 kg load/1000 cycles – weight loss CS 17 wheel – 51 mg | ASTM D-4060 |

Coating exceeds performance requirements of SSPC Coating System No. 26.00

Resistance

| Exposure | Immersion | Splash/Spillage | Fumes |
|------------|-----------------|-----------------|-----------|
| Acidic | Not recommended | Good | Good |
| Alkaline | Not recommended | Excellent | Excellent |
| Solvents | Not recommended | Good | Excellent |
| Salt water | Excellent | Excellent | Excellent |
| Water | Excellent | Excellent | Excellent |

Mixing & Reducing

Mixing Power mix each component, then blend Part B into the Part A and mix until uniform at the following ratio:

| | <u>2 Gal. Kit</u> | <u>10 Gal. Kit</u> |
|----------------------|-------------------|--------------------|
| M-250P Part A | 1 Gal (3.79 L) | 5 gallon (18.93 L) |
| M-250P Part B | 1 Gal (3.79 L) | 5 gallon (18.93 L) |

Reducing Reducing is not required for most applications; however M-250P may be reduced up to 1 pint/gal. Reducer 1-250 is recommended for applications temperatures below 70°F (21°C) and Reducer 2-250 is recommended above 70°F (21°C). Reducer 2-250 is recommended for overcoating inorganic zinc primers as well as for brush and roller applications of M-250P.

Pot life Four hours at 75°. Less at higher temperatures.

Packaging, Handling, & Storage

| Packaging Unit | <u>2 Gal. Kit</u> | <u>10 Gal. Kit</u> |
|------------------------|--|--------------------|
| M-250P Part A | 1 gallon | 5 gallon |
| M-250P Part B | 1 gallon | 5 gallon |
| Shipping Weight | | |
| Package Unit | 28 lbs. (12.7 kg) | 140 lbs. (63.5 kg) |
| | <u>1 Gal</u> | <u>5 Gal</u> |
| Reducer 1-250 | 8 lbs (3.6 kg) | 40 lbs (18.1 kg) |
| Reducer 2-250 | 9 lbs. (4.1 kg) | 45 lbs. (20.4 kg) |
| Flash Point | | |
| M-250P Part A | 98°F (36.6°C) | |
| M-250P Part B | 133°F (56.1°C) | |
| Reducer 1-250 | 53°F (11.6°C) | |
| Reducer 2-250 | 113°F (45°C) | |
| Shelf Life | 2 years for both Parts A & B when stored inside at 40–110°F (4.4–43.3°C) | |

Cleanup & Safety

- Cleanup** Cleanup with Reducer 1-250 or Reducer 2-250
- Safety** For minimum protection, Mascoat recommends a half mask respirator with organic vapor cartridge. In confined spaces, a fresh airline respirator may be used. Eye protection recommended due to spray application method.
- Ventilation** Recommended for constricted areas.
- Clothing** Safety clothing & gloves are recommended.
- Skin Contact** If product comes into contact with skin, wash thoroughly with lukewarm water or diluted Boric Acid, and obtain immediate medical attention.
- Caution** Read and follow all caution statements on this sheet and the Safety Data Sheet. CONTAINS FLAMMABLE SOLVENTS. Vapors are heavier than air and will accumulate. Extinguish all flames and prevent all sparks. All electrical equipment and installations should be made and grounded in accordance with the National Electrical Code. Where explosion hazards exist workers are required to use non-sparking tools and wear non-sparking shoes.

Dry & Cure Times

The following minimum times are based on a 5 mil DFT and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

| Surface Temperature | To Touch | To Handle | Final Cure |
|---------------------|----------|-----------|------------|
| 50°F (10°C) | 20 hours | 48 hours | 10 days |
| 60°F (15°C) | 10 hours | 24 hours | 5 days |
| 70°F (21°C) | 5 hours | 12 hours | 3 days |
| 80°F (26°C) | 3 hours | 6 hours | 2 days |
| 90°F (32°C) | 2 hours | 3 hours | 1 day |

M-250P can be applied in a wet-on-wet manner with itself, which eliminates the dry time between coats. When recoating with other Mascoat Coatings or any other coatings, M-250P should dry according to the "To Handle" schedule.

M-250P has a 30-day recoat window. It is imperative to remove chalk and surface contamination prior to recoating. High pressure washing is an acceptable method of removing chalk and surface contamination. For application requiring longer than 30 days, please contact Mascoat for recommendations.