

Selection & Specification Data

Product Name	Mascoat 250P Epoxy
Product No.	M-250P
Description	Mascoat 250P Epoxy is a 2-part 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
Components	Dual-component with optional reducers
Reducers	>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	1.48 lbs/gallon (179 grams/liter)
Reducer 1-250 @ 1 pint/gal	2.13 lbs/gallon (258 grams/liter)
Reducer 2-250 @ 1 pint/gal	2.07 lbs/gallon (250 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:

	2 Gal. Kit	10 Gal. Kit
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 above 70°F (21°C) and Reducer 2-250 is recommended below 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°F. Warmer temperatures will shorten pot life.

Packaging, Handling, & Storage

Packaging Unit	2 Gal. Kit	10 Gal. Kit
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)
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1 Gal

5 Gal

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.