Mascoat 400DFP

DRY FALL MODIFIED COPOLYMER PRIMER

Selection & Specification Data

Product Name	Mascoat 400DFP
Product No.	M-400DFP
Description	Mascoat 400DFP is a hi-temp dryfall silicone copolymer primer designed for heated substrates up to 400˚F (200˚C). The one-part coating's dryfall properties allow it to dry to a powder within 10-20 feet from point of application, allowing it to safely be used in areas where overspray damage to nearby cars and equipment would be a concern. It offers maximum adhesion and corrosion protection even in limited surface preparation areas and does not require a heat cure. Engineered specifically for heavy industrial equipment, M-400DFP may be used on any service area ranging from ambient to 400˚F (200˚C) for premium corrosion protection.
Features	♦ Excellent corrosion protection ♦ Good chemical resistance ♦ Excellent flexibility ♦ Unlimited recoat window ♦ Excellent edge protection ♦ Single coat capability ♦ Outstanding wetting & adhesion properties ♦ VOC Compliant
Color	Light Yellow
Finish	Flat
Reducer	>70˚F/21˚C: Mascoat Reducer 1-400 <70˚F/21˚C: Mascoat Reducer 2-400
Volume Solids Content	43%
Mix Ratio	Single package
WFT per Coat	5–7 mils (127–178 µ)
DFT per Coat	2–3 mils (51–76 µ)
Theoretical Dry Coat Coverage	345 ft^2/gallon @ 2 mils (8.5 m^2/liter @ 51 µ)
VOC Content	
Unthinned	3.7 lbs/gallon (448 gram/liter)
Reducer 1-400	0
Reducer 2-400	0
Limitations	Applications should not exceed 400˚F (200˚C).

Substrates & Surface Protection

All surfaces should be clean, dry and free of all foreign contaminants. An SSPC-SP1 Solvent Cleaning is recommended before blasting or other cleaning method

Carbon Steel:

Best: An SSPC-SP6 Commercial Blast will provide good results in most situations.

Good: A SSPC-SP3 Power Tool Cleaning, SSPC-SP2 Hand Tool Cleaning, or waterjetting per SSPC-SP 12 to WJ-4 will provide good results.

Galvanized Steel: Contact a Mascoat representative, as recommendation will vary depending on substrate and exposure condition

Application Equipment

Listed below are the general equipment guidelines for the application of this product. It is designed for spray application.

	Conventional
Sprayer	DeVilbiss MBC-510
Fluid Tip	E
Air Cap	704
Atomizing Pressure	60 psi
Pot Pressure	20 psi
Hose	1/2"
	Airless
Sprayer	Graco 205-591
Pump	30:1/45:1/60:1
Tip Range	3.011–4.013
Pump Pressure	1,800 psi ± 25 psi
Hose	3/8" ID
Brush/Roller	Touch-up Only

Application Conditions

	Material	Surface	Ambient
Minimum	50˚F (10˚C)	40˚F (4.5˚C)	45˚F (7˚C)
Maximum	90˚F (32˚C)	120˚F (49˚C)	N/A

Dry-Fall Application Instructions: To ensure dryfall effect, do not apply in temperatures below 45˚F (7˚C), on surfaces below 40˚F (4.5˚C), or humidity above 85% Rh. When humidity is above 50%, take caution to observe the dry-fall range as it may extend slightly past the 20' (6 m) mark, up to 50' (15 m) depending on other weather variables. Make sure the equipment being used will give accurate psi readings so the pressure from the pump can be maintained at 1800 psi allowing a maximum +/- 25 psi for surges. Do not apply in temperatures that are 5˚F (2.75˚C) or less from the dew point.

Resistance Data

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

Mixing & Reducing

Mixing Mascoat 400DFP needs to be thoroughly mixed using mechanical agitation. It is ready to spray after proper mixing and reduction

Pot Life N/A

Reduction Reduction is required to achieve the dry-fall effect. Reduce by 15% - 20% with Mascoat Reducer 1-400 in ambient temperatures above 70˚F (21˚C) or Mascoat Reducer 2-400 in ambient temperatures below 70˚F (21˚C).

If “fingering” occurs during the spray application, increase the amount of thinner. This will decrease the viscosity of the coating. DO NOT increase pump pressure.

Packaging, Handling, & Storage

Packaging 1 gallon (3.785 L) & 5 gallon pails (18.93 L)

Weight 1 gallon – 14 lbs (6.35 kg)
5 gallon – 70 lbs (31.75 kg)

Storage Temp 20˚F–110˚F (-7–43˚C)

Flash Point (Lowest Flashing Component) -8˚F (-22˚C)

Cleanup & Safety

Cleanup Cleanup with Reducer 1-400 or Reducer 2-400

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 & barrier creams 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 This product contains FLAMMABLE materials. Keep away from sparks and open flames. Observe NO SMOKING regulations.

Observe low flash regulation.

All electrical equipment and installations should conform to NEC regulations. In areas where explosion hazards exist, workers should be required to use nonferrous tools, and to wear conductive, non sparking shoes.

Dry & Cure Times

The following minimum times are based on recommended thickness guidelines and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

To Touch	10 minutes
Tack Free	30-60 minutes
To Topcoat	2-3 hours
To Handle	2-3 hours
Put in Service	12 hours

Mascoat 400DFP has an infinite recoat window, but surface must be free of oil, grease, and debris. An SSPC-SP1 Solvent Cleaning is recommended prior to recoat if a significant period of time has passed since previous coat..