



ULTRAMASTIC 187 HB

(Self-Priming Epoxy Mastic)

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: High build, heavy duty two component self-priming epoxy maintenance mastic utilizing amide-amine curing agent.

PRODUCT DESCRIPTION: Self priming high performance, high build coating with superior adhesion characteristic to rusty steel and most aged paints. It has excellent performance to hand or power tool surface preparation.

TYPICAL USES: Includes exterior of tanks, pipelines, bridges, offshore structures, process equipment, structural steel expose to chemicals, high humidity or salt water atmosphere. It is ideally recommended for repainting rusty steel, refresher coat to most deteriorated coatings. It is also recommended for coating concrete and mortar surfaces.

LIMITATIONS: Not recommended for immersion service in acids, alkalis or solvents.

CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acids	NR	Very Good	Excellent
Alkalies	NR	Very Good	Excellent
Solvents	NR	Very Good	Excellent
Salt Water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

TEMPERATURE RESISTANCE: (Dry Basis)

Sustained	:	200°F (93°C)
Intermittent	:	250°F (121°C)

TOPCOAT: Ultramastic 187 HB normally does not require topcoat. May be topcoated with most epoxies, urethanes, epoxy esters, etc.

COMPATIBILITY WITH OTHER COATINGS:

May be topcoated over most epoxies, structural inorganic and organic zinc primers. Test patches of alkyds or oil.

SUBSTRATES: Rusty steel, galvanized steel or others as recommended.

ABRASION RESISTANCE: Very Good

FLEXIBILITY: Very Good. 1/2" bend zuhr conical mandrel 5 to 7 mil film.

WEATHERING: Excellent

THERMAL SHOCK: Unaffected 5 cycles -70 to +200°F

COLORS: Aluminum, Buff, Blue, Green, Gray.

* Other colors are available upon request.

FINISH: Semi-gloss

FLASH POINT: (Pensky Martens Closed Cup)

Ultramastic 187 HB Part A	139°F (59°C)
Ultramastic 187 HB Part B	123°F (49°C)
Ultramastic Thinner	73°F (23°C)

CALCULATED VOLUME SOLIDS:

Ultramastic 187 HB	83%±2%
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RECOMMENDED DRY FILM THICKNESS PER COAT:

5 mils (125 microns) minimum, 7 mils (175 microns) maximum for severe corrosive exposures.

CALCULATED COVERAGE PER MIXED GALLON:

1,331 mil sq. ft. (32.7 sq. ft./li. @ 25 microns)
266.2 sq. ft. @ 5 mils (6.54 sq. ft./li. @ 125 microns)
190 sq. ft. @ 7 mils (4.51 sq. ft./li @ 175 microns)

SHELF LIFE: 24 months minimum. Materials on stock should be turned upside down every 3-4 months.

SURFACE PREPARATION: Remove any oil or grease from surface to be coated with clean rags soaked in Ultracote Thinner #2 or tuluol.

ZONE OF USAGE:

STEEL

- a) **Immersion Service:** For immersion purposes, dry blast to near white finish conform to SSPC-SP10 or NACE #2.
- b) **Heavy Duty Service:** Interior process areas, structural steel, process equipment, tank exteriors and other surfaces subject to attack by fumes, occasional chemical spills and splashes at intermediate temperatures. SSPC-6 finish and a minimum film thickness of 7 mils required.
- c) **Light Duty Service:** Interior and exterior area surfaces subject to fumes of fairly high concentration at ambient temperatures and marine and offshore exposures. SSPC-SP3 or SSPC-SP2 and a minimum film thickness of 5 mils required.

ALLOY STEEL, GALVANIZED STEEL AND NON-FERROUS METALS: Chemically clean surfaces in accordance with SSPC-SP-1 (Solvent Cleaning). Abrasive "brush blast to provide a lightly profiled and etched surface.

WELDING: Welding should precede coating. In the event welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instruction in USA Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damaged areas should be cleaned to base metal, prepared and recoated as specified.

CONCRETE: Acid etch surfaces and wash thoroughly with clean fresh water before application. Do not apply coating when concrete is wet and uncured.

MIXING: Mix separately, then combine and mix in the following proportions:

	<u>2 Gal. Kit</u>	<u>10 Gal.Kit</u>
Ultramastic 187 HB		
Part A	1 Gal.	5 Gal.
Ultramastic 187 HB		
Part B	1 Gal.	5 Gal.

NOTE: Components are not interchangeable. e. q. Component A of one color may not be used with Component B of another color and vice versa.

THINNERS: Ultramastic Thinner #15 is a medium drying thinner and is to be used under most conditions. Ultracote Thinner #20 is a fast drying thinner and should be used when applying at lower temperature. Thinned up at 20% by volume.

POT LIFE: Six hours at 75°F (24°C) when thinned 20%. Four hours at 75°F unthinned and one hour at 90°F (32°C) unthinned.

EQUIPMENT:

- 1) All spray equipment should be thoroughly cleaned and hose, in particular, should be free of old paints and other contaminants.
- 2) Use standard production spray guns:

<u>Gun</u>	<u>Fluid</u>	<u>Air</u>
Devilbiss		
GJA-502	E	704
Binks #18	66-SS	63-PB
Graco 800	4	02

- 3) When airless spray equipment is used, the recommended liquid pressure is 1,500 to 1,800 psi. with tip size from .017" to 0.024". Thinning requirements are more than for conventional spray.

BRUSH APPLICATION: A high quality brush should be used. Brush or roller application may result in non-uniform color.

APPLICATION PROCEDURES:

(Spray Application)

- 1) Air supply shall be uncontaminated. Adjust air pressure to approximately 50 lbs. at the gun and provide 15 to 20 lbs. pot pressure. Adjust spray gun by first opening liquid value and then adjusting air value to give approximately an 8" to 12" fan holding perpendicular to the surface at a distance of 12".
- 2) Apply a "mist" bonding pass.

- 3) Allow to flash-off for several minutes but not long enough to allow film to completely dry.
- 4) Apply 3 to 4 criss-cross multi-passes maintaining a wet appearing film (approximately 7 to 10 wet mils). This will dry to approximately 5 to 7 dry mils.
- 5) Equipment must be thoroughly cleaned immediately after use with Ultracote Thinner to prevent the setting of the coating.

NOTE: All welds, pits, and rough metal areas should be coated by brush prior to spray application.

DRYING TIME:

To Touch	:	2-3 hrs. @ 75°F (24°C) 1-2 hrs. @ 90°F (32°C)
To Handle	:	6 hrs. @ 75°F (24°C) 4 hrs. @ 90°F (32°C)
To Recoat	:	8-12 hrs. @ 75°F (24°C) 6-8 hrs. @ 90°F (32°C)
Final Cure	:	3 days @ 75°F (24°C)

STORAGE CONDITION:

Temperature	:	45-110°F (7-43°C)
Humidity	:	0-100%

PACKAGING:

Gallon (3.785 liters)
Pail (4 & 5 Gallons)

SAFETY INFORMATION: This product (and any recommended thinners) contains solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. Keep away from sparks, heat and open flame and use necessary safety equipment such as air mask, non-sparking tools and ladders, etc. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of reach of children.

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Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Ultracote Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.

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