SPENCER COATINGS

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ACOTHANE MASTIC RAPID GRADE

PRODUCT DESCRIPTION

Two component solvent-free mastic with excellent mechanical properties and low temperature curing characteristics.

USES

Repair of damaged coatings, weld coating, filling of holes and cracks etc. prior to the application of finishing systems. Rapid cure, single coat, high build, protective system for small areas.

TECHNICAL PROPERTIES

Colour	Grey
Finish	
Curing Agent	Acothane Activator
Mix Ratio	3 Base : 1 Activator by volume
Specific Gravity	
Volume Solids	100%
Recommended Film Thickness	1.0 –5.0 mm.
Theoretical Spreading Rate	0.19 m^2 per 250 g. @ 1 mm. thickness
Application Method	Putty Knife, Spatula, Trowel, Brush
Flash Point	200°C
VOC	0 g/litre.

Drying Times	**10**°C	**20**°C	**30**°C
Touch Dry		15 mins	
Hard Dry		1 hour	
Full Cure*		14 days	

**At low temperature curing rate will be slower.*

CERTIFICATION/APPROVALS

BS6920: Part 1: 2000 “Specification” – Complying with the requirements for Water Regulations Advisory Scheme tests on water quality and is suitable for use with cold water

RECOMMENDED SYSTEMS

SURFACE PREPARATION

Steel : Preferably grit blast to BS 7079 standard SA 2 ½. Surface profile 75-100 microns. Thorough abrading with wire brush, grinder, needle gun is acceptable.

Overlap Area : Remove any loose material to establish a firm edge. Feather sound coating (inducing surface roughness). Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disking etc.).

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Certificate No. LRQ4002648

PRODUCT APPLICATION

Mixing	Add Activator to Base and stir thoroughly. Pot life 5 mins. approx. @ 25°C.
Thinners	Do not thin.
Brush	Once mixed use immediately.
Roller	
Conventional Spray	
Airless Spray	
Air Assisted Airless Spray	
Cleaner	Thinner No.4
Cleanup Considerations	All equipment should be cleaned immediately after use with Thinner No.4 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited.

The user must observe local health, safety and environmental regulations when using this product.

Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

PACK SIZES

PACK WEIGHTS

STORAGE CONDITIONS

Shelf life: 12 months

LIMITATIONS

Normal application requires relative humidity below 80%. To avoid risk of condensation application should be done only when the temperature of the steel surface is at least 3°C (5°F) higher than the dew point. Application at temperatures below 1°C (33°F) must be watched carefully since the possible presence of ice in the pores of the surface could result in poor adhesion and reduced corrosion protection.

Temperature:	At Application:	Preferably above 0°C (surfaces free from ice/ condensation)
	In Service:	Immersion 0 to 70°C depending on solution
		Dry -20 to 120°C continuous

Notes:

1) Acothane Mastic is fully compatible with other Acothane grades.
2) Mastic Rapid can be used in operations requiring fast cure e.g. lay barge, weld coating and encapsulation of anode connectors, coating repair prior to trenching/backfilling. The standard grade material should be used for more leisurely coating operations.
3) UM Mastic has excellent adhesion to abraded F.B.E.

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TEST	SPECIFICATION	RESULT
Bond Strength	DIN 53232 (Primed and Unprimed Steel)	15 N/mm2
	DIN 53151 (Cross cut)	Glass G1
Water Vapour Permeability	DIN 52615	0.005 metric/perm.cm
Shrinkage	-	Negligible
Impact	ASTM 2794-69/14	20 N.M.
Tensile Strength	DIN 53504 13	20 N/mm^2
Elongation	ASTM D 2370	20-35%
Abrasion Resistance	ASTM 4060, CS17, 1 kg. load, 1000 cycles	<100 mg. loss
Shore Hardness	-	'D' 80 approx.
Flexibility	British Gas PS/CW6	Pass 2% strain @ 5°C
Cathodic Disbonding	British Gas GBE/CW6 (28 days @ 20°C) 1500 mV (calomel) 1.5 DFT Thickness	Pass

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