



# HIGH PERFORMANCE 9100 SYSTEM DTM EPOXY MASTIC

## DESCRIPTION AND USES

The 9100 System DTM Epoxy Mastic is a two-component, high solids epoxy coating for use in moderate to severe environments. It is specifically designed for application directly on sound rusted steel with minimum surface preparation. It can also be used on clean steel, galvanized metal, concrete (including concrete floors), previously coated and slightly damp surfaces. It may also be used for water immersion service, using the DTM Epoxy Mastic standard premix bases only with the Immersion Activator. (Note: Not use for immersion service in potable water tanks).

The 9100 System is available in 340 and 250 g/l VOC versions.

If a satin finish is desired, use the Satin Finish Standard Activator.

This coating complies with USDA FSIS regulatory sanitation performance standards for food establishment facilities. This coating is impervious to moisture and easily cleaned and sanitized.

Note: The Immersion Activator and the Fast-Cure Activator produce a semi-gloss finish. Also, using the Fast-Cure Activator may result with a slight color shift when compared with products using the Standard Activator.

This DTM Epoxy Mastic can be used indoors or out. Epoxy coatings will yellow with age. This is most noticeable with interior applications of white or light colors which are not subjected to bleaching from sunlight. Exterior exposure over time will cause fading and chalking with all epoxy type coatings. These changes are cosmetic in nature only and film integrity and performance will not be adversely affected.

MPI #98 Certified. Refer to the MPI website for the most current listing of MPI certified products.

## PRODUCTS

### BASE COMPONENT

| 1 Gallon             | 5 Gallons            | DESCRIPTION           |
|----------------------|----------------------|-----------------------|
| 9115402 <sup>2</sup> | -----                | Aluminum (Semi-Gloss) |
| 9122402              | -----                | Marlin Blue           |
| 9145402              | -----                | Equipment Yellow      |
| 9165402              | -----                | Regal Red             |
| 9168402              | -----                | Tile Red              |
| 9171402              | 9171300              | Dunes Tan             |
| 9179402              | -----                | Black                 |
| 9182402              | 9182300              | Silver Gray           |
| 9186402              | 9186300              | Navy Gray             |
| 9192402              | -----                | White                 |
| 266693               | 266697               | Buff                  |
| 9125402              | -----                | Safety Blue           |
| 9133402              | -----                | Safety Green          |
| 9144402              | 9144300 <sup>3</sup> | Safety Yellow         |

## PRODUCTS (cont.)

### BASE COMPONENT (cont.)

| 1 Gallon | 5 Gallons | DESCRIPTION   |
|----------|-----------|---------------|
| 204005   | 297081    | Safety Orange |
| 204006   | 297079    | Safety Red    |
| 323759   | -----     | Cafe          |

**NOTE:** Agriculture Canada accepted: 9115, 9145, 9165, 9171, 9179, 9186, 9192 and 9101.

### TINT BASES

| 1 Gallon | 5 Gallons            | DESCRIPTION |
|----------|----------------------|-------------|
| 9105405  | -----                | Red         |
| 9106405  | -----                | Yellow      |
| 9107405  | 9107375 <sup>3</sup> | Masstone    |
| 9108421  | 9108381              | Deep        |
| 9109408  | 9109388              | Light       |

### TINTING

The 9100 System tint bases can be tinted with Rust-Oleum 2020 Colorants or Evonik colorants. Tint should not be added to Activators.

### TINT BASE MAXIMUM COLORANT PER 2 GALLON KIT

| QUANTITY | TINT BASE DESCRIPTION |
|----------|-----------------------|
| 32 Oz.   | Red                   |
| 32 Oz.   | Yellow                |
| 32 Oz.   | Masstone              |
| 24 Oz.   | Deep                  |
| 16 Oz.   | Light                 |

### ACTIVATOR

| 1 Gallon             | 5 Gallons               | DESCRIPTION (340 VOC g/l) |
|----------------------|-------------------------|---------------------------|
| 9101402              | 9101300                 | Standard Gloss            |
| 9102402 <sup>4</sup> | 9102300 <sup>4</sup>    | Immersion Semi-Gloss      |
| 9104402 <sup>4</sup> | A910008300 <sup>4</sup> | Fast Cure Semi-Gloss      |

| 1 Gallon            | 5 Gallons | DESCRIPTION (250 VOC g/l) |
|---------------------|-----------|---------------------------|
| 205015              | 206232    | Standard Gloss            |
| 214430 <sup>4</sup> | -----     | Immersion Semi-Gloss      |
| 9103402             | 9103300   | Low Temp Gloss            |
| 214432 <sup>4</sup> | -----     | Fast Cure Semi-Gloss      |
| 331254              | -----     | Standard Satin            |

<sup>2</sup> The 9115 Aluminum is not recommended to be used in water immersion, as a floor finish, or as a prime coat for any finish other than itself.

<sup>3</sup> Made-to-Order only. Contact Rust-Oleum Customer Service for details

<sup>4</sup> Not for use with tint bases.



# HIGH PERFORMANCE 9100 SYSTEM DTM EPOXY MASTIC

## COMPANION PRODUCTS

### RECOMMENDED PRIMER

9100 System DTM Epoxy Mastic is self-priming and can be used without a primer in mild to moderate exposures. The use of a primer is required in severe exposures and on heavily rusted surfaces.

**NOTE:** 9100 System may be used as a primer for High Performance topcoats. For best results, use the 331254 Satin Activator.

### COMPATIBLE TOPCOATS<sup>5</sup>

3100 System Speedy-Dry DTM Acrylic Enamel  
3300 System Acrylic Aliphatic Urethane  
3700 System DTM Acrylic Enamel  
3800 System DTM Acrylic Enamel  
9400 System High Gloss Polyester Urethane  
9700 System 250 VOC Acrylic Polyester Urethane  
9800 System DTM Urethane Mastic

<sup>5</sup> Do not use any topcoat over 9115402 Aluminum. The 9115 Aluminum should only be topcoated with itself.

## PRODUCT APPLICATION

### SURFACE PREPARATION (cont.)

**ALL SURFACES:** Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® Original Cleaner Degreaser or other suitable cleaner. Rinse with fresh water and allow to dry.

**STEEL:** Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, scale, and deteriorated previous coatings to obtain a sound rusted surface. For optimum corrosion resistance, abrasive blast to commercial grade SSPCSP-6, with a blast profile of 1-2 mils (25-50 μ).

**STEEL (IMMERSION):** Abrasive blast clean to a minimum SSPC-SP-10 Near-White Grade (NACE 2) and achieve a surface profile of 1.5-3 mils. All weld spatter must be removed along weld seams, rough welds should be ground smooth, and all sharp edges should be ground to a smooth radius.

**PREVIOUSLY COATED:** Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. The DTM Epoxy Mastic is compatible with most coatings, but a test patch is suggested.

**GALVANIZED METAL:** Remove oil, dirt, grease and other chemical deposits with Krud Kutter Original Cleaner Degreaser or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

**CONCRETE OR MASONRY:** New concrete or masonry must cure 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas. Remove all loose, unsound concrete.

## PRODUCT APPLICATION (cont.)

### SURFACE PREPARATION (cont.)

**CONCRETE FLOORS:** Remove laitance and create a surface profile by either acid etching with Rust-Oleum 108402 Cleaning and Etch Solution, or by grinding. If etching, consult with 108 Clean & Etch Solution Technical Data Sheet for complete application instructions. Rinse thoroughly and allow to dry. The concrete must be fully dry prior to coating application. After etching, the concrete should have a texture, which resembles fine grit sandpaper. Repeat the process if necessary. Surface sealers and curing agents must be removed by grinding. Vacuum to remove fine dust and debris. The floor should be dry and dust free prior to application. Previously coated floors need to be in good condition with proper adhesion to the concrete substrate.

### APPLICATION

Airless spray is the preferred method of application. However, brush, roller, or air-atomized spray may also be used. Refer to table for thinning recommendations. For proper performance, a dry film thickness of 5-8 mils per coat is required. Excessive brushing or rolling may reduce film thickness. Apply a second coat if necessary to achieve the recommended film thickness.

Use the **Standard Activator or Fast Cure Activator** at air temperatures between **50-120°F (10-49°C)** and when the surface temperature is at least 5°F (3°C) above the dew point and less than 120°F (49°C). Low curing temperatures and/or condensation on the film while curing can affect appearance in the form of an amine blush. This can generally be removed with soap and water; however, in a case of extreme blushing, the performance of the coating may be slightly affected.

**NOTE:** The Fast Cure Activator may also be used in water immersion. Allow 7 days for full cure prior to beginning immersion service.

Use the **Low Temperature Activator** when application temperatures are between **40-60°F (5-15°C)** and when the surface temperature is at least 5°F (3°C) above the dew point. Do not apply the material if the temperature is expected to fall below 40°F in the first 24 hours of cure. At 40°F, full cure will be achieved in 7 days.

Use the **Immersion Activator** for water immersion service at air and surface temperatures between **60-100°F (15- 38°C)**. Apply when the surface temperature is at least 5°F (3°C) above the dew point, and when relative humidity is below 85%. Do not use the Immersion Activator with tint bases. This system may be used for both salt and fresh water; do not use for the inside of potable water tanks. Apply two coats alternating color between coats to ensure complete hide. Allow 7 days cure after application of the second coat before immersion.

**NOTE:** Do not use tinted colors in water immersion.

**RUST-OLEUM®**  
**HIGH PERFORMANCE**  
 INDUSTRIAL COATINGS

# HIGH PERFORMANCE 9100 SYSTEM DTM EPOXY MASTIC

## PRODUCT APPLICATION (cont.)

### APPLICATION (cont.)

**POOLS:** When used with Immersion Activator, the DTM Epoxy Mastic premix bases can be used as a pool coating over existing epoxy pool coatings, new bare concrete, plaster, Gunitite, and fiberglass. The pool must be completely empty and dry before coating. After pool is emptied, this typically requires 7- 10 days depending on temperature and humidity. To test the dryness of concrete, Gunitite or plaster pool surfaces, securely tape a 2 ft. by 2 ft. piece of clear plastic onto a horizontal and vertical surface at the deep end of the pool. Check after 24 hours. If water condensation is visible under the plastic, this is an indication that the surface is not completely dry, and NOT suitable for coating.

Allow additional dry time and retest. Follow surface preparation, mixing and application instructions. Avoid painting in midday sun. Application is recommended early in the day or late in the afternoon when at least 2 hours of sunlight remain after completion of the job.

Allow minimum of 5-7 sunny days cure before filling pool. Early contact with water can cause premature fading, chalking and blistering. Super chlorinated water can cause a bleached-out appearance. Sunlight and UV will cause chalking and fading. **Do not** use over: 1) chlorinated rubber, 2) synthetic rubber, 3) vinyl, 4) acrylic.

**NOTE:** In swimming pool service, early chalking may occur if the water pH is outside the range of 7.2-7.6 and/or if the water temperature exceeds 100°F (38°C). Not recommended for use in hot tubs.

### EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable.)

**BRUSH:** Use a good quality natural or synthetic bristle brush.

**ROLLER:** Use a good quality lamb's wool or synthetic fiber (3/8-1/2" nap).

### AIR-ATOMIZED SPRAY

| Method   | Fluid Tip   | Fluid Delivery | Atomized Pressure |
|----------|-------------|----------------|-------------------|
| Pressure | 0.055-0.070 | 10-16 oz./min. | 25-60 psi         |
| Siphon   | 0.055-0.070 | --             | 25-60 psi         |
| HVLP     | 0.043-0.070 | 8-10 oz./min.  | 10 psi (at tip)   |

### AIRLESS SPRAY

| Fluid Pressure  | Fluid Tip   | Filter Mesh |
|-----------------|-------------|-------------|
| 1,800-3,000 psi | 0.013-0.017 | 100         |

### THINNING

Thinning is normally not required, except for air-atomized spray. For air-atomized spray application, thin only up to 10% by volume with 160402 Thinner after the components have been mixed. If the coating is going to be used in immersion service, 9102 or 9104 activator, then, use up to 10% 165402 Thinner for air-atomized spray and up to 5% of 165402 Thinner for airless spray.

**NOTE:** Addition of more than 10% of 160402 or 165402 Thinner will cause VOC to exceed 340 g/l. In this case, 333402 VOC exempt thinner can be used if needed.

**NOTE:** When using the Satin Activator, thin only with 333402 Thinner to maintain the VOC <250 g/l.

## PRODUCT APPLICATION (cont)

### MIXING

Both the base and activator components are highly pigmented. Mix each component thoroughly to ensure any settled pigment is re-dispersed before combining the components together. Combine at a 1:1 ratio by volume in a container large enough to hold the total volume. Mix thoroughly for 2-3 minutes. Power mixing is preferred. Do not mix more material than you plan to use within the listed pot life.

### CLEAN-UP

Use 160402 or 165402 Thinner.

### SHELF LIFE

Base components 3 years<sup>6</sup> Activators 2 years<sup>6</sup>

<sup>6</sup> Unopened containers. Some settling may occur requiring mechanical mixing to redisperse pigment.

## PERFORMANCE CHARACTERISTICS

### SYSTEM TESTED

DTM EPOXY MASTIC WITH 9101 Activator

### PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: B (7 days), 4H (30 days)

### CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >32%

### CYCLIC PROHESION

Rating 1-10, 10=best

METHOD: ASTM D5894, 2300 hours

RESULT: 10 ASTM D714 for blistering

RESULT: 10 ASTM D1654 for corrosion

### IMPACT RESISTANCE (direct)

METHOD: ASTM D2794

RESULT: 160 in. lbs.

### ALKALI RESISTANCE

METHOD: ASTM D1308

RESULT: No effect

### TABER ABRASION

METHOD: ASTM D4060, CS-17 wheels, 500 gram load, 1000 cycles

RESULT: 125 mg loss

### GLOSS

METHOD: ASTM D4587

RESULT: 80%

**CAUTION:** Exposure of the 9100 System during the curing stage of the coating to the by-products of propane combustion may cause discoloration to occur. During application and curing, propane fueled fork-lifts and other vehicles or propane fueled heaters should not be used in the area until the coating is fully cured. At least 72 hours.

|  |  |               |
|--|--|---------------|
| <b>EPOXY</b>   | <b>TECHNICAL DATA</b>                                    | <b>RO-139</b> |
| <b>RUST-OLEUM<sup>®</sup><br/>HIGH PERFORMANCE<br/>INDUSTRIAL COATINGS</b> | <b>HIGH PERFORMANCE<br/>9100 SYSTEM DTM EPOXY MASTIC</b> |               |

### PHYSICAL PROPERTIES

|  |                   | <b>9101<br/>Activator</b>  | <b>9102<br/>Immersion Act.</b>                             | <b>9103<br/>Low Temp. Act.</b>                             | <b>9104<br/>Fast-Cure Act.</b>                             |   |                             |  |  |
|--|-------------------|--|--|--|--|---|-----------------------------|--|--|
| <b>Resin Type</b>  |                   | Aliphatic Amine<br>Converted Epoxy   | Polyamide<br>Converted Epoxy                               | Aliphatic Amine<br>Converted Epoxy                         | Polyamide/modified Amine<br>Converted Epoxy                |   |                             |  |  |
| <b>Inhibitive Pigment</b>  |                   | Calcium Borosilicate   | Calcium Borosilicate                                       | Calcium Borosilicate                                       | Calcium Borosilicate                                       |   |                             |  |  |
| <b>Solvents</b>  |                   | Xylene, Methyl<br>Isobutyl Ketone,<br>1-Methoxy-2-propanol                 | Xylene, Methyl<br>Isobutyl Ketone,<br>1-Methoxy-2-propanol | Xylene, Methyl<br>Isobutyl Ketone,<br>1-Methoxy-2-propanol | Xylene, Methyl<br>Isobutyl Ketone,<br>1-Methoxy-2-propanol |   |                             |  |  |
| <b>Weight<sup>7</sup></b>  | <b>Per Gallon</b> | 11.4-12.6 lbs.   | 11.4-12.6 lbs.   | 9.3-10.4 lbs.  | 12.0-13.0 lbs.   |   |                             |  |  |
|  | <b>Per Liter</b>  | 1.4-1.5 kg   | 1.4-1.5 kg   | 1.1-1.2 kg   | 1.4-1.6 kg   |   |                             |  |  |
| <b>Solids<sup>7</sup></b>  | <b>By Weight</b>  | 86-89%   | 79-82%   | 78-81%   | 81-83%   |   |                             |  |  |
|  | <b>By Volume</b>  | 78-81%   | 65-68%   | 72-75%   | 67-69%   |   |                             |  |  |
| <b>Volatile Organic<br/>Compounds<sup>7</sup></b>                                |                   | <340 g/l (2.84 lbs./gal.)  | <340 g/l (2.84 lbs./gal.)                                  | <250 g/l (2.08 lbs./gal.)                                  | <340 g/l (2.84 lbs./gal.)                                  |   |                             |  |  |
| <b>Mixing Ratio</b>  |                   | 1:1 Base:Act.(by vol.)   | 1:1 Base:Act.(by vol.)                                     | 1:1 Base:Act.(by vol.)                                     | 1:1 Base:Act.(by vol.)                                     |   |                             |  |  |
| <b>Recommended Dry Film<br/>Thickness (DFT) Per Coat</b>                         |                   | 5-8 mils (125-200µ)  | 5-8 mils (125-200µ)  | 5-8 mils (125-200µ)  | 5-8 mils (125-200µ)  |   |                             |  |  |
| <b>Wet Film to Achieve DFT<br/>(unthinned material)</b>                          |                   | 6.5-10.5 mils<br>(162.5-262.5µ)  | 7.5-12.0 mils<br>(187.5-300µ)                              | 7.0-11.0 mils<br>(175-275µ)                                | 7.5-12.0 mils<br>(187.5-300.0µ)                            |   |                             |  |  |
| <b>Theoretical Coverage at<br/>1 mil DFT (25µ)</b>                               |                   | 1,250-1,300 sq.ft./gal.<br>(30.8-32.0 m <sup>2</sup> /l)                   | 1,045-1,090 sq.ft./gal.<br>(25.7-26.8 m <sup>2</sup> /l)   | 1,155-1,200 sq.ft./gal.<br>(28.4-29.5 m <sup>2</sup> /l)   | 1,075-1,100 sq.ft./gal.<br>(26.4-27.3 m <sup>2</sup> /l)   |   |                             |  |  |
| <b>Practical Coverage at<br/>Recommended DFT<br/>(assumes 15% material loss)</b> |                   | 125-225 sq.ft./gal.<br>(3.1-5.5 m <sup>2</sup> /l)                         | 100-175 sq.ft./gal.<br>(2.5-4.3 m <sup>2</sup> /l)         | 125-200 sq.ft./gal.<br>(3.1-5.0 m <sup>2</sup> /l)         | 115-190 sq.ft./gal.<br>(2.8-4.7 m <sup>2</sup> /l)         |   |                             |  |  |
| <b>Induction Period</b>  |                   | None required  |  | 30 minutes<br>(60 min. < 65°F)                             | None required  |   |                             |  |  |
| <b>Pot Life<sup>8</sup></b>  | <b>2 gallons</b>  | 2-4 hours at<br>70°F (21°C),   | 1-2 hours at<br>90°F (32°C)                                | 2-4 hours at<br>70°F (21°C)                                | 3-5 hours at<br>60°F (15°C)                                | 2-4 hours at 60°F (15°C)                                | 2-4 hours at<br>70°F (21°C) | 1-2 hours at<br>90°F (32°C)                          |  |
|  | <b>10 gallons</b> | 2 hours at<br>70°F (21°C)  | <1 hour at<br>90°F (32°C)                                  | 2 hours at<br>70°F (21°C)                                  | 3 hours at<br>60°F (15°C)                                  | 2 hours at 60°F (15°C)                                  | 2 hours at<br>70°F (21°C)   | <1 hour at<br>90°F (32°C)                            |  |
| <b>Dry Times at<br/>50% Relative<br/>Humidity</b>                                | <b>Tack-free</b>  | 6-8 hours at<br>70°F (21°C)  | 12-24 hours<br>at<br>50°F (10°C)                           | 6-8 hours at 70°F (21°C)                                   |  | 16-20 hours at 40°F (5°C)                               |                             | 4 hours at<br>70°F (21°C)                            | 8 hours at<br>50°F (10°C)                        |
|  | <b>Handle</b>     | 6-12 hours at<br>70°F (21°C)   | 48-72 hours<br>at<br>50°F (10°C)                           | 8-14 hours at 70°F (21°C)                                  |  | 22-26 hours at 40°F (5°C)                               |                             | 5 hours at<br>70°F (21°C)                            | 10 hours at<br>50°F (10°C)                       |
|  | <b>Recoat</b>     | 16 hours to<br>1 year <sup>9</sup><br>70°F (21°C)                          | 72 hours to<br>1 year <sup>9</sup><br>50°F (10°C)          | 16 hours to<br>1 year <sup>9</sup><br>70°F (21°C)          |  | 24 hours to 1 year <sup>9</sup>                         |                             | 4 hours to 1 year <sup>9</sup><br>70°F (21°C)        | 8 hours to 1<br>year <sup>9</sup><br>50°F (10°C) |
| <b>Dry Heat Resistance</b>   |                   | 300°F (149°C),<br>Color may shift above 150°F<br>(66°C)                    |  | 300°F (149°C),<br>Color may shift above 150°F<br>(66°C)    |  | 300°F (149°C),<br>Color may shift above 150°F<br>(66°C) |                             | 300°F (149°C),<br>Color may shift above 150°F (66°C) |  |
| <b>Maximum Immersion<br/>Temperature</b>   |                   | NA   |  | 120°F (49°C)   |  | NA  |                             | NA   |  |
| <b>Shelf Life</b>  |                   | Unopened containers; 3 years Base components, 2 years Activator components |  |  |  |   |                             |  |  |
| <b>Safety Information</b>  |                   | See SDS  |  |  |  |   |                             |  |  |

<sup>7</sup> Activated material.

<sup>8</sup> Pot life is affected by air temperature, amount of material activated and quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour). Final gloss maybe slightly higher for coating applied near the end of the pot life.

<sup>9</sup> If recoat time is extended, be sure the surface is clean and free of all contamination prior to coating. Actual environmental conditions may affect results, so a trial is suggested to ensure acceptable results

|  |  |               |
|--|--|---------------|
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### PHYSICAL PROPERTIES

|  |                   | <b>205015<br/>Standard Activator</b>                  | <b>214430<br/>Immersion Activator</b>                    | <b>214432<br/>Fast-Cure Activator</b>                 | <b>331254<br/>Satin Finish Activator</b>              |
|--|-------------------|---|--|---|---|
| <b>Resin Type</b>  |                   | Aliphatic Amine converted Epoxy                       | Polyamide converted Epoxy                                | Polyamide/modified Amine converted Epoxy              | Polyamide/modified Amine converted Epoxy              |
| <b>Inhibitive Pigment</b>  |                   | Calcium Borosilicate                                  | Calcium Borosilicate                                     | Calcium Borosilicate                                  | Calcium Borosilicate                                  |
| <b>Solvents</b>  |                   | Aromatic Hydrocarbons, Ketones and Alcohols           | Aromatic Hydrocarbons, Ketones and Alcohols              | Aromatic Hydrocarbons, Ketones and Alcohols           | Aromatic Hydrocarbons, Ketones and Alcohols           |
| <b>Weight<sup>7</sup></b>  | <b>Per Gallon</b> | 11.4-12.4 lbs.  | 11.4-12.6 lbs.   | 12.1-13.2 lbs.  | 10.54-11.66 lbs                                       |
|  | <b>Per Liter</b>  | 1.4-1.5 kg  | 1.4-1.5 kg   | 1.4-1.5 kg  | 1.27-1.40 kg  |
| <b>Solids<sup>7</sup></b>  | <b>By Weight</b>  | 86.4-88.4%  | 79.3-81.8%   | 81.3-83.5%  | 80.64-83.70%  |
|  | <b>By Volume</b>  | 77.8-80.4%  | 67.0-68.5%   | 68.3-69.8%  | 71.32-74.49%  |
| <b>Volatile Organic Compounds<sup>7</sup></b>                            |                   | <250 g/l (2.08 lbs./gal.)                             | <250 g/l (2.08 lbs./gal.)                                | <250 g/l (2.08 lbs./gal.)                             | <250 g/l (2.08 lbs./gal.)                             |
| <b>Mixing Ratio</b>  |                   | 1:1 Base:Act. (by vol.)                               | 1:1 Base:Act. (by vol.)                                  | 1:1 Base:Act. (by vol.)                               | 1:1 Base:Act. (by vol.)                               |
| <b>Recommended Dry Film Thickness (DFT) Per Coat</b>                     |                   | 5-8 mils (125-200µ)                                   | 5-8 mils (125-200µ)                                      | 5-8 mils (125-200µ)                                   | 5-8 mils (125-200µ)                                   |
| <b>Wet Film to Achieve DFT (unthinned material)</b>                      |                   | 6.5-10.0 mils (162.5-250µ)                            | 7.5-12.0mils (187.5-300µ)                                | 7.5-12.0 mils (187.5-300µ)                            | 7-11 mils (175-275µ)                                  |
| <b>Theoretical Coverage at 1 mil DFT (25µ)</b>                           |                   | 1,250-1,290 sq.ft./gal. (30.7-31.7 m <sup>2</sup> /l) | 1,075-1,100 sq.ft./gal. (26.4-27.0 m <sup>2</sup> /l)    | 1,095-1,120 sq.ft./gal. (26.9-27.6 m <sup>2</sup> /l) | 1,145-1,195 sq.ft./gal. (28.2-29.4 m <sup>2</sup> /l) |
| <b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b> |                   | 130-220 sq.ft./gal. (3.2-5.4 m <sup>2</sup> /l)       | 115-190 sq.ft./gal. (2.8-4.6 m <sup>2</sup> /l)          | 115-190 sq.ft./gal. (2.8-4.6 m <sup>2</sup> /l)       | 120-200 sq.ft./gal. (3.0-4.9 m <sup>2</sup> /l)       |
| <b>Induction Period</b>  |                   | None required   | 30 minutes (60 min. < 65°F)                              | 15 minutes  | None required   |
| <b>Pot Life<sup>8</sup></b>  | <b>2 gallons</b>  | 2.5-3 hours at 75°F (24°C)                            | 2-4 hours at 70°F (21°C)<br>3-5 hours at 60°F (15°C)     | 2-4 hours at 70°F (15°C)<br>1-2 hours at 90°F (32°C)  | 2-4 hours at 70°F (21°C)                              |
|  | <b>10 gallons</b> | 2-3 hours at 75°F (24°C)                              | 2 hours at 75°F (24°C)<br>3 hours at 60°F (15°C)         | 2 hours at 70°F (21°C)<br><1 hour at 90°F (32°C)      | 2-3 hours at 75°F (24°C)                              |
| <b>Dry Times at 50% Relative Humidity</b>                                | <b>Tack-free</b>  | 6-8 hours at 70°F (21°C)                              | 6-8 hours at 70°F (21°C)<br>8 hours at 50°F (10°C)       | 4 hours at 70°F (21°C)                                | 6-8 hours at 70°F (21°C)                              |
|  | <b>Handle</b>     | 6-12 hours at 70°F (21°C)                             | 8-14 hours at 70°F (21°C)<br>10 hours at 50°F (10°C)     | 5 hours at 70°F (21°C)                                | 6-12 hours at 70°F (21°C)                             |
|  | <b>Recoat</b>     | 16 hours to 30 days <sup>9</sup> at 70°F (21°C)       | 16-72 hours at 70°F (21°C)<br>24-72 hours at 50°F (10°C) | 4 hours to 30 days <sup>9</sup> at 70°F (21°C)        | 16-72 hours at 70°F (21°C)                            |
| <b>Dry Heat Resistance</b>   |                   | 300°F (149°C), Color may shift above 150°F (66°C)     | 300°F (149°C), Color may shift above 150°F (66°C)        | 300°F (149°C), Color may shift above 150°F (66°C)     | 300°F (149°C), Color may shift above 150°F (66°C)     |
| <b>Maximum Immersion Temperature</b>                                     |                   | NA  | 120°F (49°C)   | NA  | NA  |
| <b>Safety Information</b>  |                   | See SDS   |  |   |   |

<sup>7</sup> Activated material.

<sup>8</sup> Pot life is affected by air temperature, amount of material activated and quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour). Final gloss maybe slightly higher for coating applied near the end of the pot life.

<sup>9</sup> If recoat time is extended, be sure the surface is clean and free of all contamination prior to coating. Actual environmental conditions may affect results, so a trial is suggested to ensure acceptable results.

The technical data and suggestions for use contained herein are correct to the best of our knowledge, and offered in good faith. The statements of this literature do not constitute a warranty, express, or implied, as to the performance of these products. As conditions and use of our materials are beyond our control, we can guarantee these products only to conform to our standards of quality, and our liability, if any, will be limited to replacement of defective materials. All technical information is subject to change without notice.



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Form: ARJ-1503  
Rev.: 071320