

Description	Two components surface tolerant high build polyamine cured epoxy primer / coating
Principal Characteristics	<p>Self priming surface tolerant coating for lower grade of steel preparation</p> <p>Particularly as maintenance coating for marine, steel structures, hulls and ballast tanks</p> <p>Excellent corrosion resistance</p> <p>Good flexibility and abrasion resistance</p> <p>Resistance to splash and spillage of a wide range of chemicals</p> <p>Compatible with various aged coatings</p> <p>Overcoatable with most types of coatings (epoxy-, polyurethane, chlorinated rubber-, alkyd modified acrylic)</p>
Recommended use	Special for maintenance coating with the minimum surface preparation when blasting are not permitted because of structure, health and safety reason
Specification data at 20 °C	
Gloss	Matt
Colour	Grey and Red brown
Specific gravity	1.50 ± 0.15 [g/mL]
Solids by volume	82 ± 2 %
Recommended	<p>Dry film thickness : 125-200 micron (depends on system and application method)</p> <p>Wet film thickness : 152 - 243 micron</p>
Coverage theoretical	6,56 m ² / litre - 125 micron; 4,1 m ² / litre - 200 micron
Drying time	<p>Touch dry : 6 Hours at 30 °C</p> <p>Hard dry : 20 Hours</p>
Potlife	6 Hours (after mixing components)
Full cure	7 days
Flash Point (DIN 53213)	Base = 31 °C, Hardener = 45 °C
Painting interval	Min : see table ; Max : see table
VOC	200 g/litre (base), 336 g/litre (hardener)
Service Temperature	<p>Continue : 100°C</p> <p>Periodic : up to 120°C</p>
Shelf Life	12 months (cool and dry place)

Surface Preparation

Substrate	Recommended for atmospheric exposure condition
Steel	blast cleaned to ISO-Sa2½ for excellent corrosion protection
Steel	power tool cleaned to ISO-St2 or blast cleaned to ISO Sa2 for good corrosion protection
Shopprimed steel	pretreated to SPSS-Pt3
Steel	Hydrojetted to VIS WJ2/3L
Steel existiing	Preparation SSPC Hand Toll And Power Tool
Existing epoxy and alkyd coating systems	Sufficiently roughened, dry and free from any contamination

Simacover EP Mastic 2411-00

Product Data Sheet

Last update: September 2021

Substrate	Recommended for immersion in seawater (resistant to Cathodic Protection in system)
Steel	blast cleaned to ISO-Sa2½
Steel with approved zinc silicate shopprimer	sweepblasted to SPSS-Ss or power tool cleaned to SPSS-Pt3

Suitable top coat : SIMACOVER EP TIECOAT, SIMATHANE GLOSS or SIMATHANE HB FINISH

Application instruction

Condition	Recommended		
Temperatur	Min 5°C, max 50°C		
Relative humidity	Max 85 %		
Substrate temperature	should be at least 3°C above dew point.		
Mixing ratio	Base : Hardener = 4 : 1 [by volume] temperature of the mixture should be above 15°C		
Thinner	Sima Thinner 44-00 should be added after mixing the components, and stir well before use preferable by means of mechanical mixer. Too much solvent result in lower sag resistance and slower cure.		
Method of application 1. Airless spray 2. Air Spray 3. Brush	Thinner	Nozzle Orifice	Nozzle Pressure
	Max 0-5 %	0.48-0.53 mm	15 Mpa (150 Bar / 2100 psi)
	5-10 %	1.8 - 2.0 mm	0.3-0.4Mpa(3-4Bar;43-7psi)
	0 - 5 %	-	-

Over coating table for SIMACOVER EP MASTICOAT for dft up to 150 microns

	Substrate Temperature	20°C	30°C	40°C
With epoxy coatings	Min. interval	9 hours	5 hours	3 hours
With polyurethanes	Min. interval	12 hours	6 hours	4 hours
With it self	Max. interval	9 months	6 months	3 months
With various epoxy- and polyurethane	Max. interval	3 months	1 month	1 month

- Surface should be dry and free from any contamination

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Over coating table for chlorinated rubber-, vinyl-, and alkyd paints :

Substrate Temperature	20°C	32°C	40°C
Min. interval	16 hours	8 hours	5 hours
Max. interval	10 days	7 days	3 days

- After exceeding of the maximum interval glossy finishes require a corresponding undercoat
- Surface should be dry and free from any contamination
- Best intercoat adhesion occurs when the subsequent coat is applied before the preceding coat is fully cured
- If this time is exceeded it may be necessary to roughen the surface

Packing and size instruction

Packing size (two packs product) : 5 and 20 litres

Storage

The product must be storage in accordance with national regulation. Preferred storage condition are to keep the containers in the dry space provided with adequate ventilation. The containers should be sealed tightly.

Safety Precaution

Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Ventilation shall be maintained from coating application until the completion of curing in order to remove residue of solvents and promote curing. Do not breathe the vapour or spray. This product is flammable. Keep away from sources of ignition. Do not smoke.

HEALTH AND SAFETY: For detailed information on the health and safety hazards and precaution for use of this product, please see the SAFETY DATA SHEET (SDS).

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