

PRODUCT DATA SHEET

CAPMASTIC ST

Epoxy surface-tolerant

CHARACTERISTIC Two component, modified epoxy, surface tolerant, suitable for application in high and low thicknesses with high content of active pigments (zinc phosphate). It is characterized by a high adhesion. The product can be used with Induritore Multiepox HS and Induritore Multiepox IN (during the winter season) It is characterized by a high adhesion.

USE Particularly suitable for a high protection against corrosion of steel surfaces, also on surfaces where it is not possible a perfect preparation. It can be used as primer or intermediate or undercoat/ finish both on new and undergoing maintenance surfaces, allowing to realize protective systems in a simple way. If used as a finishing, the final aesthetic effect on surface must be evaluated and approved, as well as the colour variation and the possibility of chalking in time.

TECHNICAL DATA

DESCRIPTION	VALUE
Specific weight (A+B)	1200-1300 g/l
Application temperature	< +120 °C
Flash point	27°C by Induritore Multiepox HS 29°C by Induritore Multiepox IN
Solid by volume (A+B)	80% +/-2 by Induritore Multiepox HS 80% +/- 2 by Induritore Multiepox IN
VOC	220 g/l by Induritore Multiepox HS 220 g/l by Induritore Multiepox IN
Brilliance	<5

THICKNESS AND YIELD	Induritore Multiepox HS or IN	Min.	Max	Recommended
Thickness of dry film (μm)	75	150	120	
Thickness of wet film (μm)	94	188	150	
Theoretical yield (m²/l)	10,6	5,3	6,7	
Theoretical yield (m²/kg)	8,5	4,2	5,3	

STORAGE Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR The range of colors can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.

PREPARATION OF SURFACE

General conditions: The better the level of preparation, the better the corrosion performance.

New steel

The surface must be clean and dry, free of oils and other contaminants.

Sandblasting Sa2,5 ensures the best anticorrosion performance; being Capmastic a surface tolerant product, it offers better performances than other products even when applied on surfaces mechanically cleaned at grade St3 or pressure washed grade Wa 2 free from any oil, grease, salt and calamine.

Treated surfaces

with shop primer: if undamaged, clean and free of dirt, oil, grease, salt and dry can be recoated otherwise perform as preparation for coated surfaces.

With primer: it can be painted if the substrate is clean and free of dirt, oil, grease,

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and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt).

With complete finishing coat: if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

Rusty coating: perform mechanical preparation St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer.

Localized maintenance: perform mechanical preparation St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

TOOLS

Spray, airless, roller, brush.

APPLICATION

Mix ratio in weight	100:13 Induritore Multiepoxy HS 100:12 Induritore Multiepoxy IN
Mix ratio in volume	100:17,5 Induritore Multiepoxy HS 100:16 Induritore Multiepoxy IN
Thinning	0-5% by Diluente S800
Induction time	35°C: 0' - 23°C: 10' - 15°C: 15' - <10°C 20'-25''
Time of use 23°C	2h Induritore Multiepoxy HS 2h Induritore Multiepoxy IN
Application condition	-5°C +40°C >3°C at dew point Relative humidity: <70%
Application by airless	Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi). Nozzle: 0,43 - 0,58 mm (0,021" - 0,023") Angle range: 40 - 80° Air pressure: Compression ratio 45:1 (pressure 150-180 kg/cm²)
Thinner for washing	Acetone per lavaggio

DRYING TIME

The given data must be considered as a rough guide. The drying time can be less effective or more, taking into account the applied thickness, ventilation, humidity on environment.

At temperatures below 15 ° C it is recommended to use Induritore Multiepoxy IN. In case of low temperatures and high humidity it is essential to respect the induction time indicated. There is no limit to the maximum time of over painting, however the best adhesion occurs when the application of the next layer is performed before the complete curing.

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Surface temperature	23°C	23°C
Out touch	45 minutes	4h
Dry touch	3 h	10h
Full catalysis	7 g	7g
Minimum time of over application	5 h	10h

RECOMMENDED FINISHES

Polyurethane, epoxy, vinyl, chlorinated rubber.

RECOMMENDED SYSTEM

Industrial and marine atmosphere

Product	Coat	Wet Thickness	Dry thickness
Epoxy zinc 2K	1	100	60
Capmastic ST	1	188	150
Pur car 51 HS	1	100	60
Total	3	388	270

Product	Coat	Wet Thickness	Dry thickness
Capmastic ST	1	188	150
Capmastic ST	1	188	150
Total	2	376	300

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary. This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.