PRODUCT DATA SHEET

CAPMASTIC 14
Epoxy high solid Surface-tolerant

CHARACTERISTIC

Two component epoxy product with high solid micaceous iron oxide, that can be applied on high thickness.
Capmastic 14 is surface tolerant product, characterized by high adhesion on different substrates; It can also be applied at low temperatures and are possible extended over-coating intervals. Particularly suitable for a long-lasting corrosion protection in aggressive environments.

USE

It can be used as a primer, intermediate or finish coat both on new and undergoing maintenance surfaces, allowing to realize protective systems in a simple way. It can be applied over organic and inorganic galvanizer or other porous substrates. If used as a finishing, the aesthetic final effect should be evaluated and approved, as well as the colour variation and the possibility of chalking in time.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Viscosity (DIN)	80-120 sec.	
Specific weight (A+B)	1400–1500g/l	
Operating temperature dry	<+ 120° C	
Flash point	27° C	
Solidi in volume	80±2% by Induritore Multiepox HS 80±2% by Induritore Multiepox IN	
VOC	330 g/l	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1500-1600 g/l	Internal PF3
Gloss	20-40	Internal PF6
Pot-life	Max 2 h with induritore HS	Internal PF7
Drying Time	To Touch: 10 h	Internal PF2

COLOUR

Ral 7005, Ral 7038.
The range of colors can be chosen in shades of RAL. Between one production and the other, tint may be slightly different (the product is not put in the same color).

THICKNESS AND YIELD

Induritore Multiepox HS or IN	Min.	Max	Recommended
Thickness of dry film, µm	150 µ	300 µ	200 µ
Thickness of wet film, µm	185 µ	375 µ	250 µ
Theoretical yield, m²/l	5,4	2,7	4,0
Theoretical yield, m²/kg	3,7	1,9	2,8

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.

PREPARATION OF SURFACE

The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.
A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.

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HOT GALVANIZED STEEL
It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner.
Alternatively, a light silica sandblasting is recommended.

NEW STEEL
the surface must be clean and dry, free of oils and other contaminants. Sandblasting Sa2½ (ISO 8501-1) with roughness profile Medium G (ISO 8503) ensures the best anti-corrosion performance.

SURFACES TREATED WITH SHOP PRIMER
if undamaged, clean and free from any dirt, oil, grease, salts and dry, it can be painted otherwise perform the preparation as for coated surfaces.

COATED SURFACES
with primer, if clean and free of dirt, oil, grease, salts and dry, and the application falls within the maximum re-coat time of the primer, it can be painted. If cleaning is required, perform a high pressure fresh water washing.
With full coating: if undamaged, compatible and non-chalky perform cleaning from oil and grease with detergent, then perform surface roughening followed by pressure washing to remove any dust and salts.
Rusty areas of the substrate and maintenance localized:
perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salts. Sandblasting Sa2 and Sa2 ½ increases the performance of the coating cycle. Round off the edges of the painting still well anchored and restore the system in the original layers and thicknesses.

TOOLS Spray, airless, roller, brush.

APPLICATION

Mix ratio in weight	100-10,8 - Induritore Multiepox HS 100:9,4 - Induritore Multiepox IN
Mix ratio in volume	100:16,6 - Induritore Multiepox HS 100:15 - Induritore Multiepox IN
Thinning	0-5% with Diluente S800
Induction time	35°C: 0' - 23°C: 10'- 15°C: 15'- <10°C 20'-25''
Tempo di utilizzo 23°C	Max 2h Induritore Multiepox HS Max 1h Induritore Multiepox IN
Application condition	-5°C +40°C >3°C at dew point Relative humidity: 85%
Application by airless	Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi.). Nozzle: 0,43 - 0,58 mm (0,017 - 0,023") Angle range: 40 - 80° Air pressure: Compression ratio: 45:1 (pressure 150-180 kg/cm^2)
Thinner for washing	Thinner Nitro NV 5000

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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 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.

Drying times with dry film thickness (DFT) 125 µ catalizzatore Multiepox HS.

Temperatura superficie			**10°C**	**23°C**	**35°C**	
Fuori polvere			8 h	4 h	2 h	
Asciutto al tatto			24 h	10 h	4 h	
Catalisi completa			14 g	7 g	2 g	
Tempo di ricopertura min.			24 h	10 h	4 h	
Tempo di ricopertura max			nn	nn	nn	

Drying times with dry film thickness (DFT) 125 µ catalizzatore Multiepox IN

Temperatura superficie	**-5°C**	**0°C**	**5°C**	**10°C**	**23°C**	
Fuori polvere	24 h	18 h	12 h	6 h	2,5 h	
Asciutto al tatto	48 h	28 h	18 h	12 h	5 h	
Catalisi completa	21 g	14 g	7 g	3 g	2 g	
Tempo di ricopertura min.	48 h	26 h	18 h	12 h	5 h	
Tempo di ricopertura max	nn	nn	nn	nn	nn	

RECOMMENDED FINISHES

Polyurethane, epoxy, vinyl, chlorinated rubber.

RECOMMENDED SYSTEM

Suitable for industrial environments and marine C5 M - high

Coat	**Product**	Coat	**Wet Thickness**	**Dry thickness**
1	**CAP ZINC 14**	**1**	95 µ	**60 µ**
2	**CAPMASTIC 14**	**1**	250 µ	**200 µ**
3	**PUR CAR 51 HS**	**1**	100 µ	**60 µ**
				320 µ

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.

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