Description:
A two pack high build mastic, 100% solids surface tolerant epoxy coating reinforced with chemically inert glass flake for application for enhanced durability and corrosion resistance. Excellent erosion resistance, abrasion resistance, toughness and outstanding impermeability. The coating produces high gloss and low friction surface. It also works as a top coat over SavesPast Metal Reclamation Putties for providing exceptionally smooth surfaces over applications requiring surface rebuilding and lasting protection.

Typical Applications
- Maintenance painting for Drilling Rigs and Platforms Fertilizer Plants, Chemical Factories, Refineries, Petrochemical units, Railway Bridges, Marine & Port Installations.
- Dedicated Immersion coatings for cargoes like Petroleum crude, products as also Aromatic Hydrocarbon solvents
- Outstanding Corrosion resistance in Interior of Steel Storage Tanks in Refineries, Petrochemicals, Fertilizers, Chemical and other plants.
- Excellent maintenance coating for offshore and onshore installation subject to highly humid and saline condition.
- Uses include steel structures in Industrial plants, bridges, tank exteriors, oil tanks, pipelines, marine atmosphere, Splash Zones, cooling towers, etc.
- Good resistance to spillage and fumes of acids, alkalis, fresh and salt water.

Product Features
- Superior Surface Wetting Properties and Corrosion Resistance
- High Performance Maintenance Coating for New or existing Steel
- Excellent Barrier for immersion or Splash zone & submerged surfaces
- Ideal maintenance coating over most well adhered aged coatings
- Improves the efficiency of fluid handling systems
## Typical Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Standard</th>
<th>Unit</th>
<th>Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>ASTM D 1544</td>
<td>~</td>
<td>Pearl</td>
</tr>
<tr>
<td>Appearance</td>
<td>ASTM D 1544</td>
<td>~</td>
<td>High Viscous liquid</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>ASTM D 1895 B</td>
<td>gm/cc</td>
<td>1.35</td>
</tr>
<tr>
<td>Mixing Ratio</td>
<td>~</td>
<td>kg</td>
<td>9 (R) : 1 (H)</td>
</tr>
<tr>
<td>Pot Life</td>
<td>IS 101</td>
<td>Minutes</td>
<td>25</td>
</tr>
<tr>
<td>Functional Cure Time</td>
<td>ASTM D 5895</td>
<td>hours</td>
<td>8</td>
</tr>
<tr>
<td>Compressive Strength</td>
<td>ASTM D 695</td>
<td>N/mm²</td>
<td>55</td>
</tr>
<tr>
<td>Tensile Strength</td>
<td>ASTM D 638</td>
<td>N/mm²</td>
<td>28</td>
</tr>
<tr>
<td>Flexural strength</td>
<td>ASTM D 149</td>
<td>N/mm²</td>
<td>54</td>
</tr>
<tr>
<td>Hardness</td>
<td>ASTM D 2240</td>
<td>shore A</td>
<td>80</td>
</tr>
<tr>
<td>Bond Strength</td>
<td>ASTM D 4541</td>
<td>N/mm²</td>
<td>12</td>
</tr>
<tr>
<td>Chemical Resistance</td>
<td>ASTM C 267</td>
<td>%</td>
<td>Excellent</td>
</tr>
<tr>
<td>Maximum Application Temp</td>
<td>VISUAL</td>
<td>°C</td>
<td>40</td>
</tr>
<tr>
<td>Coverage</td>
<td>~</td>
<td>Kg/Sq.mtr/ 0.5mm</td>
<td>1.389 m² / kg / 500 mic / 2 Coats</td>
</tr>
</tbody>
</table>

## Application Instructions

Proper surface preparation is critical to the long-term performance of this product. The exact requirements vary with the severity of the application, expected service life, and initial substrate conditions.

1. Clean, dry and abrade application surface. The more thorough the degree of surface preparation the better the performance of the application. If possible, it is recommended that the surface be grit blasted to a Near white Metal (SSPC-SP10/NACE No. 2) Standard. For less severe applications roughening the surface with hand tools is suitable.

   Note: For metals exposed to sea water or other salt solution, grit-blast and high-pressure-water-blast the area, then leave overnight to allow any salts in the metal to “sweat” to the surface. Repeat blasting to “sweat out” all soluble salts. Perform chloride contamination test to determine soluble salt content (should be no more than 40ppm).

2. Solvent cleaning with a residue-free solvent is recommended as the final step to aid in adhesion.

3. If flash rusting occurs, it must be removed from the application surface before applying the material. Flash rusting could be prevented by immediately applying a thin film of mixed material before the corrosion appears.

## Surface Preparations

1. Material temperature should be between 20 °C to 30 °C.

2. Add hardener contents to resin. Mix material vigorously until uniform in color. Be sure to mix along the bottom and sides of mixing container. Mix three to five minutes. Use a propeller-type Jiffy Mixer on an electric drill for large sizes and for small sizes mix thoroughly with screwdriver or similar tool. Note: It is strongly recommended that full units be mixed, as ratios are pre-measured. Keep propeller below liquid line, as additional air can be added to mixture, resulting in air bubbles on the surface of the finished product.
**Application Instructions**

**Application Method:**

WORKING CONDITIONS: Ideal application temperature is 55°F to 90°F. In cold working conditions, directly heat repair area to 100-110°F prior to applying epoxy and maintain at this temperature during product cure to dry off any moisture, contamination or solvents, as well as to achieve maximum performance properties.

1. Apply fully mixed material to 2 thin coats to the prepared surface using a short bristle brush. Ensure lack of pinholes or holidays on the substrate by using a low voltage, holiday detector will ensure a pinhole-free coating.

2. Immediately clean tools and any contaminated skin or clothing with soap and water.

**Note:** Use an approved, positive-pressure, supplied air respirator when welding or torch cutting near cured compound. **Do Not** use open flame on compound.

**Application Equipments:**

Brush / Airless Spray. Airless spray recommended for uniform and high film build.

Total output fluid pressure - 2500 - 3200 psi (176 – 225 kg/sq.cm)

**Limitation**

In common with all epoxies, this product may chalk on exposure. It may yellow with time. Discoloration also occurs under certain exposure conditions, but this is not detrimental to coating performance.

**Storage**

Store product in the unopened container in a dry location. Material removed from containers may be contaminated during use. Do not return liquid to original container.

Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.
Monarch warrants this product to be free from manufacturing defects and to meet the technical properties on the current Technical Data Sheet, if used as directed within shelf life. Satisfactory results depend not only on quality products but also upon many factors beyond our control. MONARCH MAKES NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE WITH RESPECT TO ITS PRODUCTS. The sole and exclusive remedy of purchaser for any claim concerning this product, including but not limited to, claims alleging breach of warranty, negligence, strict liability or otherwise, is the replacement of product or refund of the purchase price, at the sole option of Monarch. Any claims concerning this product must be received in writing within one (1) year from the date of shipment and any claims not presented within that period are waived by Purchaser. MONARCH WILL NOT BE RESPONSIBLE FOR ANY SPECIAL, INCIDENTAL, CONSEQUENTIAL (INCLUDING LOST PROFITS) OR PUNITIVE DAMAGES OF ANY KIND. Purchaser must determine the suitability of the products for the intended use and assumes all risks and liabilities in connection therewith. This information and all further technical advice are based on Monarch’s Present knowledge and experience. However, Monarch assumes no liability for providing such information and advice including the extent to which such information and advice may relate to existing third party intellectual property rights, especially patent rights, nor shall any legal relationship be created by or arise from the provision of such information and advice. Monarch reserves the right to make any changes according to technological progress or further developments. The purchaser of the product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with a full application of the product(s). Performance of the product described herein should be verified by.