



ULTRAMASTIC 157 HB

(Self-Priming Epoxy Mastic)

(Paints & Coatings)

HEAVY DUTY, HIGH PERFORMANCE

GENERIC CLASS: High-build, heavy duty two component epoxy maintenance mastic utilizing a unique type curing agent

PRODUCT DESCRIPTION: Self-priming high performance, heavy duty high build coating with superior adhesion characteristic to tightly rusted steel and most aged paints. It has excellent performance to hand or power tool surface preparation.

TYPICAL USES: Typical uses include exterior of tanks, pipelines, bridges, process equipment, structural steel expose to chemical, high humidity or salt water atmosphere. It is ideally recommended for repainting rusty steel refresher coat to most deteriorated coatings. It is also recommended for concrete floor coating and concrete tank lining.

LIMITATIONS: Not recommended for immersion service in acids, alkalies or solvents.

CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acids	NR	Fair	Very Good
Alkalies	NR	Good	Excellent
Solvents	NR	Good	Excellent
Salt Water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

NOTE: Aluminum color may discolor to gray in immersion service but will not impair coating performance.

TEMPERATURE RESISTANCE: (Dry Basis)

Sustained	:	180°F (82°C)
Intermittent	:	250°F (121°C)

FLEXIBILITY: Excellent. 1/2" Bend zuhr conical mandrel 5-7 mils film.

WEATHERING: Excellent.

THERMAL SHOCK: Unaffected 5 cycles: 32°F to 200°F.

ABRASION RESISTANCE: Fair

SUBSTRATES: Rusty steel, aged galvanized steel, or others as recommended.

TOPCOAT REQUIRED: Normally none required, but can be topcoated with most epoxies, chlorinated rubbers, vinyls, alkyds and others as recommended.

COMPATIBILITY WITH OTHER COATINGS: May be applied over most epoxies, inorganic and organic primers. Test patch is recommended for use over existing coatings.

CALCULATED VOLUME SOLIDS: 90%±2%

RECOMMENDED DRY FILM THICKNESS PER COAT:

5 mils (125 microns) minimum
7 mils (175 microns) for severe exposure

CALCULATED COVERAGE PER MIXED GALLON:

1,444 sq. ft. (36 sq. m./ li @ 25 microns)
289 sq. ft. @ 5 mils (7.2 sq. m./ li. @ 125 microns)
206.3 sq. ft. @ 7 mils (5.0 sq. m./ li. @ 175 microns)

NOTE: Assume loss factor when estimating job requirements at prevailing condition.

SHELF LIFE: 24 months minimum. Materials on stock should be turned upside down every 3-4 months.

COLORS: Aluminum, Buff, Gray, Blue, Green are standard. Other colors are available when required.

FINISH: Semi-gloss (Flat when weathered).

FLASH POINT: (Pensky-Martens Closed Cup)

Ultramastic 157 Part A	200°F (93°C)
Ultramastic 157 Part B	94°F (34°C)
Ultramastic Thinner	73°F (23°C)

SURFACE PREPARATION: Remove any oil or grease from surface to be coated with clean rags soaked in Ultracote Thinner #2 or tuluol.

STEEL:

For water immersion service: dry abrasive blast to a near white metal finish conforming to SSPC-SP10 with an anchor profile of 1-3 mils (25-75 microns)

For non-immersion service: subject to attack by chemical fumes, occasional spills and splashes at intermediate temperatures and on heavy marine exposures, dry abrasive blast per SSPC-SP6 (commercial blast cleaning).

For light marine and weather exposure service: clean per power tool or hand tool finish in accordance to SSPC-SP3 or SSPC-SP2 respectively.

CONCRETE: Do not coat concrete treated with hardening agents unless tests indicate satisfactory adhesion. Apply only when concrete has properly cured at 28 days unless steam curing has been done. Do not apply if surfaces are not acid etched or swept blasted.

WELDING: Welding should precede coating. In the event welding or flame cutting is performed on metal already coated with this product, do so in accordance with the latest instructions in USA Standard Z49:1 "Safety in Welding and Cutting". All welded, burned or otherwise damage areas should be cleaned to base metal, prepared and recoated as specified.

MIXING: Mix separately then combine and mix in the following proportions:

	<u>2 Gal.Kit</u>	<u>10 Gal.Kit</u>
Ultramastic 157 Part A	1 Gal.	5 Gal.
Ultramastic 157 Part B	1 Gal.	5 Gal.

THINNERS: Use Ultramastic Thinner for hot weather and Ultracote Thinner #15 or 21 for cold weather. Thin up to 25% by volume.

POT LIFE:

- 4 hrs. @ 75°F (24°C) when thinned @ 25%.
- 2 hrs. @ 75°F without thinner.
- 1 hr. @ 90°F (32°C) without thinner.

APPLICATION TEMPERATURES:

Material	:	50-90°F (10-32°C)
Surfaces	:	40-130°F (5-54°C)
Ambient	:	40-100°F (4-38°C)
Humidity	:	0-90% (Ideal: 35-80%)

Do not apply when the surface temperature is less than 5°F (2°C) above the dew point.

SPRAY: Use adequate air volume for correct operation. All spray equipment should be thoroughly clean and hose, in particular, should be free of old paints and other contaminants. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

SPRAY EQUIPMENT:

CONVENTIONAL SPRAY: Use 1/2" minimum I.D. material hose. Hold gun 8-10 inches perpendicular to the surface.

<u>Mfr. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	67	67B
DeVilbiss P-MBC or JGA	D	64
Approximately .086" I.D.		

AIRLESS SPRAY: Use 3/8" minimum I.D. material hose. Hold gun 12-14 inches perpendicular to the surface.

BRUSH OR ROLLER: Use clean, short, natural bristled brush or medium nap roller. Brush or roller application may result in non-uniform bronze color for aluminum color.

<u>Mfr. & Gun</u>	<u>Pump</u>
DeVilbiss JGB-507	QFA-514
Graco 205-591	President 30:1, Bulldog 30:1
Binks Model 500	Mercury
Teflon packings are recommended. Use a .023" to .027" tip with 2,400 psi.	

DRYING TIME:

Between Coats:	6 Days @ 40°F (4°C)
	3 Days @ 60°F (16°C)
	14 hrs @ 75°F (24°C)
	8 hrs @ 90°F (32°C)

DRYING TIME: (cont.)

Final Cure: 20 Days @ 40°F (4°C)
10 Days @ 60°F (16°C)
5 Days @ 75°F (24°C)
3 Days @ 90°F (32°C)

STORAGE CONDITION:

Temperature : 45-110°F (7-43°C)
Humidity : 0-100%

PACKAGING:

Gallon (3.785 liters)
Pail (4 & 5 Gallons)

CLEAN-UP: Use Ultracote Thinner #2 or xylol.

SAFETY INFORMATION: This product (and any recommended thinners) contains solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. Keep away from sparks, heat and open flame and use necessary safety equipment such as air mask, non-sparking tools and ladders, etc. When working in tanks, rooms and other enclosed spaces, adequate ventilation must be provided. Keep out of reach of children.

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