



TRIMITZTIC 480

Surface Tolerant Epoxy (Epoxy Mastic)

Product Description	High solid polyamide cured epoxy coating.									
Recommended Use	High performance epoxy mastic (surface tolerant epoxy) for general maintenance coating which can be applied to new or old steel and resists to splash / spillage of a wide range of chemicals.									
Characteristics	<ul style="list-style-type: none"> • Surface tolerant coating for lower grade of steel surface preparation. • Excellent corrosion resistance and good flexibility. • Resists of high humidity and moisture. • High performance self-priming topcoats. • Compatible with various aged coatings. • Can be applied over most existing coatings. • Not recommended to immersion in acids and alkali's. 									
Physical Data	Color	Available On Request								
	Gloss level	Semi-Gloss								
	Volume Solid	Approx. 84%								
	Dry Film Thickness	100 - 200 microns per coat								
	Number of Coat	1 or 2								
	Theoretical Coverage	5.60 sq.m/ltr for 150 microns								
	Temperature Resistance	<table> <tr> <td>Continuous</td> <td>: 93°C (dry)</td> </tr> <tr> <td></td> <td>22°C (wet)</td> </tr> <tr> <td>Intermittent</td> <td>: 175°C (dry)</td> </tr> <tr> <td></td> <td>22°C (wet)</td> </tr> </table>	Continuous	: 93°C (dry)		22°C (wet)	Intermittent	: 175°C (dry)		22°C (wet)
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	VOC	168 g/ltr								
	Flash Point	<table> <tr> <td>Base</td> <td>: 55°C</td> </tr> <tr> <td>Hardener</td> <td>: 29°C</td> </tr> </table>	Base	: 55°C	Hardener	: 29°C				
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	Shelf Life	At least 12 months								
	Pack Size	<table> <tr> <td>10 litres unit</td> <td>Base : 5 litres , Hardener : 5 litres</td> </tr> <tr> <td>20 litres unit</td> <td>Base : 10 litres , Hardener : 10 litres</td> </tr> </table>	10 litres unit	Base : 5 litres , Hardener : 5 litres	20 litres unit	Base : 10 litres , Hardener : 10 litres				
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Surface Preparation	Steel									
		<ul style="list-style-type: none"> • Dry abrasive blast in accordance with ISO - Sa 2 or SSPC - SP 6 "Commercial". • Blast to achieve an anchor profile of 25 microns as determined with a Keane Tator Surface Profile Comparator. • Remove abrasive residue or dust from surface. • However when this is impossible, can be applied over mechanically cleaned surface, hand tool or power tool to St 2 or St 3. • Old coating system, sufficiently roughened, cleaned and dry. 								
	Aluminum and Galvanizing									
		<ul style="list-style-type: none"> • Light abrasive blast 								
	Concrete									
		<ul style="list-style-type: none"> • Abrasive blast to ASTM D 4259 								

**TRIMITZTIC 480****Surface Tolerant Epoxy (Epoxy Mastic)**

Application Data	Application Methods	
	Airless Spray	
	Nozzle Tip	0.46 - 0.58 mm (0.018 - 0.023 inch)
	Nozzle Pressure	10 MPa (approx. 1400 psi)
	Conventional Spray	
	Nozzle Tip	1.8 - 2.0 mm (0.071 - 0.079 inch)
	Nozzle Pressure	0.3 MPa (approx. 43 psi)
	Mixing Ratio By Volume	Base : Hardener = 1 : 1
	Thinner	Thinner Trimitz 920
	Cleaner	Thinner Trimitz 930
	Surface Temperature	Should be 10°C - 49°C, at least 3°C above the dew point to prevent condensation
	Drying Time	
	Touch Dry	5 hours at 25°C, 3 hours at 32°C
	Through Dry	16 hours at 25°C, 8 hours at 32°C
	Overcoating	
	Minimum	12 hours at 25°C, 7 hours at 32°C
	Maximum	3 months (roughened and dry)
	Full Cure	7 days
	Pot Life	2 hours at 25°C, 1 hour at 32°C
System Compatibility	Primer	
	• Trimitz zs 87	
	Topcoat	
	• Trimitzpoxy Finish 466	
	• Trimitzthane Gloss 580	
	For other suitable primers or topcoats, please consult Trimitz Protective Coating.	
SAFETY PRECAUTION	<p>Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use.</p> <p>Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard.</p> <p>Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.</p>	
DISCLAIMER	<p>The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.</p>	