

# Sam mastic Alu 80

## Product description.

A high-build, Two-component, Polyamine-cured epoxy coat with excellent anticorrosive properties.

## Characteristics

- Excellent abrasion and impact resistance.
- Excellent anti corrosion properties due to aluminum Pigments.
- Designed for new construction and maintenance applications
- Surface tolerant and good adhesion to St3 prepared steel substrates.
- Compatible with most aged coatings with Excellent workability.
- Can be used with water jetting surface preparation.
- Compatible with well-designed cathodic protection system.

## Physical properties.

Colour            Silvergrey  
Texture           Semi-gloss

### Mixing and application Information

|                      |  |
|----------------------|--|
| Number of components | Two  |
| Mixing ratio         | By Volume, base to hardener: 75 / 25   |
| Specific gravity     | Approx. 1.45 g/ml  |
| Volume solids        | 80±2%   Tested acc. ASTM D 2369  |
| VOC (Supplied)       | Approx. 150 g/liter  |
| Flashpoint           | >25°C  |
| spray                | Airless spray Recommended<br>Pressure at nozzle: 180 - 250 bar. Nozzle size: 0.41 - 0.58 mm.<br>Spray angle: 40 - 80 degrees.<br>Thinning Ratio: 0 - 5%. |
|                      | Convention Air spray<br>Thinning Ratio: 0 - 10%.   |
| Brush                | Suitable for stripe coat and touch up.<br>Thinning Ratio: 0 - 10%  |
| Roller               | Suitable for stripe coat and touch up.<br>Thinning Ratio: 0 - 10%.   |
| Thinner/Cleaner      | SAM Thinner No. 1<br>Thinning should only be added after the two components have been thoroughly mixed.  |
| Pot life             | 120 min at 25 C°   |

## Recommended film thickness range

|  |                           |                          |
|--|---------------------------|--------------------------|
| Dry film thickness per coat (µm)               | 100 – 300 µm              | ASTM D1186<br>ASTM D1212 |
| Wet film thickness per coat (µm)               | 125 – 375 µm              |                          |
| Theoretical spreading rate (m <sup>2</sup> /L) | 8 - 2.6 m <sup>2</sup> /L |                          |

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### Surface Preparation

#### Blast Cleaning

- Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion,
- Surface shall be treated in accordance with ISO, ASTM or SSPC standards.
- The abrasives shall be free from oil, grease, moisture, chloride contamination, etc. and comply with ISO 8504-2 and SSPC AB1.
- The surface roughness shall be complied with ISO 8503 and ASTM D4417 with roughness between 40µm: 70µm.

|              | minimum                   | Recommended                  |
|--------------|---------------------------|------------------------------|
| Carbon steel | ISO 8501-1 Sa 2, SSPC-SP6 | ISO 8501-1 Sa 2½, SSPC-SP10. |

#### Power Tool Cleaning

- The Surfaces must be clean, dry and free from oil and other contamination.
- Surfaces shall be treated in accordance with ISO 8504-3.
- Power-tool cleaning to min. St 2, SSPC-SP2, and St 3, SSPC-SP3 is preferred.
- Feathering the coated surface "**decreasing the edge thickness of a coat film**".

#### Water Jetting

- Water jetting in accordance with ISO 8501-4 and SSPC
- Flash rust degree is recommended to not exceed M (medium) and preferred to be L (light).

|             | Recommended         |
|-------------|---------------------|
| Atmospheric | Wa 2 or SSPC-WJ3.   |
| Immersion   | Wa 2.5 or SSPC-WJ2. |

#### Coated Substrates

- The surface shall be papered to paint in accordance with ISO 8504, ISO12944-4 and ASTM D3276
- All surfaces must be clean, dry and free from contamination.
- For aged coated substrates, a fine abrasive should be utilized to roughen the surface to ensure coating adhesion.
- It is important to check that the selected paint system is compatible with the coated substrates before application.

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### Drying and recoating information

| Substrate temperature | 10°C     | 23°C       | 30°C       |             |            |
|-----------------------|----------|------------|------------|-------------|------------|
| Touch dry             | 6 Hours  | 3 Hour     | 2 Hour     | ASTM D 1640 |            |
| Dry to handle         | 20 Hours | 12 Hours   | 10 Hours   |             |            |
| Full cure             | 10 Days  | 7 Days     | 5 Days     |             |            |
| Dry to recoat         | Min.     | 24 Hours   | 15 Hours   |             | 12 Hours   |
|                       | Max      | Indefinite | Indefinite |             | Indefinite |

The drying and curing periods are established by subjecting the product to controlled temperatures and a relative humidity level that does not exceed 85%, and at average DFT range for the product.

### Application conditions

- Avoid the formation of moisture on the surface, it is recommended that the temperature of the substrate remains at least 3°C higher than the dew point of the surrounding air, during painting process and until hard dry of the paint. It is important to take measurements of the temperature and relative humidity in the area surrounding the substrate according to ISO 8502-4.
- It is recommended to not exceed the surface temperature of approximately 45°C, as this can lead to the formation of dry-spray, pinholes, and sagging.
- For optimal results, it is important to mix the product thoroughly, making sure to combine the base and hardener in the recommended ratio.
- Thinning should only be added after the two components have been thoroughly mixed.
- To achieve the best results, it is advised to follow the product's TDS recommendations for thinning. Over-thinning the product can cause sagging and may also result in a weaker paint film.
- When working in small, cramped, confined spaces, it is important to ensure sufficient ventilation during both application and drying time.
- It is important to monitor the temperature of the paint, as it can impact its viscosity. To achieve the desired film thickness, it may be necessary to control thinning in order to reach the appropriate viscosity, for additional information, please get in touch with your Local SAMCO office.

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## Safety Precautions

- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes.
- Avoid inhalation of spray mist, it is important to take appropriate precautions. Skin contact should also be avoided, and any spills should be promptly cleaned up using soap, water, and a suitable cleanser. If the product comes into contact with the eyes, they should be thoroughly flushed with water and medical attention should be sought immediately.
- To ensure safe handling and use, please follow the guidelines below:
  - Wear appropriate personal protective equipment, such as gloves, eye protection, and respiratory protection, when handling or using this product.
  - Avoid direct skin contact and inhalation of dust, mist, or vapor.
  - If skin contact occurs, immediately wash the affected area with soap and water.
  - If the product comes into contact with the eyes, flush them thoroughly with water and seek medical attention immediately.
  - Use this product in a well-ventilated area to minimize the risk of inhalation.
  - Store the product in a cool, dry place, away from sources of heat or ignition.
  - Keep the product out of reach of children and animals.
  - Follow all applicable regulations and guidelines for handling, transportation, and disposal of this product.

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## Storage and shelf life

Ensure compliance with national regulations, proper storage guidelines must be followed for the product. The cans should be stored in a well-ventilated area that is dry, cool, and kept away from any heat or ignition sources. It is important to ensure that the cans are tightly closed at all times to maintain safety.

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## Disclaimer

All information in this document has been prepared to the best of SAMCO's knowledge, based on laboratory testing and practical experience to ensure good workmanship. However, the responsibility for executing the work stays with the applicator/ contractor/sub-contractor. SAMCO products are used under conditions beyond SAMCO's control. Users should always consult SAMCO for specific guidance on the general suitability of this product for their needs and specific application practices. SAMCO reserves the right to change the given data without further notice.