

## TECHNICAL DATA SHEET

# PERMAMASTIC PI 85

## SURFACE TOLERANT EPOXY MASTIC – PRIMER/INTERMEDIATE

<b>DESCRIPTION:</b>	PERMAMASTIC PI 85 – A two component, high build, surface tolerant modified polyamide cured epoxy pigmented with micaceous iron oxide (MIO), aluminium as inert extenders. A version without MIO is also available in the same product with a limited range of colors.	
<b>RECOMMENDED USE:</b>	For application on to hand or mechanically prepared steel surfaces giving excellent wetting and adhesion characteristics. Can be used as primer/intermediate for high performance Epoxy - Polyurethane systems.	
<b>RESISTANCE TO:</b>	Moisture – Excellent Abrasion – Excellent Aliphatic Solvents – Excellent	Weather – Excellent (subject to chalking) Petroleum Solvents – Excellent

### PRODUCT INFORMATION:

Colour:	Dark grey(MIO) / Limited range of colors(without MIO)
Finish:	Matt
Volume solids %:	75 ± 3 % (ASTM-D2697-86)
V.O.C.:	210 g/l (NB. – Thinning will affect VOC compliance and volume solids)
Typical thickness:	100 - 250 microns dry film thickness
Theoretical coverage:	7.5 m <sup>2</sup> /ltr. @ 100 microns dft
Density:	1.60 ± 0.1 g/cc (mixed)
Flash point:	Base : 46°C C/A : 25°C
Mixing ratio:	3 : 1 by volume
Shelf life:	12 months from the date of manufacture
Pot life:	1 hour @ 35°C
Pack size:	Comp. A – 15 liters + Comp. B – 5 liters = 20 liters

<b>FILM THICKNESS AND SPREADING RATE:</b>	<b>MIN.</b>	<b>MAX.</b>	<b>UNIT</b>
Dry film thickness	100	250	µm
Wet film thickness	133	333	µm
Spreading rate	7.5	3	m <sup>2</sup> /l (theoretical)

This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.

**SERVICE TEMPERATURE:** 120°C maximum dry

**RECOMMENDED THINNER:** Thinner No.5 (5%)

### DRYING & CURING TIME:

<b>SUBSTRATE TEMPRATURE</b>	<b>15°C</b>	<b>23°C</b>	<b>35°C</b>
Touch dry	4 hours	3 hours	2 hours
Dried to over coat (minimum)	16 hours	12 hours	8 hours
Hard dry	48 hours	36 hours	24 hours
Fully cured	7 days	7 days	7 days

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### SURFACE PREPARATION:

Remove all oil and grease in accordance with SSPC-SP1. Manually prepared surfaces should be prepared in accordance with SSPC-SP2 or SSPC-SP3. For more severe exposure, conditions blast cleaning to SSPC-SP 7 may be required. Abrasive blast clean to Sa 2 ½ BS7079:Part A1:1989. Average surface Profile 35 - 75 microns.

### RECOMMENDED COATING SYSTEM:

Primer/Intermediate coat:	PERMAMASTIC PI 85
Topcoat:	PERMATHANE T 137

Note: The above mentioned is a generally used system for steel structures, and if any alternative systems are required, please contact the KPC's technical team.

### RECOMMENDED APPLICATION METHODS:

Airless spray, conventional spray, roller (short pile only), brush

### APPLICATION EQUIPMENT DETAILS:

#### AIRLESS SPRAY:

Nozzle Size: 0.45mm (18 thou)  
Fan Angle: 40°  
Operating Pressure: 115kg/cm<sup>2</sup> (2200 psi)

#### CONVENTIONAL SPRAY:

Nozzle Size: 1.27mm (50 thou)  
Atomising pressure: 2.8kg/cm<sup>2</sup> (40 psi)  
Fluid Pressure: 0.7kg/cm<sup>2</sup> (10 psi)

### APPLICATION CONDITIONS AND OVER COATINGS:

This material should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C. At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired. Application at ambient air temperatures below 5°C is not recommended.

### HEALTH AND SAFETY:

Please observe the precautionary notices displayed on the container. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Consult Product Health and Material Safety Data Sheet for information on safe storage, handling and application of this product.

**Disclaimer:** The information in this document is given to the best of KPC Paint's knowledge that based on laboratory testing and practical experience Products are often used under conditions beyond KPC's control and KPC Paints cannot guarantee anything but the quality of the product itself.

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