## **MANOR** PRODUCT DATA SHEET



## **PROMASTIC 600 CT (maintenance coating)**

## **INTENDED USE**

	ARTICLES - that are not part of a building structure (and therefore are outside the scope of the building products VOC Product Directive) Designed particularly as a mid sheen maintenance coating for corroded steel associated with exteriors of tanks and pipework, process plant, towers, bridges etc. It is a high performance corrosion and chemical resistant two pack epoxy coating for new and old steelwork. For exterior applications where colour and gloss retention is important Promastic 600CT must be overcoated with Manor 2 Pack Acrylic Polyurethane because epoxy systems discolour and chalk within 12 months when exposed to UV light. The main features are:
	<ul> <li>adhesion promoting coating for use on marginally prepared surfaces (a surface where only minimal cleaning and preparation is possible)</li> <li>-can be applied to damp steel surfaces which have been cleaned by water jet with no reduction in performance</li> <li>low temperature cure down to -5C</li> <li>superb high build primer and /or intermediate and/or one coat finish for high film build specifications</li> <li>applied at 150 microns d.f.t. will give up to five years life to first maintenance in most exposures. Achieveable with one coat application by airless/air assisted airless spray</li> <li>applied at 250 microns d.f.t. will give up to ten years life to first maintenance in most exposures. More than one coat will be necessary to achieve this higher film</li> </ul>
	See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.
SUITABLE SUBSTRATES AND PREPARATION	Untreated steel, for best results blast clean prior to painting to SA 2 1/2, otherwise manually abrade using powered hand tools and abrasives to ST2. GRP thoroughly abrade the surface prior to painting.
	Previously painted steel; remove rust back to sound metal. Remove loose or flaky paint. Bring forward by patch priming. Sound previously painted surfaces should be lightly abraded prior to application in order to promote adhesion.
	Remove dust. Remove oil or grease with Panel Cleaner. If using a waterborne degreaser remove fully. Test a small area prior to painting and assess adhesion.
	Galvanised steel; abrade and pre-treat with Manor 1 Pack Etch Primer in accordance with data sheets for these products.
	When used as a maintenance coating for industrial plant, external surfaces of tanks and pipework it is sometimes not possible to prepare the surface as well as it would be on a new build situation. In these cases clean the surface and after successfully testing a small area apply Promastic with brush/roller. Whilst Promastic is far more tolerant of less than ideal surface preparation than most other paints, the more preparation undertaken the better will be the end result.
	Other substrates; seek advice from Manor Coating Systems Technical Department
AVAILABILITY	Most BS and RAL colours available from the Manormix Scheme in 5 litre containers
	The accuracy of the colour match will only be approximate due to the product composition.
	Epoxies that are not topcoated will chalk, fade and may yellow and darken. The yellowing tendancy is particularly noticeable in pastel colours.

PRODUCT INFORMATION	Composition	Two pack epoxy cured with a polyamidoamine adduct containing pigme extenders and modified zinc phosphate anti-corrosive pigment.			
(TYPICAL FIGURES)	Volume Solids	53% mixed unthinned			
	Weight Solids	65% mixed unthinned			
	VOC content		415 g/litre unthinned.		
	Supply Viscosity	3 poise at 20C			
	Typical film thickness	One coat can be applied as follows: Airless spray, unthinned, 150 microns dry film thickness (approxin 300 microns wet film thickness) Brush / roller, unthinned, 50 microns dry film thickness (approxim 100 microns wet film thickness)			
			ats will depend on the area o sed as a primer or finish.	f end use and whether the	
		Typically: 150 microns dry film thickness when used as a primer under 2 Pack Acrylic Polyurethane for inland exposure areas not subject to harsh chemicals 300 microns dry film thickness when used as a primer under 2 Pack Acrylic Polyurethane for coastal exposure areas or those subject to harsh chemicals 300 microns dry film thickness when used as a primer finish on plant and equipment			
			Im thickness when used as a l interior surfaces and 150 mi ırfaces		
	Theoretical coverage	<ul><li>3.3 sq metres/litre at 300 microns wet film thickness</li><li>9.9 sq metres/litre at 100 microns wet film thickness</li></ul>			
	Dry heat resistance	120 C Continuous high temperatures will darken the film			
	Flash Point	Within the range 21-31 C			
APPLICATION DETAILS	PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE				
	Mixing	4 parts Promastic Base to 1 part Promastic Hardener by volume. Mix for at least 5 minutes to ensure base and hardener are fully incorporated unless using 'mix at the tip' spray equipment.		dener are fully	
		Do not use other	hardeners or accelerators w	ith Promastic.	
	Viscosity Pot Life	Once mixed the	product has a workable pot li	ble pot life of approximately 6	
	Airless spray: cold heated	hours dependent on temperature. Typical tip size 13-18 thou (0.33-0.48mm) Typical fluid pressure 2500 p.s.i. Not recommended			
	Conventional spray	After adding hard	After adding hardener and stirring thin with up to 15% Manor 2 Pack		
	Brush Roller	Epoxy Thinner. E Ready for use wl	Build up coats to required film hen mixed	n thickness.	
	Thinner	2 Pack Epoxy Thinner			
	Film thickness per coat		Dry	Wet	
		Minimum	75 microns (airless)	150 microns (airless)	
		Maximum	125 microns (airless)	250 microns (airless)	

## DRYING AND RECOATING

Approximate drying times at 100 microns d.f.t.

	<u>Substrate</u>	Substrate Touch Dry		ing times			
	temperature		Minimum	Maximum			
	10C	2 hours	6 hours	2 days (see note)			
	20C	1 hour	3 hours	2 days (see note)			
	Note	Full chemical cure	Full chemical cure is achieved after 3 days at 20 C				
	Environmental conditions	above the dew po that the surface is	The air temperature must be above -5 C with a surface temperature 3 C above the dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur during application or drying.				
		Drying times will be significantly extended in cold conditions.					
		Curing will slow down or stop if the temperature falls below $-5$ C a may not resume if the film is allowed to pick up moisture.					
		Do not apply to ex the next 4 hours.	Do not apply to external surfaces if the forecast is for rain to fall within the next 4 hours.				
	Overcoating / repainting	recommended. If required a furthe	In exposed windy conditions a minimum air temperature of 3 C is recommended. If required a further coat of the product may be applied or 2 Pack Acrylic Polyurethane may be applied.				
			drying between coats it is in hove sheen and improve inte				
SHELF LIFE	Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.						
SAFETY PRECAUTIONS	Refer to Manor Safety Data Sheet						
LIMITATIONS	The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not consitute a specification.						
	A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology. In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.						
	References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.						
	This data sheet super	This data sheet supercedes all previous issues.					
REFERENCES	Amended date: Nover	nber 27, 2012	Reference and number:PF	R-maintenance- 7			