



## Protectomastic TIO Coating XL

### USES

An ideal high build surface tolerant anticorrosive coating specially designed for use on structures, exterior of pipelines, equipments, valves and ducts in industries having aggressive atmospheres and high level of process corrosion.

### SCOPE

An ideal maintenance coating having low VOC, which cures to have improved flexibility. It can be applied over manually cleaned MS or GI surfaces as well as over most aged coatings during maintenance painting of various industries.

#### PRODUCT DATA

<b>Type :</b>	Two Pack surface tolerant epoxy
<b>Composition :</b>	Epoxy Resin cured with aliphatic amine hardener, reinforced with anticorrosive pigments
<b>Mixing Ratio:</b>	Base: catalyst; 4:1
<b>Pot Life:</b>	1- 2 hours
<b>Application :</b>	Brush, Airless spray
<b>Recommended DFT :</b>	100- 150 microns per coat
<b>Recommended WFT:</b>	119- 179 microns per coat
<b>Theoretical Spreading Rate :</b>	5.6 - 8.4 sq. mtr./ltr.
<b>Drying Time :</b>	
TOUCH	: 2-3 hours @ 30° C
HARD DRY	: overnight
<b>Overcoating Interval :</b>	
MIN	: overnight
MAX	: one week
<b>Colour :</b>	Limited shades
<b>Finish :</b>	Egg-shell
<b>Packing :</b>	20 Ltrs.
<b>Thinner:</b>	Thinner 844
<b>Storage Life :</b>	Upto 12 months as long as the sealed containers are kept under cover in a dry place under normal temperature conditions.

#### RESISTANCE GUIDE

##### Chemical Resistance :

EXPOSURES	SPLASH & SPILLAGE	MILD FUMES / OUTDOOR RESISTANCE
Acids	Good	Very Good
Alkalis	Very Good	Very Good
Solvent	Very Good	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

**Note-1:** Not recommended for strong alkalis or for immersion services

**Note-2:** Protectomastic TIO Coating XL as part of the coating system is recommended for areas as per ISO 12944-C5 (I)

##### Temperature Resistance :

Continuous	: 90° C
Intermittent	: 120° C

**Weatherability:** Excellent with top coats

**Flexibility :** Excellent

**Abrasion Resistance :** Excellent

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**SURFACE PREPARATION**

**Steel:** Remove grease, oil and other contaminants preferably by Solvent Cleaning to SP 1. Abrasive blast clean to a minimum of SSPC SP10. For severe corrosive conditions, blast to SSPC SP 5 with a surface profile not exceeding 35- 45 microns. If blasting is not practical, make full use of mechanical tools along with manual chipping and wire brushing to remove loose rust and scale to SSPC SP 2 / SP3. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. The surface should be clean and dry before application of primer. Hydro-blasting for maintenance structures is preferred choice where there are heavy deposits of contaminants. Ultra-high pressure hydro-blasting equivalent with light flash rusting as per standards NACE NO. 5 or SSPC SP 12- WJ2 and NV2 as referred in SSPC vis-5 pictorial standard.

**APPLICATION**

Stir the components thoroughly and then mix the base and catalyst in recommended proportion to uniform consistency. Allow it to mature for 10 minutes and stir again before use and during application. Brush : Apply preferably without thinning. However, if required during application, add upto 5% Thinner 844. Brushing is recommended for touching up small areas only.

Airless Spray : Apply preferably without thinning. However, upto 5-7% Thinner 844 may be added if absolutely essential depending on conditions. Use any standard equipment having pump ratio not less than 56:1. Tip size : 0.45 - 0.58 mm. Tip Pressure : not less than 176 Kg / cm<sup>2</sup> [2500psi]

**TYPICAL PAINTING SPECIFICATIONS**

Surface	1st Coat	2nd Coat	3rd Coat
Steel	Protectomastic TIO Coating XL	Protectomastic TIO undercoating	Bergerthane PU High Gloss Enamel
Steel	Protectomastic TIO Coating XL	Epilux 155 /Epilux 4 HB/ Epilux 950 Super	Epilux 4 CR Enamel/ Bergerthane Finish
Galvanised Iron	Protectomastic TIO Coating XL	Bergerthane PU High Gloss Enamel or BR PU HG Enamel	Bergerthane PU High Gloss Enamel or BR PU HG Enamel

**Precaution :**

1. Do Not apply in rain, fog or mist and when the surface temperature is 50°C and above.
2. Freshly mixed material must not be added to that which has been mixed for sometime.
3. Do not apply in temperature below 10° C and relative humidity above 85%.
4. Clean all equipment with Thinner 844 immediately after use.
5. Do not apply when the substrate temperature is less than 3°C than the dew point temperature

**DISCLAIMER**

The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.

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