

## Jotamastic 85

### Product description

A multi-purpose, robust and efficient, surface tolerant primer that can be used on multiple application areas in different temperatures with short recoating intervals. A two-component epoxy mastic coating, building on more than 35 years of anti-corrosion protection experience. It is a high solids product. Can be used as primer in atmospheric and immersed environments. Suitable for properly prepared carbon steel, galvanized steel, stainless steel, aluminum and a range of aged coating surfaces. It can be applied at subzero surface temperature.

### Typical use

General:  
Primarily designed for maintenance and repair.

Marine:  
Exterior and interior areas, including outside hulls, superstructures and decks.

Protective:  
Recommended for offshore environments, refineries, power plants, pipelines, bridges, buildings, mining equipment and general structural steel.

### Approvals and certificates

Certified in accordance with IMO Res.215(82) – PSPC Water Ballast Tanks  
Grain Cargo Contamination testing, Newcastle Occupational Health  
Approved for use according to ANSI/AWWA C210/15 - Liquid-Epoxy Coatings and linings for Steel Water pipes and fittings - for areas where the coating is not in contact with potable water.

Additional certificates and approvals may be available on request.

### Colours

aluminium, aluminium red toned, grey, red, off-white

### Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	72 ± 2 %
Gloss level (GU 60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	31 °C
Density	calculated	1.4 kg/l

Region	Regulation	Test Standard	VOC Value
US	CARB(SCM)2020 / SCAQMD rule 1113	US EPA Method 24	247 g/l
Hong Kong	Air Pollution Control (VOC) Regulation	US EPA Method 24	247 g/l
EU	European Paint Directive 2004/42/CE	Calculated	260 g/l
EU IED	Industrial Emission Directive 2010/75/EU	Calculated	260 g/l
Korea	Korea Clean Air Conservation Act	KS M ISO 11890-1	293 g/l

China GB 30981-2020 Limit of harmful substances of industrial protective coatings GB/T 23985-2009 8.3 221 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.  
Gloss description: According to Jotun Performance Coatings' definition.

## Film thickness per coat

### Typical recommended specification range

Dry film thickness 100 - 250 µm  
Wet film thickness 140 - 345 µm  
Theoretical spreading rate 7.2 - 2.9 m<sup>2</sup>/l

## Surface preparation

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Stainless steel	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Aluminium	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	Sweep blast-cleaning using non-metallic abrasive leaving a clean, rough and even pattern.
Shop primed steel	Clean, dry and undamaged shop primer (ISO 12944-4 5.4)	Sa 2 (ISO 8501-1)
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating

## Application

### Application methods

The product can be applied by

Spray:	Use airless spray.
Brush:	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.
Roller:	May be used for small areas but is not recommended for first primer coat. However, when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

### Product mixing ratio (by volume)

Jotamastic 85 Comp A	4 part(s)
Jotamastic 85 Comp B	1 part(s)

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

Minimum 5% thinning is recommended when applying on rusted substrates.

For DFT below 150 µm 3-5% thinner should be added.

### Guiding data for airless spray

Nozzle tip (inch/1000):	19-25
Pressure at nozzle (minimum):	150 bar/2100 psi

## Drying and Curing time

Substrate temperature	-5 °C	0 °C	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	20 h	14 h	6 h	5 h	2 h	1 h
Walk-on-dry	48 h	30 h	16 h	10 h	5 h	2 h
Dry to over coat, minimum	36 h	24 h	12 h	8 h	4 h	2 h
Dried/cured for service	28 d	21 d	14 d	10 d	7 d	3 d

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Induction time and Pot life

<b>Paint temperature</b>	<b>23 °C</b>
Induction time	10 min
Pot life	1.5 h

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	90 °C	120 °C
Immersed, sea water	50 °C	60 °C

Peak temperature duration max. 1 hour.

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Note that the coating will be resistant to various immersion temperatures depending on the specific chemical and whether immersion is constant or intermittent. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

## Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat: inorganic zinc shop primer, epoxy, epoxy mastic  
Subsequent coat: epoxy mastic, epoxy, polyurethane, acrylic

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
Jotamastic 85 Comp A	16	20
Jotamastic 85 Comp B	4	5

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

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### **Shelf life at 23 °C**

Jotamastic 85 Comp A	24 month(s)
Jotamastic 85 Comp B	24 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

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### **Caution**

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

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### **Health and safety**

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

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### **Colour variation**

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

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### **Disclaimer**

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.

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