

Jotamastic Plus

Product description

This is a two component amine cured epoxy mastic coating. It is a surface tolerant, high solids, high build product. Specially designed for areas where optimum surface preparation is not possible or required. Provides long lasting protection in environments with high corrosivity. Can be used as primer, mid coat, finish coat or as single coat system in atmospheric and immersed environments. Suitable for properly prepared carbon steel and aged coating surfaces.

Typical use

General:

Primarily designed for maintenance and repair.

Marine:

Outside hulls, exterior and interior areas.

Protective:

Recommended for offshore environments, including splash zones, refineries, power plants, bridges, buildings, mining equipment and general structural steel.

Colors

aluminum, aluminum red toned, off-white

Product data

| Property | Test/Standard | Description |
|-----------------------|-------------------|--------------------|
| Solids by volume | ISO 3233 | 72 ± 2 % |
| Gloss level (GU 60 °) | ISO 2813 | semi gloss (35-70) |
| Flash point | ISO 3679 Method 1 | 95 °F (35 °C) |
| Density | calculated | 1.4 kg/l |

The provided data is typical for factory produced products, subject to slight variation depending on color.

All data is valid for mixed paint.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

| | | |
|----------------------------|--|--|
| Dry film thickness | 5 mils (125 µm) | - 12 mils (300 µm) |
| Wet film thickness | 7 mils (175 µm) | - 16 mils (415 µm) |
| Theoretical spreading rate | 230 ft ² /gal (5.7 m ² /l) | - 100 ft ² /gal (2.4 m ² /l) |

Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Optimum performance, including adhesion, corrosion protection, heat resistance and chemical resistance is achieved with recommended surface preparation.

Surface preparation summary table

| Substrate | Surface preparation | |
|-------------------|--|--|
| | Minimum | Recommended |
| Carbon steel | St 2 (ISO 8501-1) or SSPC SP-2 | Sa 2 (ISO 8501-1) / SP 6 / NACE No. 3 (SSPC-VIS 1) |
| Shop primed steel | Clean, dry and undamaged shop primer (ISO 12944-4 5.4) | Sa 2 (ISO 8501-1) / SP 6 / NACE No. 3 (SSPC-VIS 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. Not recommended for first primer coat. Care must be taken to achieve the specified dry film thickness.

Product mixing ratio (by volume)

| | |
|------------------------|-----------|
| Jotamastic Plus Comp A | 3 part(s) |
| Jotamastic Plus Comp B | 1 part(s) |

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

Guiding data for airless spray

| | |
|-------------------------------|------------------|
| Nozzle tip (inch/1000): | 19-23 |
| Pressure at nozzle (minimum): | 150 bar/2100 psi |

Drying and Curing time

Temperatures:

-10°C = 14°F / -5°C = 23°F / 0°C = 32°F / 5°C = 41°F / 10°C = 50°F / 15°C = 59°F / 23°C = 73°F / 35°C = 95°F / 40°C = 104°F / 100°C = 212°F

| Substrate temperature | 0 °C | 5 °C | 10 °C | 23 °C | 40 °C |
|------------------------------|-------------|-------------|--------------|--------------|--------------|
| Surface (touch) dry | 24 h | 12 h | 7 h | 4 h | 2 h |
| Walk-on-dry | 42 h | 18 h | 12 h | 7 h | 3 h |
| Dried to over coat, minimum | 42 h | 18 h | 12 h | 7 h | 3 h |
| Dried/cured for service | 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

Temperatures: 15°C = 59°F / 23°C = 73°F

| Paint temperature | 23 °C |
|--------------------------|--------------|
| Induction time | 10 min |
| Pot life | 1.5 h |

Heat resistance

| | Temperature | |
|---------------------|--------------------|-------------|
| | Continuous | Peak |
| Dry, atmospheric | 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: epoxy shop primer, inorganic zinc silicate shop primer, zinc epoxy, epoxy, epoxy mastic, inorganic zinc silicate
Subsequent coat: polyurethane, polysiloxane, epoxy, acrylic, vinyl epoxy

Packaging (typical)

| | Volume (liters) | Size of containers (liters) |
|------------------------|--------------------|--------------------------------|
| Jotamastic Plus Comp A | 13.5 | 20 |
| Jotamastic Plus Comp B | 4.5 | 5 |

4.5 l = 1.19 gal
13.5 l = 3.57 gal

The volume stated is for factory made colors. 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, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 73°F (23 °C)

| | |
|------------------------|-------------|
| Jotamastic Plus Comp A | 24 month(s) |
| Jotamastic Plus 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.

Note

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.

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.

Color variation

When applicable, products primarily meant for use as primers or antifoulings may have slight color variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

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

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.
