

RAK Poxy 800HB Mastic Primer

Product description

RAK Poxy 800HB Mastic Primer is a two component, High Solids, Low VOC, amino polyamide cured, anticorrosive, high molecular weight, premium quality Zinc pigmented epoxy primer. It has very good hardness, adhesion, fast drying and abrasion resistant properties. It is specially formulated to use as a primer coat or intermediate coat on metal surfaces in highly corrosive atmosphere and where long durability is required. Suitable for freshly prepared carbon & stainless steel, aluminium, galvanized steel.

Typical use

Recommended as an anti-corrosive intermediate coat for structured steel, tanks, Refineries, power plants, bridges and equipment's.

Finish

White, Grey, Black, Green, Red

Product data

Property	Description Standard Grade	Description Winter Grade
Gloss level (GU 60 °)	Matt	Matt
Solids by Volume	85 ± 2 %	86 ± 2 %
Flash point	26°C	26°C
Density	1.59 kg/l	1.51 kg/l
VOC-EU	210 g/l	200 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour. All data is valid for mixed paint.

Gloss description: According to RAK Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

	Standard Grade	Winter Grade
Dry film thickness	150 - 325 µm	150 - 300 µm
Wet film thickness	176 - 382 µm	175 - 349 µm
Theoretical spreading rate	5.6 - 2.6 m ² /l	5.7 - 2.8 m ² /l

Surface preparation

Surface should be clean from all dust, rust, wax, oil, grease, loose particles, flakes and other contaminants. Remove all wax, oil and grease by solvent cleaning as per instruction given by SSPC-SP1. Surface profile for Carbon steel is recommended to be as per Sa 2½ (ISO 8501-1) and for Stainless steel surface profile shall be sharp and angular after removing polish through non-metallic abrasive media blasting. After abrasive blast cleaning, remove dust from the

RAK Paints LLC, PO Box: 86012, Tel: +971-7-2444036, Fax: +971-7-2446110, Ras Al Khaimah, UAE. www.rakpaints.com

RAK Poxy 800HB Mastic Primer

surface. Recommended surface profile is 25 microns and it should not exceed 40 microns. Surface to recoat should be cleaned thoroughly before application.

Application

Application methods

The product can be applied by

Spray : Use Air or Airless Spray

Brush : Use for corners and areas difficult to paint with roller

Product mixing

Summer Grade

RAK Poxy 800HB Mastic Primer Base – 6 Parts

RAK Poxy 800HB Mastic Primer Hardener – 1 Parts

Winter Grade

RAK Poxy 800HB Mastic Primer Base – 4 Parts

RAK Poxy 800HB Mastic Primer Hardener – 1 Parts

Thinner/Cleaning solvent

Thinner: RAK Poxy Thinner

Airless Spray / Brush : 10-20% thinner is recommended as per need.

Conventional Air Spray : 45-55% thinner is recommended as per need.

Guiding data for Airless spray

Nozzle tip Size (Inch/1000) : 15 - 19

Pressure at nozzle (minimum): 2100 psi

Apply this product only if relative humidity is less than 85% and substrate temperature is minimum 10° C & above 3° C of the dew point

Drying and Curing time

	Standard Grade	Winter Grade
Surface Dry	3 Hours 30 Mins	2 Hour
Tack free	6 Hours	3 Hours
Full Cure	7 Days	7 Days
Recoating Time (Minimum)	8 Hours	6 Hours

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, 30° C temperature and at average of the DFT range for the product.

RAK Paints LLC, PO Box: 86012, Tel: +971-7-2444036, Fax: +971-7-2446110, Ras Al Khaimah, UAE. www.rakpaints.com

RAK Poxy 800HB Mastic Primer

Pot Life

3 Hours at 30° C

Product Application System

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 RAK Paint for specific system recommendation.

Previous coat : RAK Poxy Primers, RAK Poxy Mastic, RAK Poxy MIO, RAK Poxy Silicate

Topcoat : RAK Thane PU Topcoat, RAK Poxy Topcoats, RAK Poxy Lowbake, RAK Poxy Tiecoat

Packaging (typical)

RAK Poxy 800HB Mastic Primer 3.6L & 20L

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 30 °C

RAK Poxy 800HB Mastic Primer 12 Months

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.

Health and safety

During paint application, it is advisable to wear suitable protective guards (PPE). In case of accidental contact with eyes rinse immediately with plenty of water and seek medical advice. In case of inhalation- remove to fresh air, loosen collar and keep patient rested. Get medical treatment. For remove splashes from skin, use soap and water or approved skin cleanser. Flammable material always keeps away from sources of ignition and do not smoke. Ensure sufficient ventilation during application and drying. Do not breathe vapour/spray. Keep container tightly closed and keep out of reach of children. In case of fire - use foam, carbon dioxide or dry chemicals. For more information, refer MSDS.

Disclaimer

The data provided in this sheet is given to the best of our knowledge and based on laboratory testing and practical experience. We cannot guarantee anything but the product since the conditions and methods during application vary. We reserve the right to change the given data without prior notice. The product data sheet supersedes those previously issued.

For more information, contact your local RAK Paints Representative, go to www.rakpaints.com or call +971-7-2444036.

RAK Paints LLC, PO Box: 86012, Tel: +971-7-2444036, Fax: +971-7-2446110, Ras Al Khaimah, UAE. www.rakpaints.com
