

**DATA SHEET**

**504**  
**SURFACE TOLERANT EPOXY MASTIC**

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V1-28/11/2014

**DESCRIPTION**

- 504 is a surface tolerant epoxy coating, filled with micro glass flakes, designed to protect surfaces with minimum preparation. It is a primer and top coat in one, also used to protect concrete and often used as a heavy duty floor coating.

**PRINCIPAL CHARACTERISTICS**

- Limited yellowing
- UV and weather resistant
- Excellent Corrosion Resistance
- V.O.C. Compliant
- Minimum Surface Preparation to St2
- Grit blasting not essential
- Bonds to:
  - Old Paint
  - Light Rust
  - Galvanised Steel
  - Damp Surfaces
  - Slightly Oily Surfaces
- Easy application by:
  - Brush
  - Roller
  - Spray
- Excellent resistance to: Salt Water Petroleum  
Products Dilute Acids  
& Alkalis
- Excellent Abrasion Resistance

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#### **SURFACE PREPARATION**

- Remove salt contamination with fresh water and Holdtight®102. Mechanically clean to ST2. Sound old coatings may be left on.

#### **HEALTH AND SAFETY**

- Please read instructions on container.
- Avoid Skin contact, do not inhale vapours.
- SKIN: Wash well with soap & water.
- EYES: Flush with water & immediately seek medical attention.
- Read 16 point Safety Data Sheet.

#### **TYPICAL PAINT SYSTEM**

- APPLICATION BY AIRLESS SPRAY, BRUSH or ROLLER 2 coats of 504 @ 150-200µ DFT/coat.

#### **HOW TO SPECIFY**

- All surfaces to be prepared and coated with 504 in accordance with the manufacturer's instructions.

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	<u>TECHNICAL DATA</u>
<b>OPERATING TEMP. RANGE</b>	: -40°C to +80°C
<b>APPLICATION TEMPERATURE</b>	: + 5°C to +40°C
<b>COLOURS</b>	: White, Grey, Red
<b>SOLIDS (% VOLUME)</b>	: 75% +/- 2
<b>SPECIFIC GRAVITY</b>	: 1,5
<b>VOC</b>	: <b>240 grams per litre</b>
<b>FLASH POINT</b>	: 35°C +/- 2
<b>FLEXIBILITY</b>	: Good
<b>SPREAD RATE</b>	: 2 coats @ 5m <sup>2</sup> /litre/coat (170µ DFT per coat)
<b>MIXING RATIO</b>	: 4:1 (By volume)
<b>INDUCTION TIME</b>	: 10 minutes
<b>POT LIFE</b>	: 2 Hrs @ 20°C
<b>OVERCOATING TIMES</b>	: 15°C - 20 Hrs minimum : 30°C - 6 Hrs minimum
<b>FULL CURE</b>	: 7 Days @ 25°C
<b>CLEANING SOLVENT</b>	: Epoxy Thinners
<b>STORAGE TEMPERATURE</b>	: +5°C to 25°C
<b>SHELF LIFE</b>	: 24 Months
<b>PACKAGING</b>	: 5 and 20 litres

<b>NOZZLE PRESSURE</b>	: 15 – 20 Mpa
<b>TIP SIZE</b>	: 0,8mm – 1,1mm
<b>SPRAY ANGLE</b>	: 40 – 80°C
<b>FILTER</b>	: Remove all filters

	THEORETICAL SPREAD RATE M <sup>2</sup> / L	FILM THICKNESS (MICRONS)	
		Wet	Dry
<b>Range:</b>	5,0–2,5	200 – 400	150 – 300
<b>Typical :</b>	4,0	250	190

The technical data furnished is obtained from controlled laboratory tests under ideal application conditions. No guarantee of any performance characteristic is therefore given or implied and we do not hold ourselves responsible for any consequential damage of whatsoever nature that may arise from use of our products. In the event of a proven fault our liability will be limited to the replacement of the product only. It is the users' responsibility to confirm the currency of product data sheets.