SanyMastic – S600
HB Coal Tar Epoxy Coating

SPECIFICATION DATA
- Solids Content By Volume: 75% ± 2%
- VOC Values
  - As supplied: 2.0 lbs/gal (192 g/l)
  - Thinned: 20 oz/gal with SolvenSany # 260 : 2.6 lbs/gal (307 g/l)
  - 25 oz/gal with SolvenSany # 260 : 2.7 lbs/gal (325 g/l)
  - These are nominal values.
- Theoretical Coverage Rate per Gallon:
  - 1184 sq. ft.
- Coverage at recommended Dry Film Thickness (mils):
  - Minimum: 8
  - Recommended: 16
  - Maximum: 35
  - 1 Coat: one or two coats
  - 2 Coats: one or two coats
- Coverage to achieve recommended Thickness (Sq. Ft/Gal.):
  - 148
  - 74
  - 34
- * Mixing and application losses will vary and must be taken into consideration when estimating job requirements.
- Temperature Resistance:
  - Continuous: 350 °F (177 °C)
  - Non-Continuous: 370 °F (190 °C)
- For immersion, temperature depends on exposure, but maximum is 120 °F (49°C)
- Dry Film Thickness per Coat
  - 8 mil (200 microns)
- Color Standard in:
  - Blank and dark red only
- Gloss:
  - High initially, becomes flat
- Limitations:
  - Do not use for potable water requirements
- Pot Life:
  - 3 hours at 75 °F (24 °C) and less at higher temperatures. Pot life ends when the coatings loses body and begins to sag.
- Shelf Life:
  - 24 months when stored at 75 °F (25 °C)
- Storage Conditions:
  - Store indoors.
  - Temp.: 45 - 110 °F (7 - 43 °C)
  - Humidity: 0 - 100%

TOPOCoAT REQUIRED:
None required. SanyMastic-S600 may be topcoated with SanyChem KoraTex Water base Paints as direct. Coal tar bleed-through is likely with most topcoats. Solvent base are not recommended due to discoloration.

COMPATIBLE COATINGS:
SanyMastic-S600 is a self-priming. Can also be applied over catalyzed epoxies or other as recommended. A good acceptable primer for steel is EpoSany-793. When an inorganic zinc primer is used, a tie-coat of EpoSany-793 is recommended. For concrete, epoxy surfacer may be necessary. Consult SanyChem Technical Service Department for specific recommendation.

TYPICAL CHEMICAL RESISTANCE

<table>
<thead>
<tr>
<th>Exposure</th>
<th>Splash &amp; Spillage</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>Acids</td>
<td>Very Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Alkalis</td>
<td>Very Good</td>
<td>Excellent</td>
</tr>
<tr>
<td>Solvents</td>
<td>Fair - Poor</td>
<td>Good - Fair</td>
</tr>
<tr>
<td>Salt</td>
<td>Excellent</td>
<td>Excellent</td>
</tr>
<tr>
<td>Water</td>
<td>Excellent</td>
<td>Excellent</td>
</tr>
</tbody>
</table>

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APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions, and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

Substrates & Surface Preparation

General
Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.

Steel
- Immersion: SSPC-SP10
- Non-Immersion: SSPC-SP6 for maximum protection. SSPC-SP2 or SP3 as minimum requirement.
- Surface Profile: 2.0-3.0 mils (50-75 micron)

Concrete
Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing. First coat of SanyMastic-S600 is thinned up to 33% and applied at a coverage rate of 200-300 sq.ft./Gal.

Spray Application Equipment

This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray: Pressure pot equipped with dual regulators, 3/8” I.D. minimum material hose, with 50” maximum material hose .086” I.D. fluid tip and appropriate air cap.

Airless Spray: Use ½” minimum I.D. material hose. Hold gun approximately 18-20 inches from the surface and at a right angle to the surface. Use a 0.029” – 0.033” tip appropriate air cap.

- Pump Ratio: 30:1
- GPM Output: 3.0 (min.)
- Material Hose: ½” I.D. (min.)
- Tip Size: .023-.035”
- Output PSI: 2100-2500
- Filter Size: 30 mesh
- Teflon packings are recommended and available from the pump manufacturer.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later. Holiday detection (testing for Pinholes or other discontinuities) is recommended, especially for all immersion services.

Brush & Roller (General)
Recommended for touch up, stripping of weld seams and hard-to-coat areas only. Avoid excessive rebushing or re-rolling.

Brush
- Use a medium bristle brush.

Roller
- Use a short-nap synthetic roller cover with phenolic core.

Mixing
Power mix separately, then combine and power mix for a minimum of two minutes. DO NOT MIX PARTIAL KITS.

Ratio
- SanyMastic-S600 P/A: 1 Gal. Kit 05 Gal. Kit 0.80 Gal. 4 Galts.
- SanyMastic-S600 P/B: 0.20 Gal. 1 Gal.

Thinning
Thin up to 25% by volume with SolvenSany #260. Use of thinners other than those supplied or recommended by SanyChem may adversely affect product performance and void product warranty, whether expressed or implied.

Contact
For information and Prices, Please Call a SANYCHEM Local Sales Representative.

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APPLICATION CONDITIONS

<table>
<thead>
<tr>
<th>Material</th>
<th>Surfaces</th>
<th>Ambient</th>
<th>Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Normal</td>
<td>60 – 85 °F (16 – 29 °C)</td>
<td>60 – 85 °F (16 – 29 °C)</td>
<td>60 – 85 °F (16 – 29 °C)</td>
</tr>
<tr>
<td>Minimum</td>
<td>50°F (10 °C)</td>
<td>50 °F (10 °C)</td>
<td>50 °F (10 °C)</td>
</tr>
<tr>
<td>Maximum</td>
<td>90 °F (32 °C)</td>
<td>125 °F (52 °C)</td>
<td>110 °F (43 °C)</td>
</tr>
</tbody>
</table>

Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

DRIED TIMES

<table>
<thead>
<tr>
<th>Surface Temp. &amp; 50% RH</th>
<th>Dry to Touch / Handle</th>
<th>Minimum Recoat Time</th>
<th>Maximum Recoat Time</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>50 °F (10 °C)</td>
<td>6 - 8 hrs</td>
<td>10 hrs</td>
<td>24 hrs</td>
<td>14 days</td>
</tr>
<tr>
<td>75 °F (24 °C)</td>
<td>2 hrs</td>
<td>6 hrs</td>
<td>24 hrs</td>
<td>7 days</td>
</tr>
<tr>
<td>90 °F (32 °C)</td>
<td>1 hr</td>
<td>3 hrs</td>
<td>24 hrs</td>
<td>5 days</td>
</tr>
</tbody>
</table>

These times are based on a 16.0 mil (400 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat time is exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats.

Cleanup & Safety

Clean up
Use SolvenSany #252. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety
Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanslike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

FOR INDUSTRIAL USE ONLY. KEEP AWAY FROM CHILDREN. 1/2001

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