

15565 KANEPOX MASTICOAT WT - 65

PRODUCT DESCRIPTION

15565 KANEPOX MASTICOAT WT-65 is an epoxy-polyamine based, two component, zinc phosphate containing, high built, self priming mastic coating with low volatile organic content (VOC). It is used as a primer and topcoat. It is specially designed as a surface tolerant coating with excellent adhesion and impact resistance on marginally prepared steel surfaces and a wide range of existing coatings. Applied coating could dry down to 5°C. It can be used in one coat applications.

RECOMMENDED USE

Multi-purpose tolerant primer/midcoat (one coat where UV resistance is not important) specially designed for wind energy industry. It has also wide range of other application areas such as:

- Moist steel surfaces.
- Petrochemical plants.
- Industrial and marine structures (including concrete surfaces).
- Ship building and maintenance industry, below or above water.
- Bridge structures, below or above water.

Complies with the requirements of LEED V4 – Low Emission Substances (substances with a maximum VOC content of 250 g/l)

PRODUCT CHARACTERISTICS

Finish: Semi-Matt	Density (g/ml) 1,53±0,10
Colour: White, Grey, Oxide Red, (Please contact Project Group for other colors)	Spreading Rate (m²/l) 8,30 (100 microns DFT)
Thinner: Kanat Thinner 0620 (Low Temp.) Kanat Thinner 0625 (High Temp.)	Flash Point 43°C
Mixing Ratio (By Volume) 16 Parts A Comp. + 4 Parts B Comp.	VOC (Volatile Organic Content) 143 gr/l
Mixed Product; Volume Solids (%) 83±2	Application Methods Airless Spray, Roller
	Pot Life (20°C) 1 hour

DRYING SCHEDULE(*)

(100 microns/4 mils film thickness)

	Dry to Touch	Hard Dry	Dry to Over Coat Minimum
5°C	10 hours	20 hours	10 hours
15°C	3,5 hours	7 hours	3,5 hours
25°C	2 hours	4 hours	2 hours
35°C	1,5 hours	2,5 hours	1,5 hours

Drying values are valid for defined dry film thickness and below 85% relative humidity.

Fully Cured: 7 days (20°C)

(*) Drying time depends on temperature, humidity and film thickness.

PACKAGING

One kit of **15565 KANEPOX MASTICOAT WT-65** is 20 l.

One pail of **15565 KANEPOX MASTICOAT WT-65** component A is 16 l.

One can of **KANEPOX HARDENER 0319** component B is 4 l.

SHELF LIFE

Part A–12 months, Part B–12 months when the material is stored in a cool and dry place in unopened original containers.

SAFETY PRECAUTIONS

Refer to the MSDS sheet prepared according to EU directives before use.

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SURFACE PREPARATION

Surfaces must be dry, clean, free of oil, grease and other foreign material.

New Steel Surfaces: Power tool cleaning to St2-St3 according to ISO 8501-1. Surface blasting to near white metal surface cleanliness according to SSPC-SP10 or ISO 8501-1 Sa 2 1/2 will improve performance. Depending on ambient conditions, power tool cleaned or blasted surfaces must be primed in maximum 5 hours with **15565 KANEPOX MASTICOAT WT-65**.

Previously Painted Surfaces: If the aged coating is in a good condition, it is slightly sanded and cleaned by pressurized fresh water cleaning to remove the dust and other contaminations. Otherwise remove all the cracked and peeling paint by using hand tools to a cleanliness of St 2–St 3 according to ISO 8501-1. If applicable blast cleaning to Sa 2-Sa 2 1/2 according to ISO 8501-1 level to get better results. Water jetting to a minimum degree of Wa 2 1/2 (ISO 8501-4:2006) is also applicable as an alternative to abrasive blasting. A flash rust degree of maximum M (ISO 8501-4:2006) is acceptable before application.

Primed/Midcoated Surfaces: Be sure that overcoating period is not exceeded. Otherwise the surfaces must be blasted to have a surface profile.

The Surfaces Other Than Steel: Contact KANAT PAINTS & COATINGS Project Group for the galvanized, aluminium, plastic surfaces.

Touch-up: Remove all dust, dirt and other foreign material and keep dry. Clean the surface to St 2-St 3 level mechanically according to ISO 8501-1 and complete the touch-up application as soon as possible. **15565 KANEPOX MASTICOAT WT-65** can be safely used for touch-up.

APPLICATION PROCEDURES (Mixing Procedure)

This is a two-component paint. Do not mix more material than you plan to use within the listed pot life. Complete containers must be mixed at one time.

DO NOT MIX PARTIAL QUANTITIES FROM CONTAINERS OR PROPER COMPONENT RATIOS MAY NOT BE OBTAINED.

Prior to mixing, components A Base and B Hardener should be at room temperature (60-75°F/16-24°C). Combine 4 parts by volume of Part B Hardener with 16 parts by volume of Part A Base. Homogenize the mixture with a power mixer, add thinner if necessary and use mixed product must be used within 1 hours (20°C).

MIXING RATIO

Base 15565 : Curing Agent 0319
4 : 1 by volume

APPLICATION CONDITIONS

For the best results;

Temperature must be more than 5°C during the application and/or the curing process.

Surface Temperature: At least 3°C above dew point.
Relative Humidity: 85% maximum.

Good ventilation is required during application.

APPLICATION

Stripe coat all crevices, welds and sharp angles. Apply paint at the recommended film thickness and spreading rate. Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance. Maximum coating interval is 30 days. Do not apply more than 500 microns (can be changed depending on the performance of application equipment and thinner amount) WFT to prevent sagging. When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas and pinholes. If necessary, cross spray at a right angle.

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CLEAN UP

**KANAT THINNER 0644, KANAT THINNER 0620,
KANAT THINNER 0625**

APPLICATION EQUIPMENT

(The table is a guide for 20°C)

Application Equipment	Airless Spray	Roller
Thinner maximum	%10	%15
Pressure minimum (bar)	200	—
Nozzle(inch)	0,017-0,023	—

PRECAUTIONS

- Recoating period is minimum 8-10 hours and maximum 1 month (20°C). Recoating interval depends on temperature, humidity and film thickness. If maximum recoating time is exceeded abrade surface, if the surface is highly contaminated apply pressurized fresh water cleaning before recoating.
- Condensation forming on the coating during early times of curing may result in longer cure times, solvent entrapment, premature failure, discoloration or a surface haze or blush that must be removed before recoating.
- High temperatures decrease resistance properties of epoxy based products. Epoxy based products also have a tendency to yellowing, chalking and have limited gloss retention on exterior surfaces.
- Use only **KANAT THINNER 0625** for thinning paint to be applied on previously painted surfaces.
- Density values can be changed according to the color.

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