



59 EPOXY MASTIC



PRODUCT INFORMATION BULLETIN

DESCRIPTION	Enviroline® 59 is a two component, surface tolerant, high build epoxy with excellent adhesion to most substrates.
TYPICAL USE	An ideal first coat in two coat, high performance epoxy / urethane systems. Use on structural steel, tanks, pipes and masonry surfaces.
BENEFITS	<ul style="list-style-type: none">- Excellent adhesion- Surface tolerant- FDA incidental- Rust inhibiting- Primer / finish- Excellent corrosion resistance
TECHNICAL DATA	Weight (lbs/gal): 10.4 Volume Solids: 72% Color: Light Gray Flash Point: >80° F Pot Life (@77° F): 3.5 hours VOC (mixed lbs/gal): 1.84 VOC (mixed g/l): 220 Recommended Thickness: 6-8 mils DFT
	Temperature Resistance: Non-Immersion, Dry Heat: 250° F (121° C) – may discolor above 140° F (60° C) Continuous immersion temperature resistance is dependent on particular reagent exposure. Consult your Enviroline representative.
COVERAGE	Theoretical Coverage*: 1155 sq. ft per gallon @ 1 mil dry @ 7.0 mils: 165 sq. ft. per gallon <i>*When ordering product, make allowances for any loss due to overspray, surface irregularities, etc. (approx. 15 – 20%).</i>
MINIMUM DRY TIME	77°F and 50% relative humidity, ASTM D 1640: To Recoat: 7 hours Hard: 14 hours
CURE SCHEDULE	Full Cure: 7 days
SURFACE PREPARATION	All surfaces must be dry, clean, free of oil, grease, form release agents, curing compounds, laitance, and other foreign matter and be structurally sound. Remove all loose paint, mill scale and rust. All direct to metal coatings provide maximum performance over blasted surfaces. There are situations and cost limitations which preclude blasting. Enviroline 59 was designed to provide excellent protection over less than ideal surface preparation. The minimum standard for non-immersion service is SSPC SP-2 or Swedish Standard St2; for immersion service, the minimum standard is SSPC SP-10/Nace No. 2 or Swedish Standard Sa2 ½, Near White Metal finish. Where very rusty surfaces still remain after cleaning for non-immersion service, use Enviroline 57X Sealer before application of Enviroline 59 coating.
APPLICATION EQUIPMENT	Spray is preferred for appearance and film build control. For air spray application, use a fluid tip of .070" or larger, a Graco #800 Gun and an air cap with good break-up. The fluid pressure should be kept low, with just enough air pressure to get good break-up of the coating. Excessive air pressure can cause overspray problems. Where airless equipment is used, an airless spray pump capable of 3,000 psi and .019" to .025" tip size will provide a good spray pattern. Ideally, fluid hoses should not be less than 3/8" ID and not longer than 50 feet to obtain optimum results. Longer hose length may require an increase in pump capacity, pressure, and/or thinning. Enviroline 59 may also be applied by brush or roller. Care should be taken that proper and uniform thicknesses are obtained. For roller work use a clean synthetic roller with ¼" - ½" nap. New rollers should be thoroughly wet with the specified thinner and spun rigorously to remove loose fibers.
MIX RATIO	2:1 by volume.

APPLICATION CONDITIONS Apply at 5° F (3° C) above dew point. Use the following chart for preferred temperature and humidity conditions.

	Coating	Substrate	Ambient	Humidity
Preferred	60-90° F	60-90° F	60-90° F	N/A
Minimum	50° F	50° F	50° F	5° above dew point

HANDLING Store at moderate temperatures (65-85° F) prior to application for ease of handling and mixing.

THINNING Thin only if necessary with Enviroline 76T Thinner. Use up to one half pint per gallon.

PRE-HEATING Not needed for **Enviroline® 59**.

MIXING Mechanically pre-mix each component one minute; then mix combined compound with mechanical mixer at low speed for 15 minutes. Allow mixed material to stand 15 minutes and re-stir before use.

CLEAN UP Clean immediately with methyl ethyl ketone (MEK) or methyl isobutyl ketone (MIBK).

PACKAGING One unit forms approximately 4 gallons consisting of two components:
Resin: 5 Gallon Pail **Hardener:** 2 Gallon Pail

SHELF LIFE 2 years when stored at 75° F (24° C) unopened.

SHIPPING F.O.B. Pompano Beach, Florida for domestic shipments, Ex-Works Pompano Beach for international shipments.

SAFETY This product is for industrial use only and should be installed by qualified coating and lining specialists. Consult Material Safety Data Sheets for important health and safety information prior to use.

10/04*

**Enviroline continuously strives to improve its data sheets for the benefit of all users. The owner/applicator is responsible for obtaining the most recent Product Information Bulletin prior to the purchase or application of material.*