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PT. Indowijaya Sakti Teguh

Jl. Pangeran Jayakarta 121/3-4

Telp : 021- 62313238

PUFFIN MASTIC EPOXY PRIMER SURFACER

Two components epoxy coating with zinc chromate anti corrosion pigment. Suitable for primer coat as a part of a complete system in atmospheric and immersed environments.

This product can be apply in carbon steel, stainless steel, aluminum, concrete, galvanized steel, primed steel and thermally sprayed zinc substrate.

1. Properties

COLOR	GREY(OTHER COLOUR DEPENDING REQUEST)
GLOSS LEVEL	SATIN 35-75
FILM THICKNESS, DRY (µm)	40-60
FILM THICKNESS, WET (µm)	80-120
THEORETICAL SPREADING RATE (M ² /L)	9-13
SOLIDS (VOL %)	55% +/- 2
DENSITY (g/cm ³)	1.3
FLASH POINT	25°C ± 2%
PRACTICAL COVERAGE	ALLOW APPROPRIATE LOSS FACTORS

2. Characteristics

Recommended

For steel structure and piping in offshore environments, refineries, power plants, bridges, buildings and mining equipment

3. Usage

1) Surface preparation

For lasting adhesion to the subsequent product, all surfaces shall be clean, dry and free from any contamination. Oil or grease should be removed

2) Substrate minimum recommended :

The surface should be assessed and treated in accordance with substrate minimum recommended.



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Carbon steel: Sa 2½ (ISO 8501-1)

Stainless steel: Cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2)

Aluminum: The surface shall be hand or machine abraded with non-metallic abrasives or bonded fiber machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface.

Dry abrasive blast cleaning to SSPCSP 13/NACE No. 6.

Galvanized steel: The surface shall be clean, dry and appear with a rough and dull profile. Light brush blasting using nonmetallic abrasive leaving a clean, rough and even pattern. Coated surfaces Clean, dry and undamaged compatible coating (ISO 12944-4 6.1) Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)

3) Application:

Airless spray, airspray, brush, roller

Spray: Pressure at nozzle (minimum):
150 bar/2100 psi

Nozzle tip (inch/1000): 15-19

Filter Check to ensure that filters are clean.

Brush: For stripe coating and small areas.

Care must be taken to achieve the specified dry film thickness.



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4) Mixing ratio

Puffin Mastik Epoxy Base A :	4
Puffin Mastik Epoxy Base B :	1
Pot life :	2-4 hour after mixing
Thinner	Puffin Epoxy Thinner

5) Drying and Curing time:

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

Walk-on-dry:

Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum:

The shortest time allowed before the next coat can be applied.

Surface (touch) Dry:

The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

SUBTRATE TEMPERATURE (°C)	15	23	40
SURFACE DRY (hour)	2	1	0.5
DRY ON WALK (hours)	14	6.5	3
Dry to over coat, minimum (hours)	5	4	3
Dried/cured for service (days)	10	7	4



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6) Product compatibility: 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.

Previously:

Shop primer

Subsequent coat:

Epoxy, polyurethane

4. Precaution

1) Ensure to clean the surface before application.

2) Health and safety

Please observe the precautionary notices displayed on the container.

Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact.

Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

3) 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 23 °C 24 Month(s)

5. Packing size:

1kg,5kg & 20kg set