

# Technical Data

## JOTAMASTIC 87 ALUMINIUM



### Product description

Jotamastic 87 Aluminium is a two-pack surface-tolerant, abrasion resistant, high solids epoxy-based coating, for use in cases where optimum pretreatment is not feasible. It may be applied in high film thickness. Two hardeners (comp.B) are available, according to temperature conditions. Cures down to -5°C by using cold climate comp. B. This product is a part of a complete system which is certified not to spread surface flames.

### Recommended use

Steel where blast cleaning may not be possible, and where gloss retention is of minor importance. Can be used alone or in combination with various systems of primers and topcoats. Gives excellent corrosion protection both in salt and fresh water. If exposed to sunlight chalking may occur.

### Film thickness and spreading rate

Standard comp. B	Minimum	Maximum	Typical
Film thickness, dry (µm)	150	300	200
Film thickness, wet (µm)	170	345	230
Theoretical spreading rate (m <sup>2</sup> /l)	5.8	2.9	4.4

Cold climate comp. B	Minimum	Maximum	Typical
Film thickness, dry (µm)	150	250	200
Film thickness, wet (µm)	215	360	290
Theoretical spreading rate (m <sup>2</sup> /l)	4.7	2.8	3.5

### Physical properties

Colour	Aluminium and Aluminium redtoned.
Solids (vol %)*	87 ± 2 Standard comp. B 70 ± 2 Cold climate comp. B
Flash point	40°C ± 2 Standard comp. B (Setaflash) 31°C ± 2 Cold climate comp. B (Setaflash)
Gloss	Semigloss
Gloss retention	Fair
Water resistance	Excellent
Abrasion resistance	Very good
Solvent resistance	Good
Chemical resistance	Good
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

### Bare steel

Cleanliness: Power tool cleaning to min. St 2, mill scale free (ISO 8501-1:1988). Improved surface treatment (blast cleaning to Sa 2½) will improve the performance.

### Shopprimed steel

Clean, dry and undamaged approved blast-primer.

### Coated surfaces

Clean, dry and undamaged compatible primer. Contact your local Jotun office for more information. For maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12) or Power tool cleaning to min. St 2 for rusted areas

### Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

## Condition during application

The temperature of the substrate should be minimum +10°C (Std) (-5°C in CC) and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying.

## Application methods

<b>Spray</b>	Use airless spray (thin 10%)
<b>Brush</b>	May be used but care must be taken to achieve the specified dry film thickness.
<b>Roller</b>	May be used for small areas but not recommended for first primer coat, however when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

## Application data

<b>Mixing ratio (volume)</b>	5.5 parts Comp. A ( base) to 1 part Standard comp. B (hardener) 3.7 parts Comp. A (base) to 1 part Cold climate comp. B (hardener)
<b>Induction time</b>	10 minutes.
<b>Pot life (23°C)</b>	1½ hour (Standard comp. B)
<b>Thinner/Cleaner</b>	Jotun Thinner No. 17
<b>Guiding data airless spray</b>	
<b>Pressure at nozzle</b>	15 MPa (150 kp/cm <sup>2</sup> 2100 psi)
<b>Nozzle tip</b>	0.53 - 0.79 mm (0.021-0.031")
<b>Spray angle</b>	65-80°
<b>Filter</b>	Check to ensure that filters are clean.

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

\* Good ventilation (Outdoor exposure or free circulation of air)

\* Typical film thickness

\* One coat on top of inert substrate

### Standard comp. B

Substrate temperature	10°C	23°C	40°C
Surface dry	8 h	4 h	2 h
Through dry	24 h	10 h	4 h
Cured	14 d	7 d	2 d
Dry to recoat, minimum	24 h	10 h	4 h
Dry to recoat, maximum <sup>1</sup>			

### Cold climate comp. B

Substrate temperature	-5°C	0°C	5°C	10°C	23°C
Surface dry	24 h	18 h	12 h	6 h	2.5 h
Through dry	48 h	26 h	18 h	12 h	5 h
Cured	21 d	14 d	7 d	3 d	2 d
Dry to recoat, minimum	48 h	26 h	18 h	12 h	5 h
Dry to recoat, maximum <sup>1</sup>	-	-	-	-	-

1. Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

## Typical paint system

Jotamastic 87 Aluminium	1 x 200 µm	(Dry Film Thickness)
Jotamastic 87	1 x 200 µm	(Dry Film Thickness)
Hardtop AS	1 x 50 µm	(Dry Film Thickness)

Other systems may be specified, depending on area of use

## Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

## Handling

Handle with care. Stir well before use.

## Packing size

14,7 L. Comp. A and 2.7 L. Standard Comp. B  
(14,7 L. Comp. A and 4 L. Cold Climate Comp. B)

Packing may vary from country to country according to local requirements.



## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale 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.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

## DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

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ISSUED 13 FEBRUARY 2002 BY JOTUN PAINTS  
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