

Description

MASTERGUARD PR 331 is two components amine cured, high build epoxy primer designed for rapid cure even at low temperatures, with a workable pot-life and the ability to resist moisture during cure. It can be applied in marine and other severe service industrial environments.

Key Features

- Good anti corrosion
- Rapid cured
- Economical products

Recommended Use

Offshore environments, refineries, power plants, bridges, buildings and mining equipment.

Product Data

Properties

Type	: Epoxy Primer
Solid Volume	: 72 ± 2%
Specific gravity mix	: 1.56 kg/l (calculated)
Dry film thickness	: 100 – 200 µm
Wet film thickness	: 140 – 275 µm
Spreading rate theoretical	: 7.2 – 3.6 m ² /l
Finish	: Matt (0% – 40%)
Color	: Red, Light grey

Packaging Size

5 Liter set	COMP A (4 L) COMP B (1 L)
20 Liter set	COMP A (16 L) COMP B (4 L)

Application Data

Substrate & Surface Preparation

- General
To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination that can reduce adhesion via SSPC-SP1 solvent cleaning.
- Metal
Abrasive blasting is recommended to remove rust and mill scale. Solvent clean surfaces according to SSPC-SP1, then perform a commercial blast to SSPC-SP6 for mild exposures. For immersion service and severe environments, solvent clean surfaces according to SSPC-SP1 first, then perform a near-white blast SSPC-SP10. Used sealer or tie coat before anti fouling applied.
- Previously painted surfaces
All previously painted surfaces should be cleaned thoroughly to remove surface contamination. Rinse well and allow to dry. Scrape loose, scaly, peeling paint and sand the edges smooth, remove any rust and scale from ferrous metal. If the paint is glossy, sand to dull the surface. Test for compatibility with existing coatings.

Mixing

Stir well before use, then combine and mix with ratio as follows:

COMP A : COMP B = 4 : 1 by volume

Pot Life

Pot life end when coatings become too thick to use. At 25°C = 1.5 hours

Thinner/Cleaning

May be thinned up to 5% by volume with Thinner 3 for spray application

Application Method

- Airless Spray
 - Pump Ratio : 30 : 1 (minimum)
 - Tip Size : 0.017 – 0.031 inch
 - Fluid Output : 1.5 – 2.5 litres/min
 - Pressure Output : 1500 – 3000 psi
 - Filter Size : 60 mesh
- Brush & Roller may be used only for stripe coating and small areas

Application Condition

Condition	Substrate Temp.	Ambient Temp.	Humidity
Minimum	10°C	10°C	10%
Maximum	49°C	49°C	85%

Drying Time

Surface Temperature	Surface Dry	Dry to Overcoat	Full Cured
25°C	2 hours	4 hours	7 days

Determined based on wet film thickness 76µ at standard conditions.

Storage Condition

Keep away from heat, fire and direct sunlight. Close the container tightly when not in use, keep in dry and cool room. Keep in temperature room (25-30 degree C).

Shelf-Life Product

Standard shelf life COMP-A and COMP-B is 24 months from the date of manufacturing in originally not opened boxes, but may be extended based upon retesting by Pacific Paint Quality Control.

Health, Safety and Environment

Always use personal protective equipment and apply in a well-ventilated space. Caution with hazard symbol, see on packaging or refer to safety data sheet.

Read all safety, security, health and environment precautions before use. Wash hands and exposed skin before meals and after use. In case of contact with eyes and skin, rinse immediately with clean water, if swallowed or for more serious cases seek medical attention immediately.