



HIGH PERFORMANCE INDUSTRIAL DTM EPOXY MASTIC (9100 SYSTEM)

DESCRIPTION AND USES

A two-component, high solids epoxy coating for use in moderate to severe environments. It is specifically designed for application directly on sound rusted steel with minimum surface preparation. It can also be used on clean steel, galvanized metal, concrete (including concrete floors), previously coated and slightly damp surfaces. It may also be used for water immersion service, using High Performance Industrial DTM Epoxy Mastic standard premix bases only with 9102402 Immersion Activator. (Note: Do not use for immersion service in potable water tanks). High Performance Industrial DTM Epoxy Mastic can be used indoors or out. While exposure to sunlight and certain interior lighting conditions causes fading and chalking of all epoxy type coatings, these changes are cosmetic in nature only and film integrity and performance will not be adversely affected.

Epoxy coatings will yellow with age. This is most noticeable with interior applications of white or light colors which are not subjected to bleaching from Sunlight. Note: 9102402 Immersion Activator and 9104402 Fast-Cure Activator produce a semi-gloss finish. Also, using the 910402 Fast-Cure Activator may result with a slight colorshift when compared with products using the 9101402 Standard Activator.

PRODUCTS

COATINGS

1-Gallon	5-Gallon	Description
9115402	—	Aluminum
9122402	—	Marlin Blue
9125402	—	Safety Blue
9133402	—	Safety Green
9145402	—	Equipment Yellow
9165402	—	Regal Red
9168402	—	Tile Red
9171402	—	Dunes Tan
9179402	—	Black
9182402	—	Silver Gray
9186402	—	Navy Gray
9192402	—	White
9144402	—	Safety Yellow

PRODUCTS (cont.)

ACTIVATOR

1-Gallon	5-Gallon	Description
9101402	9107300	Standard Activator
9102402*	9102300	Immersion Activator
9103402	9103300	Low Temp Activator
9104402*	A910008300	Fast Cure Activator

* Not for use with tint bases.

TINT BASES*

1-Gallon	5-Gallon	Description
9105405	9105375	Red
9106405	9106405	Yellow
9107405	9107375	Masstone
9108421	9108381	Deep
9109408	9109388	Light

*Tint bases use the Rust-Oleum 2020 Colorants

All standard colors, tint bases and activators are USDA acceptable under FSIS Directive 11000.4 (Rev.1), November 24, 1995.

Color subject to approval of USDA Inspector. Agriculture Canada accepted: 9115, 9145, 9165, 9171, 9179, 9186, 9192 and 9101.

COMPANION PRODUCTS

RECOMMENDED PRIMERS

System is self-priming

COMPATIBLE PRIMERS

Extended Recoat Epoxy Primers (9300 System)

COMPATIBLE TOPCOATS

Industrial High Performance Acrylic Finishes (3700 & 3100 Systems)

Industrial High Gloss Urethane Finishes (9400 System)*

Industrial Low VOC Urethane Finishes (9700 System)*

Industrial DTM Urethane Mastic Finishes (9800 System)*

*Do not use over 9115402 Aluminum



PRODUCT APPLICATION

SURFACE PREPARATION

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Pure Strength® Cleaner/Degreaser item #3599402 or other suitable cleaner. Rinse with fresh water and allow to dry.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, scale, and deteriorated previous coatings to obtain a sound rusted surface. For optimum corrosion resistance, abrasive blast to commercial grade SSPC-SP-6, with a blast profile of 1-2 mils (25-50 µ).

STEEL (IMMERSION): Abrasive blast clean to a minimum SSPC-SP-10 Near White Grade (NACE 2) and achieve a surface profile of 1.5-3 mils. All weld spatter must be removed along weld seams, rough welds should be ground smooth, and all sharp edges should be ground to a smooth radius.

PREVIOUSLY COATED: Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. The High Performance Industrial DTM Epoxy Mastic is compatible with most coatings, but a test patch is suggested. **WARNING!** If you scrape, sand or remove old paint from any surface, you may release lead paint dust. **LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.** Wear a NIOSH-approved respirator to control lead exposure. Carefully clean up with a wet mop or HEPA vacuum. Before you start, find out how to protect yourself and your family by contacting the U.S.EPA/Lead Information Hotline at 1-800-424-LEAD or log onto www.epa.gov/lead.

GALVANIZED METAL: Remove oil, dirt, grease and other chemical deposits with Pure Strength® Cleaner/Degreaser item #3599402 or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

CONCRETE OR MASONRY: Scrape and wire brush or power tool clean to remove any loose or unsound concrete, masonry, or deteriorated coating. Acid etch smooth concrete with 108402 Cleaning and Etching Solution. New concrete or masonry must cure 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas.

APPLICATION

Airless spray is the preferred method of application. However, brush, roller, or air-atomized spray may also be used. Refer to table for thinning recommendations. For proper performance, a dry film thickness of 5-8 mils per coat is required. Excessive brushing or rolling may reduce film thickness. Apply a second coat if necessary to achieve the recommended film thickness.

PRODUCT APPLICATION (cont.)

Use Industrial DTM Epoxy Mastic with 9101402 Standard Activator or 9104402 Fast Cure Activator at air and surface temperatures between 50-100°F (10-38°C) and when the surface temperature is at least 5°F (3°C) above the dew point. Low curing temperatures and/or condensation on the film while curing can affect appearance in the form of an amine blush. This can generally be removed with soap and water, however, in a case of extreme blushing, the performance of the coating may be slightly affected.

When application temperatures are between 40-60°F (5-15°C) and when the surface temperature is at least 5°F (3°C) above the dewpoint, use Industrial DTM Epoxy Mastic with the 9103402 Low Temperature Activator. Do not apply the material if the temperature is expected to fall below 40°F in the first 24 hours of cure. At 40°F, full cure will be achieved in 7 days.

For water immersion service, use Industrial DTM Epoxy Mastic with the 9102402 Immersion Activator. Do not use the 9102402 Immersion Activator with tint bases. This system may be used for both salt and fresh water; do not use for the inside of potable water tanks. Apply at air and surface temperatures between 60-100°F (15-38°C), when the surface temperature is at least 5°F (3°C) above the dew point, and when relative humidity is below 85%. Apply two coats alternating color between coats to ensure complete hide. Allow 7 days cure after application of the second coat before immersion.

NOTE: The 9104402 Fast Cure Activator may also be used in water immersion. Allow 7 days for full cure prior to beginning immersion service. Do not use tinted colors in water immersion.

Pools

When used with 9102402 Immersion Activator, the Industrial DTM Epoxy Mastic premix bases can be used as a pool coating over existing epoxy pool coatings, new bare concrete, plaster, gunite, and fiberglass. The pool must be completely empty and dry before coating. After pool is emptied, this typically requires 7-10 days depending on temperature and humidity. To test the dryness of concrete, gunite or plaster pool surfaces, securely tape a 2 ft. by 2 ft. piece of clear plastic onto a horizontal and vertical surface at the deep end of the pool. Check after 24 hours. If water condensation is visible under the plastic, this is an indication that the surface is not completely dry, and NOT suitable for coating. Allow additional dry time and retest. Follow surface preparation, mixing and application instructions. Avoid painting in midday sun. Application is recommended early in the day or late in the afternoon when at least 2 hours of sunlight remain after completion of the job. Allow minimum of 5-7 sunny days cure before filling pool. Early contact with water can cause premature fading, chalking and blistering. Super chlorinated water can cause a bleached out look. Sunlight and UV will cause chalking and fading. **Do not** use over: 1) chlorinated rubber, 2) synthetic rubber, 3) vinyl, 4) acrylic. See Note in Performance Characteristics Section on Page 3.



TECHNICAL DATA

HIGH PERFORMANCE INDUSTRIAL DTM EPOXY MASTIC

PRODUCT APPLICATION (cont.)

EQUIPMENT RECOMMENDATIONS

(Comparable equipment also suitable.)

BRUSH: Use a good quality natural or synthetic bristle brush.

ROLLER: Use a good quality lamb's wool or synthetic fiber (3/8-1/2"nap).

AIR-ATOMIZED SPRAY:

Method	Fluid Tip	Fluid Delivery	Atom. Pressure
Pressure	0.055-0.070	10-16 oz./min.	25-60 psi
Siphon	0.055-0.070	—	25-60 psi
HVLP	0.043-0.070	8-10 oz./min.	10 psi (at tip)

AIRLESS SPRAY:

Fluid Pressure	Fluid Tip	Filter Mesh
1800-3000 psi	0.013-0.017	100

THINNING

Thinning is normally not required, except for air-atomized spray. For air-atomized spray application, thin only up to 10% by volume with 160402 Thinner after the components have been mixed. For material activated with 9102402 Immersion Activator, use up to 10% 165402 Thinner for air-atomized spray and up to 5% of 165402 Thinner for airless spray.

NOTE: Addition of more than 10% of 160402 or 165402 Thinner will cause VOC to exceed 340 g./l. In this case, 333402 VOC exempt thinner can be used if needed.

MIXING

Premix both components before combining at a 1:1 ratio by volume and mix together. Do not mix more material than can be used within the stated pot life.

CLEAN-UP

Use 160402 or 165402 Thinner.

SHELF LIFE

Base components	3 years*
Activators	2 years*

*Unopened containers. Some settling may occur requiring mechanical mixing to redisperse pigment.

PERFORMANCE CHARACTERISTICS

System Tested

Topcoat: DTM Epoxy Mastic with 9101 Activator

PENCIL HARDNESS

METHOD: ASTM D3363

RESULT: B (7 days), 4H (30 days)

CONICAL FLEXIBILITY

METHOD: ASTM D522

RESULT: >32%

CYCLIC PROHESION

Rating 1-10, 10=best

METHOD: ASTM D5894, 2300 hours

RESULT: 10 per ASTM D714 for blistering

RESULT: 10 per ASTM D1654 for corrosion

IMPACT RESISTANCE (direct)

METHOD: ASTM D2794

RESULT: 160 in.-lbs.

TABER ABRASION

METHOD: ASTM D4060 CS-17 wheel, 500 g. load, 1000 cycles

RESULT: 125 mg loss

GLOSS

METHOD: ASTM D4587

RESULT: 80%

For chemical and corrosion resistance, see the Rust-Oleum Industrial Brands Catalog Form # 206275.

NOTE: In swimming pool service, early chalking may occur if the water pH is outside the range of 7.2-7.6 and/or if the water temperature exceeds 100°F (38°C).



TECHNICAL DATA

HIGH PERFORMANCE INDUSTRIAL DTM EPOXY MASTIC

PHYSICAL PROPERTIES

		9101 Activator	9102 Immersion Act.	9103 Low Temp. Act.	9104 Fast-Cure Act.
Resin Type		Polyamide or Polyamide converted Epoxy	Polyamide or Polyamide converted Epoxy	Polyamide or Polyamide converted Epoxy	Polyamide or Polyamide converted Epoxy
Inhibitive Pigment		Calcium Borosilicate	Calcium Borosilicate	Calcium Borosilicate	Calcium Borosilicate
Solvents		Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol	Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol	Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol	Xylene, Methyl Isobutyl Ketone, 1-Methoxy-2-propranol
Weight*	Per Gallon	11.4-12.6 lbs.	11.4-12.6 lbs.	9.3-10.4 lbs.	12.0-13.0 lbs.
	Per Liter	1.4-1.5 kg.	1.4-1.5 kg.	1.1-1.2 kg.	1.4-1.6 kg.
Solids*	By Weight	86-89%	79-82%	78-81%	81-83%
	By Volume	78-81%	65-68%	72-75%	67-69%
Volatile Organic Compounds*		<340 g/l. (2.84 lbs./gal.)	<340 g/l. (2.84 lbs./gal.)	<340 g/l. (2.84 lbs./gal.)	<340 g/l. (2.84 lbs./gal.)
Mixing Ratio		1:1 Act.:Base (by vol.)	1:1 Act.:Base (by vol.)	1:1 Act.:Base (by vol.)	1:1 Act.:Base (by vol.)
Recommended Dry Film Thickness (DFT) Per Coat		5-8 mils (125-200µ)	5-8 mils (125-200µ)	5-8 mils (125-200µ)	5-8 mils (125-200µ)
Wet Film to Achieve DFT (unthinned material)		6.5-10.5 mils (162.5-262.5µ)	7.5-12.0 mils (187.5-300µ)	7-11 mils (175-275µ)	7.5-11.5 mils (187.5-287.5µ)
Theoretical Coverage at 1 mil DFT (25µ)		1250-1300 sq. ft./gal. (30.8-32.0 m ² /l.)	1045-1090 sq. ft./gal. (25.7-26.8 m ² /l.)	1155-1200 sq. ft./gal. (28.4-29.5 m ² /l.)	1075-1100 sq. ft./gal. (26.4-27.3 m ² /l.)
Practical Coverage at Recommended DFT (assumes 15% material loss)		125-225 sq. ft./gal. (3.1-5.5 m ² /l.)	100-175 sq. ft./gal. (2.5-4.3 m ² /l.)	125-200 sq. ft./gal. (3.1-5.0 m ² /l.)	115-190 sq. ft./gal. (2.8-4.7 m ² /l.)
Induction Period		None required	30 min. (60 min. at 60-70°F)	None required	15 minutes
Pot Life**	2 gallons	2-4 hours at 70°F (21°C), 1-2 hours at 90°F (32°C)	2-4 hours at 70°F (21°C), 3-5 hours at 60°F (15°C)	2-4 hours at 60°F (15°C)	2-4 hours at 70°F (21°C), 1-2 hours at 90°F (32°C)
	10 gallons	2 hours at 70°F (21°C), <1 hour at 90°F (32°C)	2 hours at 70°F (21°C), 3 hours at 60°F (15°C)	2 hours at 60°F (15°C)	2 hours at 70°F (21°C), <1 hour at 90°F (32°C)
Dry Times at 50% Relative Humidity	Tack-free	6-8 hours at 70°F (21°C), 12-24 hours at 50°F (10°C)	6-8 hours at 70°F (21°C)	16-20 hours at 40°F (5°C)	4 hours at 70°F (21°C), 8 hours at 50°F (10°C)
	Handle	6-12 hours at 70°F (21°C), 48-72 hours at 50°F (10°C)	8-14 hours at 70°F (21°C)	22-26 hours at 40°F (5°C)	5 hours at 70°F (21°C), 10 hours at 50°F (10°C)
	Recoat	16-72 hours at 70°F (21°C), 72-96 hours at 50°F (10°C)	16-72 hours at 70°F (21°C)	24-72 hours at 40°F (5°C)	4 hours at 70°F (21°C), 8 hours at 50°F (10°C)
Dry Heat Resistance		300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), 125°F (52°C): for immersion service Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)	300°F (149°C), Color may shift above 150°F (66°C)
Safety Information	Flash Point	110°F (43°C)	110°F (43°C)	110°F (43°C)	68°F (20°C)
	Contains	Lead-free	Lead-free	Lead-free	Lead-free
	Warning!	FLAMMABLE LIQUID AND VAPOR. HARMFUL IF INHALED. CAUSES RESPIRATORY TRACT, EYE AND SKIN IRRITATION. MAY AFFECT THE BRAIN OR NERVOUS SYSTEM CAUSING DIZZINESS, HEADACHE OR NAUSEA. MAY CAUSE ALLERGIC SKIN REACTION. FOR INDUSTRIAL OR COMMERCIAL USE ONLY. REFER TO MATERIAL SAFETY DATA SHEET (MSDS) FOR ADDITIONAL INFORMATION.			

*Activated material. **Pot life is affected by air temperature, amount of material activated and quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour). In hot weather, thin activated material with 10% 160 Thinner or 165 Thinner for 9102 activated material.

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