



UNI-BOND MASTIC SERIES 118

PRODUCT PROFILE

GENERIC DESCRIPTION Mastic Waterborne Acrylic

COMMON USAGE A high-build, rust-inhibitive, elastomeric coating formulated for exceptional adhesion and corrosion resistance over minimally prepared aged coating systems. Series 118 is an excellent choice for projects where abrasive blast cleaning of the substrate is not possible and an anti-corrosive coating is needed. Uni-Bond Mastic accepts a variety of high-performance topcoats for the creation of a long-term protective and aesthetic coating system.

COLORS 1281 White, 03BR Washed Khaki, 06WH Albatross, 18YW Sponge, 19RD Salmon, 20GN Fairway, 25BL Fountain Bleu, 30GR Comet, 34GR Deep Space, 36BL Touch of Blue, 45GR Captain Hook, 83BR Kindling.

FINISH Matte

COATING SYSTEM

PRIMERS **Steel:** Self-priming

TOPCOATS Series 30, 72, 73, 700, V700, 701, V701, 740, 750, 1026, 1028, 1029, 1070, 1070V, 1071, 1071V, 1072, 1072V, 1074, 1074U, 1075, 1075U or 1095. **Note:** Series 118 is not intended to be a finish coat. A topcoat is strongly recommended for aesthetics and avoidance of dirt accumulation.

SURFACE PREPARATION

STEEL Minimum surface preparation of bare steel or previously painted steel requires a cleanliness level as defined by SSPC-SP WJ-4/NACE WJ-4 Light Cleaning by use of Low Pressure Water Cleaning (LP WC) between 3,500 and 5,000 psi using a 0 degree rotating nozzle. If all visible contaminants, loose mill scale, loose rust and other corrosion products, and loose paint have not been removed, SSPC-SP2 Hand Tool Cleaning or SSPC-SP3 Power Tool Cleaning should be employed until the surface cleanliness definition is met.

GALVANIZED STEEL & ALUMINUM Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

ALL SURFACES Must be clean, dry and free of dust, dirt, oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 55.0 ± 2.0% †

RECOMMENDED DFT 6.0 to 8.0 mils (150 to 205 microns) per coat. **Note:** Two coats are required over bare steel. Overcoating an aged system that is mostly intact and tightly adhered can be achieved by spot priming prior to applying a full coat.

| CURING TIME | Temperature | To Touch | To Handle | To Recoat |
|-------------|-------------|------------|-----------|-----------|
| | 75°F (24°C) | 30 minutes | 4 hours | 8 hours |

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 0.26 lbs/gallon (31 grams/litre) †

HAPS **Unthinned:** 0.02 lbs/gal solids

THEORETICAL COVERAGE 882 mil sq ft/gal (21.6 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

PACKAGING 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

NET WEIGHT PER GALLON 11.51 ± 0.25 lbs (5.1 ± .11 kg) †

STORAGE TEMPERATURE Minimum 45°F (7°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 170°F (77°C) Intermittent 200°F (93°C)

SHELF LIFE 6 months at recommended storage temperature

FLASH POINT - SETA N/A

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

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APPLICATION

COVERAGE RATES

| | Dry Mils (Microns) | Wet Mils (Microns) | Sq Ft/Gal (m ² /Gal) |
|-----------|--------------------|--------------------|---------------------------------|
| Suggested | 7.0 (175) | 13.0 (330) | 126 (11.7) |
| Minimum | 6.0 (150) | 11.0 (280) | 147 (13.7) |
| Maximum | 8.0 (205) | 15.0 (380) | 110 (10.2) |

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

MIXING

Mix by stirring to uniform consistency without creating air bubbles. Stir thoroughly, making sure no pigment remains on the bottom of the can.

THINNING

DO NOT THIN.

APPLICATION EQUIPMENT

Airless Spray

| Tip Orifice | Atomizing Pressure | Mat'l Hose ID | Manifold Filter |
|------------------------------------|--------------------------------|------------------|--------------------------|
| 0.015"-0.027" (380-685 microns) | 2500-3000 psi (172-206 bar) | 3/8" (9.5 mm) | 30 mesh (600 microns) |

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Rolling is an acceptable method of building a film to the proper thickness, however it will not produce an aesthetically pleasing finish. Use 3/8" to 3/4" (9.5 mm to 19.0 mm) synthetic woven nap covers. Multiple coats may be required to achieve recommended film thickness, depending on applicator technique and roller nap size.

Brush: Recommended for small areas only. Use a stiff nylon brush. Work material into voids and avoid brushing out too thin. **Note:** Applying this product by roller or brush will result in a film with stiple and/or brush marks.

SURFACE TEMPERATURE

Minimum 45°F (7°C) Maximum 120°F (49°C)
The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with clean tap water. Finish by flushing all spray equipment with isopropyl alcohol.

† Values may vary with color.

CAUTION

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

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