THIS METHOD STATEMENT COVERS PREPARATION AND APPLICATION OF **MasterProtect 1816**, A HIGH BUILD EPOXY POLYSULFIDE COATING

METHOD STATEMENT: MasterProtect 1816

NON-TOXIC, FLEXIBLE, CHEMICAL RESISTANT, SOLVENT FREE, HIGH BUILD, EPOXY POLYSULFIDE COATING.

1. GENERAL:

1.1. The area to be coated shall be marked on the drawings and on the structure.

1.2. All areas not to be coated, but which may be affected by spillage or overspray shall be fully masked. Flora and fauna shall be protected.

1.3. Any further areas to be coated shall be at the discretion of the Engineer and subject to re-measurement.

1.4. All deviations from the original Bill of Quantities or scope of works must be agreed in writing with the Engineer before application starts.

2. PREPARATION:

2.1. All surfaces shall be free from oil, grease, friable matter and general curing compounds (wax based curing membranes shall not be used in areas to be over coated).

2.2. Concrete surfaces shall be cleaned using high pressure water jetting, grit blasting or other methods approved by the Engineer.

2.3. For steel surfaces, dry abrasive blast to Sa 3 SIS (Swedish Standards) or Steel Structure Painting Council SP-5. Blasted surface should have a minimum anchor profile of 50µm.

2.4. Arrases shall be rounded off and surface protrusions shall be ground down to ensure a smooth substrate.

2.5. All blow holes and other surface defects shall be made good using **MasterBrace ADH 2200**.

2.6. Mix Part A with Part B until a uniform, streak free color is obtained. Full packs only shall be mixed.

2.7. Application shall be by spatula or trowel, ensuring blow holes and other minor defects are completely filled.

3. TEMPERATURE CONDITION:

3.1. **MasterProtect 1816** shall be used when the ambient temperature is above 14°C.

3.2. Substrate temperatures should not be less than 14°C. In hot weather, areas to be coated shall be shaded from direct sunlight to prevent the substrate temperature exceeding 40°C.

3.3. Coating shall not be applied if the humidity is likely to rise above RH 85% or the dew point is reached before or during the application.

3.4. Moisture content of the substrate should not exceed 4%.

4. MIXING:

4.1. The total contents of the reactor component shall be poured into the base component and mixed, using a slow speed drill 200 – 300rpm with suitable mixing attachment. Mixing time shall not be less than 2 minutes and continue until a uniform color is achieved.

4.2. Care shall be taken to insert the mixing head slowly into the base material due to the high viscosity of the resin.

5. APPLICATION:

5.1. Application shall be by brush, short hair roller or airless spray.

5.2. The first coat shall be applied at a rate of 0.25 L/m² giving total coverage of the prepared area.

5.3. The coating shall then be inspected for any pinholes or other defects. These shall be made good with **MasterBrace ADH 2200**.

5.4. A minimum of two coats is recommended.

5.5. The second and subsequent coat shall be applied to the right angles of the previous coat and within 16 hours at 40°C or 36 hours at 20°C. If the application of the subsequent coat is delayed the previous coat shall be abraded and wiped with a lint free cloth, dampened with Xylene / MEK / Acetone immediately prior to the application of subsequent coats.

6. AIRLESS SPRAY:

6.1. For large areas, Airless Spray application can be used. Airless Spray equipment such as Graco Bulldog Hydra, De Vilbiss, Nordon-Bede or Spee-Flo with a fluid tip between 0.5 to 0.8 mm opening should be used.

6.2. Or alternatively one can use a 45:1 or higher ratio pump, minimum 9mm dia. hoses and HD tip 19-23 thou.