



HEAVY DUTY
PROTECTIVE COATINGS

Mult-E-Poxy 230 AL

Epoxy Mastic Aluminum

LF-2230 Part A
LM-0230 Part B



Technical Data

PRODUCT DESCRIPTION

A versatile, self-priming, 2 component, high solids epoxy mastic aluminum, formulated for heavy duty industrial maintenance application on wide variety of substrates. Protects against abrasion, moisture, corrosive fumes and chemical contact. Surface tolerant over tightly adhering rust and most tightly adhered, existing coatings. Cures through a wide range of temperatures. V.O.C. compliant.

INTENDED USES

Designed for heavy duty commercial and industrial maintenance on properly prepared structural steel, tank exteriors, pipes and galvanized metal substrates. These are typical uses and are not intended to limit the use of this product. **Contact Diamond Vogel Technical Service for detailed information.**

PHYSICAL PROPERTIES

Color	Aluminum. * Epoxies will chalk and fade with extended exposure to sunlight.	
Finish/Sheen	Semi-Gloss	
Bases (Part A)	LF-2230	
Cure (Part B)	LM-0230	
Resin Type	2 Component Epoxy	
Clean-up Solvents	Diamond Vogel N-3023 Xylol	
Solids By Weight	81%	
Solids by Volume	74% + or - 2%	
Theoretical Coverage	1187 ft ² /gal @ 1 mil	
Dry Film Thickness / Coat	5 - 8 mils (125 - 200 microns)	
Wet Film to Achieve DFT	7 - 11 mils (175 - 275 microns)	
Coverage at DFT	148 - 257 ft ² /gal @ 5 - 8 mils DFT	
VOC	1.9 lbs./gal. (228 grams/liter) activated / unthinned 2.0 lbs./gal. (240 grams/liter) activated / thinned	
Induction time	None	
Mixing ratio (by volume)	1 part resin to 1 part cure	
Thinning (as needed)	Up to ½ pint of Diamond Vogel N-3023 Xylol per gallon of <i>activated</i> material	
** Pot life [At 70°F (21°C)]	5½ hours	
Drying Time* (hours)	<u>At 70°F (21°C)</u>	
[ASTM D1640] - 83 Reapproved 1989	Set to Touch	8-9 hours
	Dry Through	12 hours
* Dry times vary with surface temperature, air movement, humidity and film thickness.		
** Extreme temperatures can dramatically shorten Pot life.		

RECOAT/TOPCOAT

Recoat Time*	<u>Product</u>	<u>Minimum Recoat</u>	<u>Maximum Recoat</u>
[At 70°F (21°C)]	MEP 230 AL/MEP 230 AL	12-14 hours	6 months
	MEP 230 AL/Mult-E-Poxy 180	12-14 hours	6 months
	MEP 230 AL/Pinnacle 330HS	12-14 hours	2 weeks
	MEP 230 AL/V-Tech 500	12-14 hours	6 months
	MEP 230 AL/V-Cote 222	12-14 hours	2 weeks

* Recoat times vary with surface temperature, air movement, humidity and film thickness.

** Coverage rates are estimates based on the products volume solids and make no allowance for material loss during application. Actual spread rates may vary dependent on applicator experience, surface porosity and texture.

RECOMMENDED TOPCOATS

Multi-E-Poxy 230 AL Epoxy Mastic Aluminum
Multi-E-Poxy 180 Epoxy Mastic
Pinnacle 330HS Polyurethane
V-Cote 222 Acrylic Maintenance Finishes (MC-Series)

SURFACE PREPARATION

All surfaces must be dry, cured, clean, sound and free of all dirt, dust, efflorescence, wax, oil, grease, chalk and any other contamination that would interfere with new coating adhesion. Bare surfaces must be properly prepared prior to application of this product.

Ferrous Metal Surfaces:

Abrasive blast new steel to SSPC-SP-6. Use proper abrasive to achieve an average of 1.5 to 2 mil profile. Blasted surfaces should be primed before flash rusting occurs. If blasting is not practical, remove loose rust and mill scale with hand or power abrading tools as per SSPC-SP-2 and SSPC-SP-3. Treat rust free, cold rolled steel with a metal cleaning and etching solution.

New Galvanized & Aluminum Surfaces:

Remove surface contamination or passivators by scrubbing with a cleaning & etching solution or blast per SSPC-SP-7 Brush-off Blast.

Weathered Galvanized & Aluminum Surfaces:

Power or hand wash with detergent and rinse thoroughly. The surface must be dull and have a profile; use a cleaning & etching solution if needed.

Previously Painted Surfaces:

Power or hand washing is recommended to remove contamination. If oil or grease is present, use of a cleaner/degreaser is required. All cleaning residue must be completely rinsed from the surface. Allow to dry. Remove all loose coatings, rust and corrosion by scraping, sanding or other abrading method as per SSPC-SP-2 and SSPC-SP-3. For complete removal of the old coating, abrasive blast according to SSPC-SP-6 Commercial Blast. Use sandpaper to dull slick, glossy and/or non-porous surfaces with sandpaper.

Mildew:

Remove by using a solution of one part household bleach and three parts water. Apply to mildewed area and scrub. Allow solution to remain on the surface for 3 to 5 minutes and then rinse completely and allow to dry before coating application.

APPLICATION

Part A (epoxy resin) and part B (cure) have a 1:1 mixing ratio. Mix Part A and Part B separately using an explosion-proof power drill and Jiffler mixer. Add part B to part A and thoroughly mix and blend. Mix only the amount that can be used within the estimated pot life. For optimum application, material should be from 50° to 90°F (10° to 32°C). Above 122°F (50°C), sagging may occur. Surface temperature must be at least 5° above dew point.

Brush or Roller:

Apply product in full even coats. Maintain a wet edge. To insure adequate film build, two coats are recommended when applying by brush or roller (See *Recoat/Topcoat* for recoat period).

Airless Spray:

Flush airless lines with Xylol. Equipment must be clean prior to start. Thin only as needed for workability. Apply a wet coat in even, parallel passes with 50 % overlap to avoid bare areas and pinholes. If required, crosshatch spray at right angles.

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.019" to 0.021"	2500-3000 psi	1/4" or 3/8"	60 mesh

STORAGE

Store in protected area maintained at 40 - 100°F (4 - 38°C).

SHELF LIFE

Two years from date of manufacture when maintained in protected storage. Subject to inspection thereafter.

SAFETY DATA

"Material Safety Data Sheets" are available from your Diamond Vogel representative. Prior to use of this product, obtain and review the Material Safety Data Sheet for health and safety information. Read and observe all precautionary notices on container labels. NOT INTENDED FOR RESIDENTIAL USE.

LIMITED WARRANTY

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Diamond Vogel Paints does not control the application of its products, or the condition of the surfaces to which they are applied, Diamond Vogel Paint's liability will under no circumstances exceed replacement of the product. **All technical information is subject to change without notice.**