

PRODUCT DATA SHEET

RomoCoat 1256-HB Mastic Epoxy Paint

RomoCoat 1256-HB Mastic Epoxy is a **fast-drying, high-solids, surface-tolerant epoxy mastic** for heavy-duty protection of steel and concrete in aggressive industrial and marine environments.

Product description

- Two-component, high-build, polyamide-adduct cured epoxy mastic with very high volume solids (~80%) and excellent wetting properties.
- Forms a very hard, tough yet flexibilised coating that cures even at relatively low temperatures and tolerates marginally prepared substrates (within limits).
- Can act as self-priming coat, intermediate, or finish coat in low-VOC, high-build heavy-duty systems.



Typical applications

- 1) Marine & offshore (ballast tanks, underwater hull, splash zone)
- 2) Industrial & coastal structural steel
- 3) Heavy-duty maintenance coating (surface-tolerant)
- 4) Immersion & water/waste-water service (where specified)
- 5) New-build steel where low VOC + high build are needed

Product data

• Mixing ratio	: 4 : 1 by volume (Base : Hardener).
• Pot life	: 4–5 hours at 30 °C.
• Application methods	: airless spray, brush (roller possible for touch-up / small areas).
• Volume solids	: approx. 80%.
• Finish	: egg-shell.
• Colour	: grey.
• Recommended DFT per coat	: 80–100 µm.

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ROSALEE COLOURS PVT. LTD. - MONARCH CREATIONS GROUP

Mfg. Of Anti-Corrosive Primers, Epoxy – PU Paints, Rebar Protective Coat, Marine-Industrial Paints

Office: 219, Narshi Natha Street, Mumbai-9 Factory: C-1, GIDC, Waghodia, Dist: Vadodara, Pin: 391760, India

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• Theoretical spreading rate	: 10.00–8.00 m ² /L at 80–100 µm DFT
• Drying & curing (30 °C)	: Touch dry: 3–3.5 hours. Hard dry: ~16 hours. Fully cured: ~7 days.
• Overcoating interval	: Minimum: 16 hours at 30 °C
• Flash point	: above 23 °C.
• Thinner	: Thinner-1256 dedicated epoxy mastic thinner

Surface preparation

Because it is **surface-tolerant**, requirements are slightly relaxed compared to conventional epoxies, but proper cleaning is still critical:

- General requirement:
 - Surface must be dry, and free from oil, grease, salts, dust and loose rust/paint; high-pressure fresh-water wash often recommended before mechanical prep.
- For best performance (new steel):
 - Abrasive blast cleaning to Sa 2½ with suitable profile is preferred, especially for long-life systems and immersion/ballast tank service.
- Maintenance / marginal prep situations:
 - Power-tool cleaning or St 2/St 3 (wire brushing, needle gunning, grinding) to remove loose rust and poorly adhering coatings, leaving sound, tightly adherent substrate and firm old coating.
 - Suitable for application over sound, aged epoxy, inorganic zinc silicate, and some other coatings after proper cleaning and roughening.
- Recoating / max interval:
 - The indicated maximum recoating interval (4 weeks) applies to overcoating with itself or compatible topcoats.
 - At long recoat intervals, surface must be clean (no chalking, salts, oil) and roughened (light sweep-blast or sanding) before further coats.

Application guidance

- Mix base and hardener at 4:1 by volume; power-mix until homogeneous, scraping sides and bottom of container.
- Allow any specified induction time if your internal standard requires (often not necessary with mastic epoxies, but follow in-house QC).

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- Adjust viscosity with Thinner-1256 only as required; avoid over-thinning as this reduces film build and may affect sag resistance and tolerance.

Airless spray (preferred):

- Typical nozzle: 0.017"-0.021" (per your internal spec), high-pressure pump (e.g. 180–230 bar) for high-build application.
- Apply in one or two passes to achieve 80–100 µm DFT per coat; avoid excessive single-coat build beyond spec to prevent internal stress and potential cracking, especially in ballast tanks.

Brush:

- Use for touch-up, edges, welds, small areas and stripe coats; ensure required DFT is achieved, often requiring two passes.

Systems examples:

- Immersion / ballast tanks:
 - 2–3 x RomoCoat 1256-HB Mastic Epoxy to achieve total 200–300 µm DFT, or
 - 1–2 x 1256-HB + compatible epoxy tie-coat / antifouling as per spec.
- Atmospheric C4–C5:
 - 1 x RomoCoat 1256-HB (self-priming) → 1 x 1256-HB or PU topcoat, or
 - 1 x zinc-rich primer → 1 x 1256-HB → PU finish for maximum life.

Health & safety

- Avoid inhalation of solvent vapours and paint mist; avoid contact with skin and eyes. Use appropriate PPE: organic vapour respirator, gloves, safety goggles and protective clothing as per local regulations.
- Provide forced ventilation when working in confined spaces or areas with stagnant air (ballast tanks, hull internals, closed rooms).
- Follow MSDS for first aid, spill control and disposal; do not discharge into drains or watercourses.

Storage

- Store in a cool, dry, well-ventilated place, away from direct sunlight, heat and open flames.
- Keep containers tightly closed when not in use; avoid moisture ingress into hardener and base.
- Shelf life is typically 12 months in unopened original containers under recommended conditions (confirm via internal QC label).

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