

## PRODUCT DATA SHEET

### RomoCoat 1257 Surface Tolerant Epoxy Paint

RomoCoat 1257 Surface Tolerant Epoxy Paint is a **two-component, high-solids, surface-tolerant epoxy mastic/primer** for heavy-duty protection of steel in marine and industrial environments, especially where surface preparation is limited.

#### Product description

- Two-pack, high-build polyamide-adduct cured epoxy with very high volume solids (~80%), giving low VOC and thick films in one or two coats.
- Very hard, tough yet flexibilised film with excellent wetting of marginally prepared steel; cures at relatively low temperatures and acts as a surface-tolerant epoxy primer or self-priming coat.



#### Typical applications

- 1) Marine & offshore (immersion and splash zone)
- 2) Coastal & industrial structural steel
- 3) Heavy-duty maintenance coating (surface-tolerant)
- 4) New steel & low-VOC high-build systems

#### Product data

- Mixing ratio : 3 : 1 by volume (Base : Hardener).
- Pot life : 4–5 hours at 30 °C.
- Application methods : airless spray, brush (roller for small/touch-up areas)
- Volume solids : approx. 80%.
- Colour : silver aluminium.
- Finish : egg shell.
- Specific gravity : 1.40 ± 3%.
- Recommended DFT/coat : 100–125 µm.
- Theoretical spreading rate : 8.00–6.4 m<sup>2</sup>/L at 100–125 µm DFT (on smooth surfaces; practical coverage lower due to losses and profile).

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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

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- Drying & curing (30 °C) : Touch dry: 2–3 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 system for spray / viscosity adjustment.

## Surface preparation

Even though it is surface-tolerant, **good preparation is still essential** for long-term performance:

- General:
  - Surface must be dry and free from oil, grease, salts, dust and loose rust/paint; high-pressure fresh-water wash is recommended before mechanical cleaning.
- Best practice (new steel / severe duty, immersion):
  - Abrasive blast cleaning to Sa 2½ with an appropriate profile where possible, especially for ballast tanks and long-life systems.
- Surface-tolerant / maintenance situations:
  - Where blasting is not possible, clean to St 2/St 3 by power tools (wire brushing, needle-gunning, grinding) to remove loose rust and poorly adherent coatings, leaving tight rust and sound coatings.
  - Remove all salts and contaminants before coating; ensure no loose rust, mill scale or flaking paints.
- Recoating window:
  - The stated maximum recoating interval applies to overcoating with itself or compatible topcoats; beyond this, surface must be cleaned and roughened to restore adhesion.

## Application guidance

- Mix base and hardener at 3:1 by volume; power-mix until uniform, scraping sides/bottom of container.
- Use only the recommended “Surface Tolerant Thinner” for thinning; keep added thinner to the minimum needed for spray application.

Airless spray (preferred for high build):

- Typical tip range (by analogy with similar epoxies): around 0.017"–0.021" with adequate pump pressure to achieve 100–125 µm in one or two passes, avoiding excessive DFT that can cause internal stresses, especially in ballast tanks.

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Brush / roller:

- For touch-up, edges, welds and small areas; may require multiple passes to reach specified DFT.

Systems examples:

- Ballast tanks / immersion (project dependent):
  - 2–3 x RomoCoat Surface Tolerant 1257 to achieve 250–350 µm DFT, or 1–2 x 1257 plus compatible epoxy lining, as per specification.
- Atmospheric C4–C5:
  - 1 x 1257 (self-priming) → 1 x 1256 or PU / polysiloxane topcoat (for UV/gross colour retention) for long-life systems.

## Health & safety

- Avoid inhalation of solvent vapours and spray mist; avoid contact with skin and eyes. Use gloves, goggles and suitable respirator according to local regulations.
- Ensure forced ventilation when working in confined or stagnant areas (tanks, hulls, closed rooms).
- Follow SDS/MSDS for first aid, spill management and disposal; do not discharge into drains or water bodies.

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