



PROTUFF MASTIC SERIES 132

PRODUCT PROFILE

GENERIC DESCRIPTION Phenalkamine Epoxy Mastic

COMMON USAGE Series 132 is versatile, high-build, surface tolerant epoxy mastic designed for application over tightly adhered light corrosion and marginally prepared or previously coated steel, or as a primer/intermediate coat under weather-able finishes. Series 132 may be applied at low-temperatures, over dew point conditions and on damp surfaces.

COLORS A11417 Light Gray, 1211 Red, 1252 Beige. **Note:** Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, miscatalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may cause yellowing to occur. Due to product's curing chemistry, color change or variation may occur. These changes are aesthetic only and will not affect performance.

FINISH Semi-gloss

COATING SYSTEM

PRIMERS Self-priming

TOPCOATS **Exterior:** Series 72, 73, 138, 180, 1028, 1029, 1074, 1074U, 1075, 1075U, 1094, 1095, 1096. Refer to COLORS on applicable topcoat data sheets for additional information. **Note:** The following maximum recoat time applies when using Series 72, 73, 138, 180, 1028, 1029, 1074, 1074U, 1075, 1075U, 1094, 1095 or 1096: fourteen (14) days. If this time limit is exceeded, Series 132 must be uniformly scarified prior to topcoating.

SURFACE PREPARATION

STEEL Minimum surface preparation of bare steel or previously painted steel requires a cleanliness level as defined by SSPC-SPWJ-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 contaminates, 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 & NON-FERROUS METAL Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.

PAINTED SURFACES Test patch is recommended.

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

TECHNICAL DATA

VOLUME SOLIDS 81% ± 2.0% (mixed)

RECOMMENDED DFT 4.0 to 18.0 mils (100 to 455 microns) in one coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME

Temperature	To Handle/To Recoat	Max Recoat
90°F (32°C)	3 hours	14 days
75°F (24°C)	4 hours	14 days
65°F (18°C)	7 hours	14 days
55°F (11°C)	13 hours	14 days
45°F (7°C)	20 hours	14 days
35°F (2°C)	48 hours	14 days
20°F (-6°C)†	n/a	14 days

† Substrate temperature should not be below 35°F (2°C) during application. However, Series 132 will continue to cure below freezing temperatures. Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 1.30 lbs/gal (156 g/l)
Thinned 5% (No. 4 Thinner): 1.57 lbs/gal (188 g/l)

HAPS **Unthinned:** 1.26 lbs/gal solids
Thinned 5% (No. 4 Thinner): 1.61 lbs/gal solids

THEORETICAL COVERAGE 1,299 mil sq ft/gal (31.5 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Four (Part A) epoxy to one (Part B) amine.

PACKAGING

	Part A	Part B	When Mixed
Large Kit	1-6 gallon pail (partially filled)	1-1 gallon pail	5 gallons (18.9 L)
Small Kit	1-1 gallon can (partially filled)	1-quart can (partially filled)	1 gallon (3.79 L)

NET WEIGHT PER GALLON 12.47 ± 0.25 lbs (5.66 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 50°F (10°C) Maximum 110°F (43°C)
Prior to application, the material temperature should be above 60°F (16°). It is suggested the material be stored at this temperature at least 48 hours prior to use.

TEMPERATURE RESISTANCE (Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

SHELF LIFE 12 months at recommended storage temperature.

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FLASH POINT - SETA Part A: 87°F (30°C) Part B: 185°F (85°C)

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

APPLICATION

COVERAGE RATES		Dry Mils (microns)	Wet Mils (microns)	Sq Ft/Gal (m ² /gal)
	Minimum	4.0 (100)	5.0 (125)	325 (6.7)
	Maximum	18.0 (455)	22.0 (564)	72 (6.7)

Note: Roller or brush application requires multiple coats to obtain recommended film thickness. 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 thickness may adversely affect coating performance.

MIXING Mix the entire contents of Part A and Part B separately. Scrape all of the Part B into the Part A pail by using a flexible spatula. Use a variable speed drill with a PS Jiffy blade and mix the blended components for a minimum of two minutes. Apply the mixed material within pot life limits after agitation. Both components must be above 50°F (10°C) prior to mixing. For optimum application properties, the material temperature should be above 60°F (16°C). For applications to surfaces between 35°F to 50°F (2°C to 10°C) allow mixed material to stand 30 minutes and restir before use. **Note:** A large volume of material will set up quickly if not applied or lessened in mass. **Caution: Do not reseal mixed material. An explosion hazard may be created.**

THINNING **Caution: Do not add thinner to Part A prior to mixing with Part B.** Thin up to 5% or 6.4 ounces (189 mL) per gallon with No. 4 Thinner.

POT LIFE 1 1/2 hours at 77°F (21°C) 1 hours at 90°F (32°C)

SPRAY LIFE 45 minutes at 77°F (21°C)

SUBSTRATE CONDITIONING Do not apply over puddles, ponding, or standing water. All standing and heavy accumulations of water must be removed before application. In the case of sweating pipes accumulated water must be removed. Brush, roll, or spray/backroll to displace water and create a monolithic film in direct contact with substrate.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss IGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	1/4" (6.35 mm)	60-80 psi (4.1-5.5 bar)	25-35 psi (1.7-2.4 bar)

Low temperature or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.021" (430-535 microns)	3400-4760 psi (234-328 bar)	3/8" (9.5 mm)	60 mesh (250 microns)

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

Roller: Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic nap covers.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE Minimum 35°F (2°C) Maximum 135°F (57°C)

CLEANUP Flush and clean all equipment immediately after use with the recommended thinner or MEK.

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