

## Jotamastic 87 GF

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### Product description

This is a two component polyamine cured epoxy mastic coating. It is a surface tolerant, high solids, high build product. It is reinforced with glass flakes for improved abrasion and scratch resistance. Specially designed for areas where optimum surface preparation is not possible or desired. Provides long lasting protection in environments with high corrosivity. Can be used as primer, mid coat, finish coat or as single coat system in atmospheric and immersed environments. Suitable for properly prepared carbon steel and aged coating surfaces. It can be applied at sub zero surface temperatures.

### Scope

The Application Guide offers product details and recommended practices for the use of the product.

The data and information provided are not definite requirements. They are guidelines to assist with efficient and safe use, and optimum service of the product. Adherence to the guidelines does not relieve the applicator of responsibility for ensuring that the work meets specification requirements. Jotun's liability is in accordance with general product liability rules.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

### Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

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### Surface preparation

The required quality of surface preparation can vary depending on the area of use, expected durability and if applicable, project specification.

When preparing new surfaces, maintaining already coated surfaces or aged coatings it is necessary to remove all contamination that can interfere with coating adhesion, and prepare a sound substrate for the subsequent product.

Inspect the surface for hydrocarbon and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area using fresh water. Paint solvents (thinners) shall not be used for general degreasing or preparation of the surface for painting due to the risk of spreading dissolved hydrocarbon contamination. Paint thinners can be used to treat small localized areas of contamination such as marks from marker pens. Use clean, white cotton cloths that are turned and replaced often. Do not bundle used solvent saturated cloths. Place used cloths into water.

### Process sequence

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter and treatment of welds is complete. It is important that all hot work is completed before coating commences.

### Soluble salts removal

Soluble salts have a negative impact on the coating systems performance, especially when immersed. Jotun's general recommendations for maximum soluble salts (sampled and measured as per ISO 8502-6 and -9) content on a surface are:

For areas exposed to (ISO 12944-2):

C1-C4: 200 mg/m<sup>2</sup>

C5M or C5I: 100 mg/m<sup>2</sup>

Im1-Im3: 80 mg/m<sup>2</sup>

## Carbon steel

### Initial rust grade

The steel shall preferably be Rust Grade A or B (ISO 8501-1). It is technically possible to apply the coating to rust grades C and D, but it is practically challenging to ensure specified film thickness on such a rough surface, hence risk of reduced lifetime of the coating system. When steel of Rust Grade C or D is coated, the frequency of inspection and testing should be increased. For steel with Rust Grades C or D, contact your nearest Jotun office for advice.

### Metal finishing

For areas in corrosivity category C1 to C4 (ISO 12944-2) all irregularities, burrs, slivers, slag and spatter on welds, sharp edges and corners shall conform to minimum grade P2 (ISO 8501-3) Table 1, or as specified. All edges shall have a rounded radius of minimum 2 mm subjected to three pass grinding or equally effective method.

For areas in corrosivity category C5 the requirement is conformance to grade P3 (ISO 8501-3) Table 1. Defective welds shall be replaced and treated to an acceptable finish before painting. Temporary welds and brackets shall be ground to a flat finish after removal from the parent metal.

### Pitting repair

Pittings in steel can be difficult to cover fully with most coatings. In some areas it is practically feasible to use filler to fill pittings. This should then be done either after the initial surface preparation or after application of first coat.

## Abrasive blast cleaning

### Cleanliness

After pre-treatment is complete, the surface shall be dry abrasive blast cleaned to Sa 2 (ISO 8501-1) using abrasive media suitable to achieve a sharp and angular surface profile.

### Surface profile

Recommended surface profile 30-85 µm, grade Fine to Medium G (ISO 8503-2).

### Abrasive media quality

The selected abrasive must be compatible with both the surface to be blast cleaned and the specified coating system. The abrasive shall meet specifications as per relevant parts of ISO 11124 (Specification for metallic blast-cleaning abrasives), or ISO 11126 (Specification for non-metallic blast-cleaning abrasives). It should be sampled and tested as per relevant parts of ISO 11125 (metallic abrasives) or ISO 11127 (non-metallic abrasives). Dry storage of abrasive and shelter for blasting pots is necessary to prevent equipment becoming clogged with damp abrasive.

All abrasive blast media used should be new and not recirculated, with the exception of Steel Grit. If this is utilized the circulation process must include a cleaning process.

### Compressed air quality

The supply of clean air to blasting pots must be secured to avoid contamination of abrasive and thereby of blast cleaned surfaces. Compressors must be fitted with sufficient traps for oil and water. It is also recommended to fit two water separators at the blasting machine to ensure a supply of moisture-free air to the abrasive chamber.

### Dust contamination

At the completion of abrasive blasting the prepared surface shall be cleaned to remove residues of corrosion products and abrasive media, and inspected for surface particulate contamination. Maximum contamination level is rating 2 (ISO 8502-3) as per Figure 1. Dust size no greater than class 2.

## Hand and Power Tool Cleaning

### Power tool cleaning

Surfaces to be coated shall be prepared by mechanical preparation methods to minimum St 2 (ISO 8501-1). Suitable methods are disc grinding, hand sanding or hand wire brushing. Ensure the surface is free from mill scale, residual corrosion, failed coating and is suitable for painting. If power wire brushing is used, care should be taken not to polish the metal surface, as this can reduce adhesion of the coating. The surface should appear rough and mat.

Overlapping zones to intact coating shall have all leading edges feathered back by sanding methods to remove all sharp leading edges and establish a smooth transition from the exposed substrate to the surrounding coating. Consecutive layers of coating shall be feathered to expose each layer and new coating shall always overlap to an abraded existing layer. Abrade intact coatings around the damaged areas for a minimum 100 mm to ensure a mat, rough surface profile, suitable for over coating.

### Water jetting

High pressure water jetting surface preparation refers to ISO 8501-4, for substrates previously coated either with a full coating system (surface DC A, DC B, DC C) or shop primer (surface DP I and DP Z). The surface definition for existing coating (DC) refers to the degree of coating breakdown according to ISO 4628.

It is important before considering hydro jetting, to ensure that the specified coating system is compatible with the existing coating system. High pressure water jetting does not remove mill scale or create surface roughness, and is only useful for surfaces with an initial roughness suitable for the subsequent coat.

Optimum performance is achieved with preparation grade Wa 2 (ISO 8501-4). Minimum preparation grade is Wa 1. For DP I and DP Z surface Wa 2 is accepted.

Maximum accepted grade of flash rust for any preparation is FR M (ISO 8501-4). Alternatively minimum approved preparation grade is SSPC-SP WJ-2/ NACE WJ-2, Very thorough cleaning.

Maximum accepted flash rust grade is Moderate (M).

## Galvanised steel

### Hand and Power Tool Cleaning

After removal of excess zinc and surface defects the area to be coated shall be degreased with an alkaline detergent, washed by Low-Pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard and the surface abraded using mechanical or hand sanding methods using non-metallic abrasives or bonded fibre abrasive pads to remove all polish and to impart a scratch pattern to the surface. Do not use high speed rotational sanders.

### Water jetting

Inspect the surface for process residues, hydrocarbon contamination and zinc corrosion by-products. If present, remove with an alkaline detergent. Agitate the surface to activate the detergent and before it dries, wash the treated area by Low-Pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard using fresh water.

Optimum performance is achieved with preparation to a grade corresponding to the description of Wa 2½.

Minimum preparation grade is Wa 1.

## Aluminium

### Abrasive blast cleaning

After pre-treatment of welds, sharp edges, removal of weld spatter and other surface contamination the surface shall be degreased using an alkaline detergent which is agitated with non-metallic brushes and removed by Low-pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard with fresh water. The surface shall be then dry abrasive blast cleaned with an approved non-metallic abrasive media to create a sharp and angular surface profile. As a guide, a surface profile between 25-55 µm, grade Fine G; Ry5 (ISO 8503-2) should be achieved.

### Hand and Power Tool Cleaning

After pre-treatment of welds, sharp edges, removal of weld spatter and other surface contamination the surface shall be degreased using an alkaline detergent which is agitated with non-metallic brushes and then fresh water rinsed. The cleaned surface shall be then hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to remove all surface polish and to impart a scratch pattern to the surface. Do not use high speed rotational sanders.

### Water jetting

Surfaces not contaminated with hydrocarbon deposits shall be cleaned by Low-pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard using fresh water to remove all dusts, chloride and non-visible contamination. Optimum performance is achieved with preparation to a grade corresponding to the description of Wa 2½. Minimum preparation grade is Wa 1.

## Stainless steel

### Hand and Power Tool Cleaning

After pre-treatment of welds, sharp edges, removal of weld spatter and other surface contamination the surface shall be degreased with an alkaline detergent, washed by low-pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard and hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to remove all polish and to impart a scratch pattern to the surface. Do not use high speed rotational sanders.

### Water jetting

Inspect the surface for oil and hydrocarbon contamination and if present, remove with an alkaline detergent. Agitate the surface with non-metallic brushes to activate the detergent and before it dries, wash the treated area by low-pressure Water Cleaning (LPWC) to a grade corresponding to the description of Wa 1 (ISO 8501-4) or higher standard using fresh water to remove contamination and reduce salt concentration. Optimum performance is achieved with preparation to a grade corresponding to the description of Wa 2½. Minimum preparation grade is Wa 1.

Chlorinated or chlorine containing solvents or detergents must not be used on stainless steel.

## Concrete

### Water cleaning

Low pressure water washing to a rough, clean, dry and laitance free surface.

## Coated surfaces

### Verification of existing coatings including primers

When the surface is an existing coating, verify with technical data sheet and application guide of the involved products, both over coatability and the given maximum over coating interval.

### Over coating

High pressure water jetting surface preparation refers to ISO 8501-4, for substrates previously coated either with a full coating system (surface DC A, DC B, DC C) or shop primer (surface DP I and DP Z). The surface definition for existing coating (DC) refers to the degree of coating breakdown according to ISO 4628. It is important before considering hydro jetting, to ensure that the specified coating system is compatible with the existing coating system. High pressure water jetting does not remove mill scale or create surface roughness, and is only useful for surfaces with an initial roughness suitable for the subsequent coat.

### Shop primers

Shop primers are accepted as temporary protection of steel plates and profiles. Refer to the technical data sheet for the generic types accepted. Certain standards require pre-approval of the shop primer as part of a complete system. Contact your nearest Jotun office for specific system compatibility. Before being overcoated the shop primer must be fully cured, clean, dust free, dry and undamaged. Inorganic zinc shop primers must be free of zinc salts (white rust).

Corroded and damaged areas must be blast cleaned to minimum Sa 1 (ISO 8501-1).

## Application

### Acceptable environmental conditions - before and during application

Before application, test the atmospheric conditions in the vicinity of the substrate for the dew formation according to ISO 8502-4.

#### Standard grade

Air temperature	10 - 60	°C
Substrate temperature	10 - 60	°C
Relative Humidity (RH)	10 - 85	%

#### Winter grade

Air temperature	-5 - 25	°C
Substrate temperature	-5 - 25	°C
Relative Humidity (RH)	10 - 85	%

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3 °C (5 °F) above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

## Product mixing

Independent on substrate temperature the minimum temperature of the mixed base and curing agent is 15 °C. Lower temperature may require additional thinner to reach correct application viscosity. Additional thinner gives lower sag resistance and slower curing. If addition of thinner is required, this shall be done after mixing of the two components.

### Product mixing ratio (by volume)

#### STANDARD GRADE

Jotamastic 87 GF Comp A	6 part(s)
Jotamastic 87 Standard Comp B	1 part(s)

#### WINTER GRADE

Jotamastic 87 GF Comp A	4 part(s)
Jotamastic 87 Wintergrade Comp B	1 part(s)

### Induction time and Pot life

#### Paint temperature

	10 °C	23 °C	40 °C
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#### Standard grade

Induction time		10 min	
Pot life	4 h	2 h	1 h

#### Winter grade

Pot life		1 h	
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The temperature of base and curing agent is recommended to be 18 °C or higher when the product is mixed.

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

### Spray application

#### Airless Spray Equipment

Pump ratio (minimum) :	42:1
Pressure at nozzle (minimum) :	200 bar/2900 psi
Nozzle tip (inch/1000) :	21-27
Nozzle output (litres/minute) :	2.2-3.4
Filters (mesh) :	Remove filters

Several factors influence, and need to be observed to maintain the recommended pressure at the nozzle. Among factors causing pressure drop are:

- extended hoses or hose bundles
- extended hose whip-end line
- small internal diameter hoses
- high paint viscosity
- large spray nozzle size
- inadequate air capacity from compressor
- incorrect or clogged filters

## Film thickness per coat

### Typical recommended specification range

#### STANDARD GRADE

Dry film thickness	200 - 350 $\mu\text{m}$
Wet film thickness	250 - 440 $\mu\text{m}$
Theoretical spreading rate	4 - 2.3 $\text{m}^2/\text{l}$

#### WINTER GRADE

Dry film thickness	200 - 300 $\mu\text{m}$
Wet film thickness	285 - 430 $\mu\text{m}$
Theoretical spreading rate	3.5 - 2.3 $\text{m}^2/\text{l}$

This product can be applied up to 50 % higher than maximum specified film thickness without loss of technical properties.



Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The shortest time allowed before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Maximum over coating intervals

Maximum time before thorough surface preparation is required. The surface must be clean and dry and suitable for over coating. Inspect the surface for chalking and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by low-pressure water jetting to Wa 1 (ISO 8501-4) using fresh water.

If maximum over coating interval is exceeded the surface should in addition be carefully roughened to ensure good inter coat adhesion.

### Areas for atmospheric exposure

Average temperature during drying/curing	-5 °C	0 °C	5 °C	10 °C	23 °C	40 °C
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#### Standard grade

Itself			extended	extended	extended	extended
acrylic			10 d	10 d	7 d	5 d
epoxy			3 mth	3 mth	3 mth	2 mth
polyurethane			3 mth	3 mth	3 mth	2 mth
epoxy mastic			extended	extended	extended	extended

#### Winter grade

Itself	3 mth	3 mth	3 mth	3 mth	3 mth	2 mth
acrylic	14 d	10 d	7 d	7 d	5 d	1 d
epoxy	3 mth	3 mth	3 mth	3 mth	3 mth	2 mth
polyurethane	10 d	10 d	10 d	10 d	7 d	5 d
epoxy mastic	3 mth	3 mth	3 mth	3 mth	3 mth	2 mth

### Areas for immersed exposure

Average temperature during drying/curing	-5 °C	0 °C	5 °C	10 °C	23 °C	40 °C
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#### Standard grade

Itself			21 d	18 d	14 d	14 d
epoxy			21 d	18 d	14 d	14 d
vinyl epoxy			10 d	10 d	7 d	5 d
epoxy mastic			21 d	18 d	14 d	14 d

#### Winter grade

Itself	14 d	10 d	10 d	10 d	7 d	7 d
epoxy	14 d	10 d	10 d	10 d	7 d	7 d
vinyl epoxy	14 d	10 d	7 d	4 d	2 d	1 d





## Symbols and abbreviations

min = minutes

h = hours

d = days

°C = degree Celsius

° = unit of angle

µm = microns = micrometres

g/l = grams per litre

g/kg = grams per kilogram

m<sup>2</sup>/l = square metres per litre

mg/m<sup>2</sup> = milligrams per square metre

psi = unit of pressure, pounds/inch<sup>2</sup>

Bar = unit of pressure

RH = Relative humidity (% RH)

UV = Ultraviolet

DFT = dry film thickness

WFT = wet film thickness

TDS = Technical Data Sheet

AG = Application Guide

SDS = Safety Data Sheet

VOC = Volatile Organic Compound

MCI = Jotun Multi Colour Industry (tinted colour)

RAQ = Required air quantity

PPE = Personal Protective Equipment

EU = European Union

UK = United Kingdom

EPA = Environmental Protection Agency

ISO = International Standards Organisation

ASTM = American Society of Testing and Materials

AS/NZS = Australian/New Zealand Standards

NACE = National Association of Corrosion Engineers

SSPC = The Society for Protective Coatings

PSPC = Performance Standard for Protective Coatings

IMO = International Maritime Organization

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## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.

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