MasticGrip® 2530

High Solids Low Temperature Cure Aluminum Mastic Epoxy

Features

- Low temperature cure
- Surface tolerant coating
- Excellent corrosion protection
- Aluminum pigmentation / low moisture permeability
- VOC compliant
- Excellent edge protection
- Extended recoat window
- Single coat capability
- Outstanding wetting and adhesion properties
- Good chemical resistance
- Excellent Flexibility

Typical Uses

MasticGrip 2530 provides excellent corrosion protection over tightly adhered rust and hand tooled cleaned steel surfaces in low temperature conditions. Use of MasticGrip 2530 may extend the painting season for applications down to 35°F. MasticGrip 2530 is primarily used where abrasive blasting is not permitted or possible. MasticGrip 2530 is widely used as a touch-up primer for shop primed steel prior to field finishing. May be topcoated with epoxies and/or polyurethane for extended corrosion protection and color fastness.

Excellent for use as a spot primer on tank exteriors prior to top coating and on structural steel, steel tanks, barges, refineries, petrochemical plants, power plants, railcars, pulp & paper mills, and others as recommended.

Qualifications

Exceed performance requirements of SSPC Coating System No. 26.00

Physical Data

Abrasion resistance (ASTM D 4060)	
1 kg load/1000 cycles (ASTM D 4060)	weight loss
CS 17 wheel	51 mg
Temperature resistance (non-immersion)	
Continuous	250°F
Non-continuous	300°F
Theoretical volume solids of mixed material	80%±1%
Theoretical coverage of mixed gallon (1 mil)	1,283 sq. ft.
Volatile Organic Content	
Unthinned	1.40 lbs./gal. 169 g/l
Reducer 1 @ 1 pint/gal.	2.00 lbs./gal. 242 g/l
Reducer 3 @ 1 pint/gal.	2.05 lbs./gal. 248 g/l

Resistance

MasticGrip2530 is resistant to a wide range of chemicals in atmospheric exposures. The following is a guide to the proper selection.

Exposure	Immersion	Splash & Spillage	Fumes
Acidic	Not recommended	Good	Good
Alkaline	Not recommended	Excellent	Excellent
Solvents	Not recommended	Good	Excellent
Salt water	Excellent	Excellent	Excellent
Water	Excellent	Excellent	Excellent

Film Thickness (per coat)

Dry film thickness: 4 to 6 mils
Wet film thickness: 5 to 9 mils
Theoretical coverage: 257 sq. ft. @ 5 mils DFT

Primer/Substrates

MasticGrip 2530 can be applied directly over Hand Tool cleaned and prepared steel and concrete. MasticGrip 2530 can also be applied to cured ZincGard 1000 by thinning one pint per gallon with Reducer #1 and applying a mist coat approximately 4 mils wet which seals the porous inorganic zinc. The mist coat is followed by another light coat to achieve the total desired film thickness. MasticGrip2530 can be applied directly to ZincGard 1500. Consult SSPC-PS Guide 8.00 for topcoating zinc-rich primers.

Topcoats

MasticGrip 2530 is recommended as a single coat system in benign environments as the aluminum pigmentation reduces the chalking rate of the epoxy. MasticGrip 2530 is normally topcoated with EpoxyGrip 2000 or EpoxyGrip 2030 for chemical resistant finish. Approved finish oats such as UreGrip 3000 or MultiGrip 7000XP are recommended to control the erosion of the epoxy and maintain a colorfast system.

Color

MasticGrip 2530 is available in a matte aluminum finish. The aluminum pigmentation provides exceptional corrosion resistance.

Shipping Data

Packaging unit	2 gal.	10 gal.
Part A	1 gal.	5 gal.
Part B	1 gal.	5 gal.
Shipping weight (approx.)		
Package unit	28 lbs.	140 lbs.
	1 gal	5 gal.
Reducer 1	8 lbs.	40 lbs.
Reducer 3	9 lbs.	45 lbs.
Flash Point: (Setaflash)		
Part A	98°F	
Part B	45°F	
Reducer 1	53°F	
Reducer 3	78°F	

Shelf Life: 2 years for both the Part A and B when stored inside at 40°F to 110°F.

MasticGrip® 2530

Surface Preparation

Remove oil and grease from the surface with solvent or a commercial cleaner, which does not leave a residue according to SSPC-SP1.
Steel: Abrasive blasting is preferred when possible as the performance is enhanced. For normal environments, abrasive blast to a Commercial finish per SSPC-SP 6 to obtain a 1 ½ to 3 mil profile. For immersion conditions, abrasive blast to a Near-White finish per SSPC-SP 10 to obtain 1 ½ to 3 mil profile. For mild environments, which do not permit abrasive blasting, Hand Tool cleaning per SSPC-SP 2, Power Tool cleaning per SSPC-SP 3 or High Pressure Water cleaning per SSPC-SP12/NACE 5 WJ-4 is recommended.
Concrete: Minimum cure is 28 days at 75° F and 50 % RH or the equivalent. Abrasive blast to remove laitance and form oils and to produce a surface roughness similar to medium sandpaper. Surfacing may be required to fill holes in order to produce a sealed surface.

Mixing

Power mix each component, then blend Part B into the Part A and mix until uniform at the following ratio:

	2 Gal. Kit	10 Gal. Kit
MasticGrip 2500 Part A	1 gallon	5 gallon
MasticGrip 2530 Part B	1 gallon	5 gallon

Thinning

Thinning is not required for most applications; however MasticGrip 2530 may be thinned up to 1 pint/gal. Reducer 1 is recommended for most applications, however, reducer 3 may be used when topcoating MasticGrip 2530 with EpoxyGrip 2030, UreGrip 3000 or UreGrip 3300.

Pot Life

Thirty minutes at 75°F and less at higher temperatures.
One hour at 60°F
Two hours at 45°F
Four hours at 35°F

Applications Conditions

	Material	Surface	Ambient
Minimum	35°F	35°F	35°F
Maximum	75°F	85°F	85°F

Special thinning and application procedures are required outside these temperatures. Surface temperatures should be 5°F above dew point to prevent condensation.

Application Equipment

Conventional Spray: Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8' I.D. minimum material hose and a .070" I.D. fluid tip and air cap are recommended.
Airless Spray: Sprayer such as Graco's Bulldog with a 30:1 ratio and a .017" to .021" tip is recommended. A 30 mesh inline filter is recommended.
Power Mixer: Use only explosion proof power mixers.
Brush or Roller: Use medium brush and short nap roller with solvent resistant fibers and core.

Drying Time

The following minimum times are based on a 5 mil DFT and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

Surface Temperature	Cure To Topcoat
35°F	16 hrs.
45°F	8 hrs.
60°F	4 hrs.
75°F	2 hrs.

MasticGrip 2530 can be applied in a wet-on-wet manner with itself, EpoxyGrip 2030 or with EpoxyGrip 2000, which eliminates the dry time between coats. When recoating with UreGrip, MasticGrip2530 should dry according to the "Cure To Topcoat" schedule.

Maximum Recoat

MasticGrip 2530 has a 30-day recoat window. It is imperative that chalk and surface contamination be removed prior to recoating. High pressure washing is an acceptable method to remove chalk and surface contamination. For applications requiring longer than 30 days, please contact US Coatings for recommendations.

Cleanup

Cleanup with Reducer 1 or Reducer 3.

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CAUTION: Read and follow all caution statements on this product data sheet and on the Material Safety Data Sheet for this product.
CONTAINS FLAMMABLE SOLVENTS. Vapors are heavier than air and will accumulate. Extinguish all flames and prevent all sparks. All electrical equipment and installations should be made and grounded in accordance with the National Electrical Code. Where explosion hazards exist workers are required to use non-sparking tools and wear non-sparking shoes.
HEALTH: In confined spaces workers must wear fresh airline respirators.
WARRANTY: Any recommendation of U.S. Coatings contained herein, covering use, utilization, chemical or physical properties and other qualities of the products sold is believed reliable; however U.S. Coatings makes no warranty or representation with respect thereto. Use or application is at the discretion of the Buyer without liability or obligation whatsoever of U.S. Coatings.

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