

MasterSeal® P 681 (Formerly known as Mastertop® P 681)

Two Component, Low Viscosity, Epoxy Based Primer

DESCRIPTION OF PRODUCT

MasterSeal® P 681 is a solvent free, low viscosity, two component epoxy based primer used to protect steel and iron surfaces against corrosion.

FIELDS OF APPLICATION

- Under **MasterTop®** and **MasterSeal®** systems, iron and steel surfaces (not appropriate for stainless steel surfaces).

FEATURES AND BENEFITS

- Protects iron and steel against corrosion.
- Ensures and high adherence on steel and iron surfaces.

APPLICATION PROCEDURE

Preparation of Substrate

All substrates should be structurally sound, dry and clean. Oil, grease and other adhesion impairing contaminants should be removed. Steel surfaces must be sandblasted according to DIN55924 part 4, SA 2.5 standards. For steel primer the relative humidity should be below 4%.

Mixing

MasterSeal® P 681 is supplied as ready to use kits in the exact ratio. Before mixing, precondition both A and B parts to the temperature of +15°C - +25°C. **MasterSeal® P 681** part A is pigmented. Mix the part A with an epoxy/polyurethane paddled drill at 300-400 rpm for 3-4 minutes until a homogenous colour is achieved without causing air bubbles. Pour the entire contents of part B into the container of part A; make sure that there is no product left in the part B package. Scrape well the sides and the bottom of the container to ensure a thorough mixing. After mixing **MasterSeal® P 681** parts for 3-4 minutes, pour the mix into a fresh container, set it aside for a while and mix for another minute.

TECHNICAL DATA

MasterSeal® P 681 Part A	Epoxy Resin
MasterSeal® P 681 Part B	Epoxy Hardener
Color	Oxide Red-White
Mixed Density	1,23 kg/liters
Substrate Temperature	+8°C + 30°C
Working Time	30 minutes
Re Coating Interval	Min. 10 hours – max. 1,5 day
+10°C	Min. 5 hours – max. 1 day
+23°C	Min. 2,5 hours – max. 12 hours
+30°C	

The above figures are valid for 23°C and intended as a guide only and should not be used as a basis for specifications.

Mixing Ratio

MasterSeal® P 681	Part A	Part B
Mixing Ratio	7,50 kg	2,50 kg
Mixing Density	1,23 kg/lt	

APPLICATION METHOD

MasterSeal® P 681 primer should be applied with a roller and double coated. Oven dried silica (0.1-0.3 mm or 0.3-0.8 mm) should be broadcast into the second coat of the still wet primer (0.8-1.0 kg/m²) in order to improve adhesion of it.

COVERAGE

0.3-0.4 kg/m²/coat, depending on capillarity of the surface. **MasterSeal® P 681** should be applied in double coats.

WATCH POINTS

- Avoid application under excessive heat or wind and/or when the ambient and/or substrate temperature is below +10°C or above +30°C.
- The materials to be used at the appropriate temperatures should be brought and stored in the application area 1-2 days prior to the application and enabled to adjust the ambient conditions.
- In extremely cold conditions, heaters should be used to increase the ambient and the workability of the product, the packages should be preconditioned to +20°C - +25°C to become ready to use.
- Epoxy and polyurethane based floor coatings should be applied by specialists.
- The reaction and workability times of resin based systems depend on the ambient and substrate temperatures as well as the relative humidity. Under lower temperatures, the chemical reaction times are prolonged and this increases the pot life, coating interval and the working time. In addition to this, the consumption is increased as the viscosity increases. High temperatures ignite stronger chemical reactions and the above mentioned times decrease accordingly. For the material to be cured properly, the ambient and

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the substrate temperatures should not fall below the specified limits. After the application, the material should be protected from direct contact with water for 24 hours minimum. Within this period, a contact with water may cause a surface carbonation and/or tackiness; both of which will cause the coating to lose its characteristics. In such cases, the overall coating should be removed from the floor and renewed.

- Permissible relative humidity 75%-85%
- **MasterSeal® P 681** is supplied in working packs which are pre-packaged in the exact ratio. No solvent should be added.
- Mixing should be done with a mechanical drill at 300-400 rpm with epoxy/polyurethane mixing paddles.
- DO NOT MIX BY HAND.
- After the first mix, contents should be poured into a clean container and mixed once again.
- The empty packs should be consolidated and disposed properly in order to prevent reusing of the packages.

CLEANING OF TOOLS

Used tools and equipment must be cleaned carefully with an appropriate solvent: Once fully cured **MasterSeal® P 681** can only be removed by mechanically.

PACKAGING

10 kg set
Part A: 7.5 kg drum
Part B: 2.5 kg drum

STORAGE

The product should be stored in its original package, in a cool and dry place protected from frost. For short term storage, maximum 3 palettes should be placed on top of each other and the shipment should be made on a 'first come, first go' basis. Palettes should not be placed on top of each other during long term storage.

SHELF LIFE

The shelf life is 12 months from the date of production under suitable storage conditions. Opened packages should be stored under suitable storage conditions and used within 1 week.

HEALTH AND SAFETY PRECAUTIONS

It is dangerous to approach the application sites with fire. Fresh air should be circulated in the storage and the application sites. During the application, a protective apparel, protective gloves, goggles and masks which comply with the Occupational Health and Safety Precautions Rules should be used. Due to the irritation effect of the uncured materials, the mixture should not come into contact with skin and eyes; in case of a contact, the affected area should be washed with plenty of water

and soap; in case of swallowing, a physician should be consulted immediately. No food or beverages should be brought to the application area. The product should be stored and kept out of reach of children. For detailed information please consult the Material Safety Data Sheet.

DISCLAIMER

The technical information given in this publication is based on the present state of our best scientific and practical knowledge **Master Builders Solutions Yapı Kimyasalları Sanayi ve Ticaret Ltd. Şti.** is only responsible for the quality of the product. **Master Builders Solutions Yapı Kimyasalları Sanayi ve Ticaret Ltd. Şti.** is not responsible for results that may occur because the product is used other than advised and/or out of instructions regarding the place and the method of use. This technical form is valid only till a new version is implemented and nullifies the old ones.

CONTACT INFORMATION

Master Builders Solutions Yapı Kimyasalları Sanayi ve Ticaret Ltd. Şti.

Adres: Barbaros Mah. Begonya Sok.

Nidakule Kuzey Ataşehir, C Kapısı

No:3 E/5, 34746 Ataşehir İstanbul / Türkiye

Tel: 0216 217 88 00

Mail: mbs.tr@mbcc-group.com

Web: www.master-builders-solutions.com/tr-tr

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