



**MODERN MASTERS® COLORFAST™ EX  
EPOXY MASTIC PRIMER**

**DESCRIPTION AND USES**

Modern Masters® Colorfast™ EX high performance two component high solids epoxy mastic primer is specifically designed for application directly to sound rusted steel, clean steel, galvanized metal, concrete, previously coated surfaces and slightly damp surfaces. This primer contains <100 g/L VOC and can be used inside or outside (must be top coated). The Colorfast EX Epoxy Mastic Primer comes in either gray or white.

**PRODUCT FEATURES AND BENEFITS**

- Adheres to multiple substrates including sound rusted steel with minimal surface preparation
- Available in gray or white
- User friendly: 2-4 hour pot life, low VOC and minimal hazardous air pollutants (HAPs)
- 24 hour recoat time
- VOC compliant nationwide

**PRODUCTS**

DESCRIPTION	1-Gallon
Gray Primer Base	366718
White Primer Base	366719
Activator	366721

**PRODUCT APPLICATION**

**SURFACE PREPARATION**

**ALL SURFACES:** Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with Krud Kutter® Cleaner Degreaser or other suitable cleaner. Rinse with fresh water and allow to thoroughly dry.

**STEEL:** Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, scale, and deteriorated previous coatings to obtain a sound rusted surface. For optimum corrosion resistance, abrasive blast to Near White Metal SSPC-SP10 (NACE 2). Commercial Grade SSPC-SP-6 (NACE 3) is acceptable. Blast profile should be 1-2 mils (25-50µ). If abrasive blast cleaning method is used, then two coats of primer are required to properly prime steel.

**PREVIOUSLY COATED:** Previously coated surfaces must be sound and in good condition. Smooth, hard, or glossy finishes should be scarified by sanding or sweep blasting to create a surface profile. The Colorfast EX Epoxy Mastic Primer is compatible with most coatings, but a test patch is suggested.

**GALVANIZED METAL:** Remove oil, dirt, grease and other chemical deposits with Krud Kutter Cleaner Degreaser or other suitable cleaner. Remove loose rust, white rust or deteriorated old coatings by hand or power tool cleaning or brush off blasting. Rinse thoroughly with fresh water and allow to fully dry.

**PRODUCT APPLICATION (cont.)**

**SURFACE PREPARATION (cont.)**

**CONCRETE OR MASONRY:** New concrete or masonry must cure 30 days before coating. Any concrete surface must be protected from moisture transmission from uncoated areas. Remove all loose, unsound concrete. Remove laitance and clean with Zinsser WaterTite Etch and Cleaner (refer to this products' TDS for further information). Prime the surface with Colorfast EX Epoxy Mastic Primer.

**MIXING**

Both the base and activator components are highly pigmented. Mix each component thoroughly to ensure any settled pigment is re-dispersed before combining the components together. Combine at a 1:1 ratio by volume in a container large enough to hold the total volume. Mix thoroughly for 2-3 minutes. Power mixing is preferred. Do not mix more material than you plan to use within the listed pot life.

**REDUCTION/THINNING**

Thinning is normally not required, except for air-atomized spray. For air-atomized spray application, thin only up to 25% by volume with Colorfast EX Urethane/Epoxy Reducer CFEXR1000132 after the components have been mixed. Substitution of thinner can affect VOC compliance.

**APPLICATION CONDITIONS**

Apply only when air and surface temperatures are between 50-120°F (10-48°C) and when the surface temperature is at least 5°F (3°C) above the dew point. Use in areas with adequate ventilation. The relative humidity should not be greater than 85%. Extremely high or low relative humidity can affect dry times and the final gloss of the coating. Low curing temperatures and/or condensation on the film while curing can affect appearance in the form of an amine blush. This can generally be removed with soap and water; however, in a case of extreme blushing, the performance of the coating may be slightly affected.

**NOTE:** If curing time exceeds 30 days, the surface must be scarified by sanding, or other method, prior to application of an additional coat or other finish coating.



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**PRODUCT APPLICATION (cont.)**

**APPLICATION**

Airless spray is the preferred method of application. However, brush, roller, or air-atomized spray may also be used. Refer to Reduction/Thinning section for reduction recommendations. If used as a standalone product, a dry film thickness of 3-8 mils is required. When topcoating with the Colorfast EX topcoat, 1.5-3 mils are recommend. Excessive brushing or rolling may reduce film thickness. Apply a second coat if necessary to achieve the recommended film thickness.

**EQUIPMENT RECOMMENDATIONS**

(Comparable equipment also suitable)

BRUSH: Use a good quality synthetic bristle brush.

ROLLER: Use a good quality lamb's wool or synthetic fiber (3/8-1/2" nap)

**AIR-ATOMIZED SPRAY**

Method	Fluid Tip	Fluid Delivery	Atomized Pressure
Pressure	0.055-0.070	1-16 oz./min.	25-60 psi
Siphon	0.055-0.070	--	25-60 psi
HVLP (var.)	0.043-0.070	8-10 oz./min.	10 psi (at tip)

**AIRLESS SPRAY**

Fluid Pressure	Fluid Tip	Filter Mesh
1,800-3,000 psi	0.013-0.017	100

**CAUTION:** Protect surrounding surfaces from over spray. Over spray can be wet or dry depending on height of work, weather, environmental conditions and application equipment. Wet over spray can adhere to unwanted surfaces. Dry over spray may be removed by wiping or washing. Always clean dry over spray from hot surfaces before fusing occurs as surface temperatures can be higher than the air temperature.

**CLEAN-UP**

Use 315512 Compliant Thinner.

**SHELF LIFE**

Base components	3 years†
Activators	3 years†

†Unopened containers. Some settling may occur requiring mechanical mixing to re-disperse pigment.

	<b>TECHNICAL DATA</b>	<b>MDM-24</b>
	<b>MODERN MASTERS® COLORFAST™ EX EPOXY MASTIC PRIMER</b>	

**PHYSICAL PROPERTIES**

		COLORFAST EX EPOXY MASTIC PRIMER	
<b>Resin Type</b>		Cycloaliphatic modified amine converted epoxy	
<b>Inhibitive Pigment</b>		Calcium borosilicate	
<b>Solvents</b>		Exempt halogenated solvent Benzyl alcohol (activator only)	
<b>Weight*</b>	<b>Per Gallon</b>	12.5-13.2 lbs.	
	<b>Per Liter</b>	1.5-1.6 kg	
<b>Solids*</b>	<b>By Weight</b>	78-83%	
	<b>By Volume</b>	75-80%	
<b>Volatile Organic Compounds*</b>		<100 g/l (0.83 lbs./gal.)	
<b>Mixing Ratio</b>		1:1 Base:Activator (by volume)	
<b>Recommended Dry Film Thickness (DFT) Per Coat</b>		3-8 mils (75-200µ)	
<b>Wet Film to Achieve DFT (unthinned material)</b>		4-10.0 mils (100-250µ)	
<b>Practical Coverage at Recommended DFT (assumes 15% material loss)</b>		104-352 sq. ft./gal. (2.5-8.6 m <sup>2</sup> /l)	
<b>Induction Period</b>		None required	
<b>Pot Life**</b>	<b>2 gallons</b>	2-4 hours at 70°F (21°C)	1-2 hours at 90°F (32°C)
	<b>10 gallons</b>	2 hours at 70°F (21°C)	<1 hour at 90°F (32°C)
<b>Dry Times at 50% Relative Humidity</b>	<b>Tack-free</b>	8-10 hours at 70°F (21°C)	16-24 hours at 50°F (10°C)
	<b>Handle</b>	10-16 hours at 70°F (21°C)	48-72 hours at 50°F (10°C)
	<b>Recoat</b>	24 hours to 30 days at 70°F (21°C)	72 hours to 30 days at 50°F (10°C)
<b>Shelf Life</b>		3 years (Unopened containers. Some settling may occur requiring mechanical mixing to re-disperse pigment.)	
<b>Dry Heat Resistance</b>		Works in conjunction with topcoat of 200°F (93°C)	
<b>Safety Information</b>		For additional information, see SDS	

Calculated values are shown and may vary slightly from the actual manufactured material.

\* Activated material

\*\* Pot life is affected by air temperature, amount of material activated and the quantity of thinner used. Avoid activating large quantities at temperatures above 80°F (27°C). At temperatures above 90°F (32°C), the pot life of unthinned material in 5 gallon pails may be very short (less than one hour).

\*\*\* Highly textured surfaces (e.g. blasted metal) may require coating thicknesses at the upper end of the recommended range: 5-8 mils dry (125 to 200µ) or 6.5-10 mils wet (162.5 to 250µ)

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