



Coronado Industrial Coatings - 308 Old County Road - Edgewater, Florida 32132 - 800-883-4193 - FAX 800-394-9022

**COROPOXY® Surface Tolerant Mastic 113 Line**

Type	Sheen	Theoretical Spread Rate	Recommended Application	Thinner	Clean Up	
Polyamide Epoxy	Semi-Gloss	175 - 275 Sq. Ft. Per Gallon*	Airless, Air-Spray, Brush or Roller	45-187	45-187	
<b>Touch Dry Time:</b>		8 Hrs. @55°F 4 Hrs. @77°F 2 Hrs. @95°F	<b>Min Recoat:</b>	24 Hrs. @55°F 12 Hrs. @77°F 6 Hrs. @95°F	<b>Max Recoat:</b>	8 weeks @55°F 6 weeks @77°F 2 weeks @95°F

<b>PRODUCT NAME:</b> 113 Line COROPOXY® Surface Tolerant Mastic	COROPOXY® 113 Line is a true surface tolerant high solids epoxy. It provides excellent corrosion protection, excellent flexibility, and very high build in one application. It may be used over marginally prepared corroded steel, provided rust is tightly adhering to the base metal, over most existing coatings systems, and over blasted metal. In addition, it may be used as a corrosion resistant, high build intermediate coating. Additionally, this coating may be used direct to concrete as well as non-ferrous metals. A full line of tinting bases is available to achieve virtually any color; however, for extended exterior durability a urethane finish coat may be desired. The high volume solids, VOC compliant formulation minimizes the risk of pin-holing in the cured film, ensuring excellent corrosion protection for many years. 113 Line is qualified for use in direct and indirect food contact areas (FDA and USDA) and in immersion in many liquids.	
<b>WHERE TO USE:</b>	<b>Ferrous Metal Galvanized Aluminum Concrete Aged Coatings</b>	Intended for use on hand prepared rusty ferrous metal, abrasive blast cleaned and hydro-blasted ferrous metal, blasted concrete, and over a wide range of intact aged coatings. COROPOXY® Surface Tolerant Mastic will amber and chalk if exposed to ultraviolet light. Use in industrial maintenance, coastal structures, pulp and paper plants, food and beverage plants, structural steel, tank exteriors, bridges, offshore, marine and immersion in fresh or salt water. COROPOXY® Polyamide will amber and chalk if exposed to ultraviolet light.
<b>SURFACE PREPARATION:</b>	The performance of this product is directly dependent upon the degree of surface preparation employed. All dirt, oils and accumulated salts must be removed prior to employing specific surface preparation methods. Pressure washing will best accomplish this task. Tightly adhering rust need not be removed prior to coating application for areas of atmospheric exposure. Non-Ferrous metals (galvanized, aluminum) should be prepared by treating with 93-300 Metal Pretreatment or light abrasive blasting prior to application of this product. Concrete should have contaminants and laitance removed and be porous enough to allow for coating penetration. <b>Abrasive Blasting:</b> For immersion service, blast clean steel substrates to a minimum of SSPC-SP10, and concrete substrates to a suitable cleanliness through sweep blasting. For atmospheric exposure on steel, blast to a minimum of SSPC-SP6, for concrete sweep blast or acid etch. Surface profile should be 2 to 3 mils. <b>Hand or Power Tool Preparation:</b> Hand or power tool clean steel surfaces to a minimum SSPC-SP2. <b>Hydro-blasting / Abrasive Wet Blasting:</b> May be applied to surfaces prepared to SSPC-SP6 which may have flash rusted. <b>Aged Existing Coatings:</b> COROPOXY® 113 Line is suitable for over-coating a limited range of tightly adhering, intact aged coatings. Sand glossy surfaces to provide profile. Remove loose, flaking coatings back to a firm edge. Coatings that may be over-coated include urethanes, epoxies, alkyds, and acrylics. Do not overcoat existing thermoplastic coatings (chlorinated rubber, vinyl) with 113 Line.	
<b>APPLICATION:</b>	Mix each component thoroughly prior to blending the two, with a power agitator. Slowly add the "B" component to the "A" while agitating the "A". Allow a 15 minute induction or sweat-in time. Do not vary the packaged ratio. Only mix enough material that can be used within the working pot life. POT LIFE: 5 Hrs. @ 50°F / 3 Hrs. @ 60°F / 2 Hrs. @ 77°F / 1 Hr. @ 100°F <b>Airless Spray (Preferred to apply maximum millage in one coat):</b> Tip range between 19 and 25 thousandths. Total fluid output pressure at tip should not be less than 2500 psi. Equipment should be not less than 30:1 compression ratio. <b>Air Spray (Pressure Pot):</b> DeVilbiss MBC or JGA gun, with 704 or 765 air cap and Fluid Tip E. Application by air spray may require a multiple cross spray pattern to achieve maximum film build. Thinning may be required to adequately atomize material. Do not thin more than local regulations allow. NOTE: Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with recommended thinner. <b>Brush:</b> Natural Bristle only. Typical Brush application will apply 4 to 5 mils of product. <b>Roller:</b> ¼" Mohair with Phenolic core. Typical roller application will apply 3 to 4 mils of product. Level of sheen and surface finish is directly dependent upon application method. Avoid using a mixture of application methods whenever possible. After prolonged stoppages, do not mix previously catalyzed material with freshly catalyzed material. <b>RECOAT WINDOW :</b> With all epoxy coatings, this product may be recoated at any time up to 14 days. Recoating after that time will require abrading the surface to allow adhesion of the subsequent coats of coatings.	

Coronado Industrial Coatings - 308 Old County Road - Edgewater, Florida 32132 - 800-883-4193 - FAX 800-394-9022

IMA – 704  
**COROPOXY®**  
**Surface Tolerant Mastic**  
**113 Line**

<b>*NOTE ON SPREAD RATE:</b>	Actual spread rate will vary based upon numerous factors, including texture of the substrate, application method, waste, surface porosity and thinning. The Theoretical Spread rate listed on this document has not taken into account these factors and is only based upon the volume solids of this product and the recommended wet film thickness when applied to a smooth substrate.
<b>STORAGE:</b>	12 months minimum at 77°F. Examine product after this time. If material is fluid and no settling is apparent, product is still usable. Store in dry, shaded area, away from heat and ignition sources. Protect from frost.
<b>TINTING:</b>	COROPOXY® Surface Tolerant Mastic is available in 3 bases: -1 White, -38 Deep, and -36 Clear. These bases are intended to be tinted with Prism Industrial Colorants (844 type). <b>DO NOT DOUBLE</b> printed formulas when tinting this product, as with certain other Coronado® Industrial Epoxies that yield two gallons when mixed. <i>Due to the high build nature of this product, only a one-gallon formula is required to tint the two-gallon kit.</i> <b>TINT ONLY THE "A" COMPONENT.</b> Check color accuracy by mixing equal portions of the "A" and "B" components, apply and allow to completely dry.
<b>RESIN TYPE:</b>	Epoxy
<b>SOLIDS (MIXED):</b>	Weight: 86.2 ± 1.0%      Volume: 78.4 ± 1.0%
<b>WEIGHT PER GALLON (MIXED):</b>	11.6 lbs.
<b>MIX RATIO:</b>	1.0 : 1.0 by volume
<b>INDUCTION TIME:</b>	30 minutes at 55°F / 15 Minutes at 77°F / 10 minutes at 95°F
<b>FLASH POINT:</b>	Mixed: 80°F. (TT-P-141, Method 4293)
<b>SPECULAR GLOSS:</b>	45 - 55 units @ 60°
<b>WET FILM THICKNESS:</b>	5.8 to 9.2 mils
<b>DRY FILM THICKNESS:</b>	4.6 to 7.2 mils
<b>CAUTIONS:</b> (These cautions are for 113-1A and 113-251B mixed 1:1- Cautions for other bases or colors may vary)	<p style="text-align: center;"><b>DANGER!</b></p> <p style="text-align: center;">FLAMMABLE LIQUID AND VAPOR. VAPOR HARMFUL. HARMFUL IF INHALED. CAUSES EYE AND SKIN BURNS. MAY CAUSE ALLERGIC SKIN REACTION. MAY BE HARMFUL IF ABSORBED THROUGH SKIN. HARMFUL OR FATAL IF SWALLOWED.</p> <p><b>Contains: Aromatic Petroleum Distillates, Xylene, Ethylbenzene, Triethylenetetramine, Propylene Glycol m-Methyl Ether, and Crystalline Silica.</b></p> <p><b>Cancer Hazard: Contains Crystalline Silica</b>, which can cause cancer. Risk of cancer depends on duration and level of exposure to dust generated from sanding surfaces or spray mists.</p> <p>Vapor Harmful. May affect the brain or nervous system causing dizziness, headache or nausea. Causes eye, lung, skin, nose, and throat irritation. May cause allergic respiratory reaction. Overexposure may cause lung and kidney damage. <b>NOTICE:</b> Reports have associated repeated and prolonged occupational over-exposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling contents may be harmful or fatal. Keep away from heat, sparks and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors, and other sources of ignition during use and until all vapors are gone. Prevent build-up of vapors by opening all windows and doors to achieve cross-ventilation. <b>Use Only With Adequate Ventilation.</b> Do not breathe dust, vapors or spray mist. Ensure fresh air entry during application and drying. If you experience eye watering, headache or dizziness or if air monitoring demonstrates vapor/mist levels are above applicable limits, wear an appropriate, properly fitted respirator (NIOSH approved) during and after application. Follow manufacturer's directions for respirator use. Do not get in eyes, on skin or clothing. Wash thoroughly after handling.</p> <p><b>FIRST AID:</b> In case of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes. Remove contaminated clothing and shoes. Get medical attention immediately. Wash clothing before reuse. Destroy contaminated shoes. If inhaled, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen, get medical assistance immediately. If swallowed, do not induce vomiting. Get Medical Attention Immediately.</p> <p>Close container after each use. If spilled, contain spilled material and remove with inert absorbent. Dispose of contaminated absorbent, container and unused contents in accordance with local, state and federal regulations.</p> <p><b>ATTENTION:</b> This container hazardous when empty. Empty container retains explosive vapors and flammable residues. All labeled hazard precautions must be observed. Keep away from heat, sparks, and flames. Do not cut, puncture or weld on or near this container. Not rated for pressure, do not apply air or gas pressure. Do not reuse this container for any purpose.</p> <p><b>DANGER</b> – Rags, steel wool or waste soaked with this product may spontaneously catch fire if improperly discarded. Immediately after use, place rags, steel wool or waste in a sealed, water-filled metal container.</p> <p style="text-align: center;"><b>WARNING:</b> This product contains a chemical known to the state of California to cause cancer and birth defects, or other reproductive harm.</p> <p style="text-align: center;"><b>Obtain and Read the Material Safety Data Sheet Before Using</b>  <b>KEEP OUT OF REACH OF CHILDREN</b></p> <p style="text-align: center;"><b>INTENDED FOR INDUSTRIAL USE ONLY</b></p>
<b>VOC/VOS STATEMENT:</b>	This product contains a maximum of 200 grams of VOC/VOS per liter of coating. (1.7 Pounds Per Gallon)
<b>OTC CATEGORY:</b>	This product is compliant under the Ozone Transport Commission regulations as an Industrial Maintenance Coating.

IMA - 704  
**COROPOXY®**  
**Surface Tolerant Mastic**  
**113 Line**

TEST DATA	
<b>Abrasion (ASTM D4060)</b>	1 kg load/1000 cycles/ CS-17 Wheel: 80 mg loss
<b>Adhesion (ASTM D3359)</b>	Pass 5B
<b>Salt Spray (ASTM B117)</b>	Face Corrosion-None
<b>(1 Coat , 6 mils, 3000 Hours)</b>	Face Blistering-None
<b>Humidity (ASTM D4585)</b>	Face Corrosion-None
<b>(1000 Hours)</b>	Face Blistering-None
<b>Steam Resistant</b>	Yes
<b>Direct Impact Resistance</b>	90 in. lb.
<b>Reverse Impact Resistance</b>	40 in. lb.
<b>Dry Heat Resistance</b>	250°F
<b>Wet Heat Resistance</b>	150°F
<b>Flexibility (ASTM D1737)</b>	Pass ¼" Mandrel
<b>Persoz Pendulum Hardness</b>	170

CHEMICAL RESISTANCE GUIDE (NON-IMMERSION)	
<b>Fresh Water</b>	Excellent
<b>Salt Water</b>	Excellent
<b>Acids</b>	Good
<b>Alkalis</b>	Excellent
<b>Solvents</b>	Excellent
<b>Fuel</b>	Excellent
<b>Acidic Salt Solutions</b>	Excellent
<b>Alkaline Salt Solutions</b>	Excellent
<b>Neutral Salt Solutions</b>	Excellent

QUALIFICATIONS	
<b>USDA</b>	Incidental Food Contact
<b>FDA</b>	Direct Food Contact

SYSTEMS RECOMMENDATIONS	
PRIMERS	
<b>Ferrous Metal (Blasted)</b>	Use Direct, or use 1201 as primer
<b>Ferrous Metal (Marginally Prepared)</b>	Use Direct
<b>Non-Ferrous Metal</b>	Use Direct, or use 317
<b>Concrete</b>	Use Direct or use 1433-10, 1447-10, 111-111, or 101-10
<b>Aged Coatings</b>	Use Direct
COMPATIBLE FINISHES OVER 113	
101, 827, 837, 847, 848, 3823	
For substrates other than listed above, or for usage in severe environmental conditions, please consult with Coronado Industrial Coatings technical service.	

WARRANTY
Coronado Paint Company warrants its products to be free from defects in materials and workmanship. Coronado Paint Company's sole obligation and the purchaser's exclusive remedy shall be limited, at Coronado Paint Company's option, to either replacement of nonconforming products or credit to the purchaser's account in an amount not greater than the original purchase price of the nonconforming products. Any claim under this warranty must be made by the purchaser, in writing to Coronado Paint Company, within ten (10) days of the purchaser's discovery of the claimed defect, but not later than the expiration of the applicable shelf life, or one year from the original delivery date, whichever is earlier. Purchaser's failure to notify Coronado Paint Company of any nonconformance as required shall bar the purchaser from recovery under this warranty.
Coronado Paint Company makes no other warranties, expressed or implied, such as merchantability or fitness for a particular purpose concerning its products. In no event shall Coronado Paint Company be liable for consequential or incidental damages.
Any recommendation or suggestion relating to the usage of products made by Coronado Paint Company, whether in the form of literature, data, or in response to specific inquiry, or otherwise is based upon information believed to be reliable; however the products and information are intended for use by skilled and knowledgeable purchasers, and is therefore for the purchaser to satisfy itself of the suitability of the products for its own specific use, and it shall be deemed that the purchaser has done so, at the sole discretion and risk. Variation in application conditions, ambient conditions or extrapolation of information may cause unsatisfactory results.

LIMITATION OF LIABILITY
Coronado Paint Company's liability on any claim, including claims based upon negligence, or strict liability for loss, or damage arising out of, connected with, or resulting from the use of products, shall in no case exceed the purchase price of the products directly giving rise to the claim. In no event shall Coronado Paint Company be liable for consequential or incidental damages.

THINNING RECOMMENDATION:
Do not thin more than local regulations allow.
Use Corosolve® 45-187 only to thin this product.

Coronado Industrial Coatings - 308 Old County Road - Edgewater, Florida 32132 - 800-883-4193 - FAX 800-394-9022

**COROPOXY® Surface Tolerant Mastic**

**113 Line**

NOTES:

