

Mastic 680

Code: 7680

Product description.

Navimare Mastic 680 is a general purpose epoxy filler offering superior adhesion and working characteristics. It is recommended for use in all filling applications including below water areas where adhesion and strength are paramount.

Technical properties.

Colour/Texture	White/ Mat
Volume Solids	90%
Specific gravity	1.47 gr/ml
Flashpoint	>45°C

Surface Preparation

GRP – Ensure surface is dry and free from traces of wax, lubricants and other contaminants. Treat if required with Navimare Gelclean and wash with fresh water.

Wood – Ensure surface is dry. Sand and remove the remaining dust by vacuum cleaning, with dry rags or rags slightly dampened with water (not solvent).

Metals – Prime with appropriate priming system first.

Primed surfaces. Sand primers lightly with coarse grade of sandpaper. Ensure surface is dry and free from contaminants prior to application of Navimare Mastic 680.

Usage instructions

Substrate should be dry and free from contaminations.

Relative Humidity should be less than 90 %RH.

Mix pack A and pack B well. Do not mix more paint than can be used in 1 hour.

The product can be applied by brush but preferably by combining trowel and putty knives.

Typically a layer of 3 mm thickness is applied. After 16 hours the filler can be sanded with a coarse grade of sandpaper.

Avoid longer recoat intervals of 48 hours. Do not use at temperatures less than 5°C.

Whether applying by brush, roller or spray, wear protective clothing, goggles and gloves. Refrain from smoking at all times. For further information refer to label instruction or safety data sheet please.

Application data.

Mixing ratio by weight	Base to hardener: 68,5 to 31,5
Mixing ratio by volume	Base to hardener: 2 to 1
Potlife	1 hours at 20° C
Practical coverage	0,8-1 sq.m/liter when applied at 1 mm thickness
Cleaner	Navimare Epoxy Thinner 7603
Surface Temperature	Minimum 5°C Maximum 40°C

Drying and recoating times.

Substrate temperature	Dry to recoat	Fully cured	Maximum recoating (1)
10 °C	24 hours	7 days	4 days
23 °C	16 hours	5 days	2 days
30 °C	12 hours	2 days	1 day

(1) The surface should be dry and free from salts and other contaminants prior to overcoating. When the maximum recoat time has been exceeded or after prolonged exposure times it is necessary to roughen the surface in order to ensure intercoat adhesion. When in doubt, consult your nearest Navimare office.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product.

Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product.

We reserve the right to change the product without notice.

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