

MA3 TIE-COAT

ThistleBond

A Division of E. Wood Ltd., U.K.



ThistleBond 'MA3 Tie-Coat' is a high performance anti-corrosive solvent based polymer coating designed for use as a versatile universal primer for metallic and GRP substrates.

ThistleBond 'MA3 Tie-Coat' uses a well established blend of high molecular weight polymer resin and a range of fine inorganic pigments and fillers combined with a specially formulated polyamine adduct which react together to produce an effective anti-corrosive system with excellent adhesion to a wide range of surfaces whilst providing an extended over coating window for most top coat finish systems.

ThistleBond 'MA3 Tie-Coat' can be used as a primer coat before applying ThistleBond Ceramic Carbide systems, Hycote chemical protection systems, floor protection systems, saline / marine corrosion protection systems etc.

SURFACE PREPARATION & APPLICATION PROCEDURE

Steel Surfaces

All steel surfaces to be coated should be abrasive blast cleaned to a minimum SA 2 in accordance with BS7079 Part A1:1989, near white metal finish. All loose abrasive dust and debris must be blown clear or vacuum cleaned away. Hydro cleaning may be required to remove absorbed salts / chemicals and neutralization is to be done prior to coating. Coating should be done within 2-4 hours of blasting. Open air surfaces can be cleaned by mechanical wire brush, grinding or high pressure water jetting to achieve Swedish Standard St2-St3.

Galvanized Steel

All oil and grease must be removed by thoroughly degreasing with ThistleBond 'Cleaner'. Any zinc corrosion salts must be removed by abrasion or thorough wire brushing.

Aluminium Surfaces

All oil and grease must be removed by thoroughly degreasing and metal surface should then be abraded or lightly abrasive blasted.

Polyester / GRP Surfaces

Abrade with 80 grade abrasive paper to remove all surface contamination. On gelcoat use a random orbit sander to achieve a uniform mat finish.

Concrete Surfaces

Should be thoroughly abraded or slightly blasted to get a good and rough surface. Care should be taken not to expose the aggregate in concrete. Hydro jetting can also be used.

Application Procedure

Ensure ambient temperature is not below 7°C and relative humidity should not exceed 90%. 'Ma3 Tie-Coat' can be applied by conventional air assisted spray or airless spray. It can also be applied by brush or roller to the small working areas.

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PHYSICAL PROPERTIES

Abrasion Resistance	70 mg loss / 1000 cycles
ASTM D4060	CS17 wheel 1 kg load
Impact Resistance	Direct - 5mm
BS 3900 E3	Reverse - 2.5mm
Tensile Shear Adhesion	140 kg/cm ²
ASTM D1002	(2000 psi)
Humidity Resistance	5000 hours
BS 3900 Part F2	unaffected
Salt Fog Resistance	5000 hours
ASTM B117	unaffected
Scratch Resistance	No Failure 2.5 kg load
BS 3900 Part E2	(5.5 lbs)
Dry Heat Resistance	100 °C
ASTM D2485	
Direct Pull Adhesion	38 kg/cm ²
ASTM D4541	(550 psi)
Recommended Thickness	Wet 100 microns
	Dry 50 microns
Coverage per litre	10 m ² @ 50 microns

PHYSICAL CONSTANTS

Mixing Ratio	Resin	Hardner
By volume	3	1
Appearance	Resin	Hardner
Liquid	Thixotropic	Clear
Drying Time @ 20°C		
Usable Life	8 Hours	
Touch Dry	4 Hours	
Hard Dry	16 Hours	
Volume Solids	50%	
VOC	475 gm/litre	
Shelf Life	5 years	

CHEMICAL RESISTANCE *

Acetic Acid 0-10%	Good
Hydrochloric Acid 0-20%	Good
Phosphoric Acid < 75%	Good
Nitric Acid 0-10%	Good
Sodium Hydroxide	Good
Nitrous Acid Dilute	Good
Sulfuric Acid 0-20%	Good
Sulphur Dioxide	Good
Kerosene / Petrol / Diesel	Good
Chlorine	Good
Sea Water	Good

SUPPLY INFORMATION

Stock No : TL520
Description : MA3 Tie-Coat
Pack Size : 2.5 litre

* for further information see Chemical Resistance Chart

RECOMMENDED APPLICATIONS

- Over coating window for most top coat finish systems
- Primer coat prior to application of ceramic carbide systems in pumps, impellers, casings, fan blades etc.
- Primer coat for structural steel work of towers, bridges
- Primer coat for chemical storage tanks
- Protective coating for the external surface area
- Priming of surface prior to the application of floor repair

Distributor catering to your needs



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