

Epoxy Surtol Aluminium HS × 2 coats

IPC-ST-CC-2L-02-SS · Processing — Surface-Tolerant Maintenance System (Hand-Prepared Steel)

 2 COATS SYSTEM BUILD · NUMBER OF COATS	 C4-C5 ISO 12944-2:2017 ENVIRONMENT	 250 µm TOTAL SYSTEM DFT	 HIGH EXPECTED DURABILITY · C4 15-25 YRS	 St 3 SURFACE PREPARATION GRADE
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DESCRIPTION

An ultra-high solids (90%), surface-tolerant epoxy mastic maintenance system applied in two coats as a self-priming primer/finish. Aluminium flake and corrosion-inhibiting pigments provide dense barrier protection on hand-prepared rusted steel and aged coatings where blasting is impractical.

Epoxy Surtol Aluminium HS — Two component, high solids, modified epoxy mastic with aluminium flake; adheres to hand-prepared rusty steel, hydro-blasted steel and a wide range of intact aged coatings. Resistant to humidity, saltwater immersion and exterior exposure.

SYSTEM BREAKDOWN

SYSTEM BUILD — LAYER · VOLUME SOLIDS · DFT · THEORETICAL YIELD					
Layer	Product	Vol. Solids	DFT	Theoretical Yield ¹	Comments
1st coat	Epoxy Surtol Aluminium HS	90%	125 µm	7.2 m²/L @ 125 µm	Self-priming, high build
2nd coat	Epoxy Surtol Aluminium HS	90%	125 µm	7.2 m²/L @ 125 µm	Overcoat 16-72 h @ 25 °C
TOTAL	Total system dry film thickness		250 µm		

¹ Theoretical yield = Volume Solids × 10 ÷ DFT (µm), per product TDS — allow for application loss factors.

SURFACE PREPARATION

Degrease with Hydrosolve and high-pressure water rinse; grind weld spatter and sharp edges. Steel: very thorough hand / power tool cleaning to St3 (ISO 8501-2) minimum — blast cleaning further improves performance. Galvanizing: degrease and abrade / sweep blast to provide a key.

OVERCOATING INTERVALS

DRYING & OVERCOATING — SUBSTRATE TEMPERATURE AS STATED			
Product	Minimum	Maximum	If window exceeded / notes
Epoxy Surtol Aluminium HS (each coat)	16 h @ 25 °C	72 h @ 25 °C	If exceeded, abrade or sweep blast before recoating

Overcoating information is a guide only and is subject to climate and site conditions — the product TDS governs.

INTENDED USES & BENEFITS

- Maintenance of industrial and coastal structures, bridges, offshore steel
- Pulp & paper plants — atmospheric exposure and immersion service
- Single-product primer/finish — one or two coats, minimal downtime
- Overcoatable with epoxies, polyurethanes, alkyds and acrylics if colour is required

ISO 12944 CLASSIFICATION & EXPECTED DURABILITY

Environment classification	C4 (high) – C5 (very high) atmospheric; immersion-capable (ISO 12944-2:2017)
Expected durability	C4: High · C5: Medium (on St3 hand-prepared steel) (ISO 12944-1:2017)

ISO 12944-4 assigns reduced durability expectations on hand-prepared (St) substrates versus blast-cleaned steel; assessment by Specialized Coating Systems.

NOTE: All products shall be applied according to the instructions and within the application parameters given on the Speccoats™ Technical Data Sheet (TDS) for each product — the TDS governs in any conflict. Expected durability = time to first major maintenance (ISO 12944-1:2017), not a guarantee.