HY-TECH COATINGS®

Bituminous Mastic 50-HT

VOC Compliant High Build Bituminous Mastic Coating

Features

- A tough, durable bituminous based coating for lasting protection of steel pipe, tanks, flanges, bolts and other bare metal structures. The coating particularly suited for quick repairs. Less than 100 gms/liter VOC which meets the most stringent VOC requirements. Can be applied to new and reconditioned pipe. When applied over light rust it will stop further deterioration. Meets requirements of an architectural coating and/or an Industrial Maintenance Coating.

Typical Uses

Excellent exterior durability and adhesion over metal, wood, and concrete surfaces. Can be used above and below grade.

Physical Data

Pencil Hardness (ambient cure)	Soft to 4B	**Theoretical volume solids of mixed material**	**90%±1%**
Adhesion (ASTM D 4541)	300 psi	**Theoretical coverage of mixed gallon (10 mil DFT)**	**144 sq. ft.**
Temperature resistance		**Volatile Organic Content**	
Continuous	250°F	**Ready to apply**	**< 50 gm/liter**
Non-continuous	300°F		

Resistance

Bit 50-HT is designed for exposures to mild chemical fumes under typical atmospheric conditions.

Exposure	Typical Buried Pipe Performance	No liquid Only Fumes	Full Strength Splash & Spillage
Acidic	Excellent	Fair	Poor
Alkaline	Excellent	Fair	Poor
Solvents	Excellent	Good	Fair
Salt water	Excellent	Excellent	Good
Water	Excellent	Excellent	Good

Film Thickness (per coat)

Dry film thickness: 10 to 20 mils per coat.
Wet film thickness: 12 to 24 mils
Theoretical coverage: 144 sq. ft.@ 10 mils DFT

Primer/Substrates

Bit 50-HT Mastic Pipe Coating may be applied directly to properly prepared steel substrates, weathered galvanized steel and concrete surfaces. All surfaces should be free of oil or dirt.

Colors

Only in Standard Black semi-gloss.

Shipping Data

Packaging unit	50 gal.	5 gal.	1 gal.	50 HT	70 °F
Shipping weight (approx.)				Shelf Life: 3 years when stored inside at 40°F to 110°F.	
Package unit	550 lbs.	55 lbs.	11.lbs	DOT Classification	Paint,3,UN1263. PGII

1 Gallon or less can be shipped under Limited Quantity Rule

Flash Point: (Setaflash)

Surface Preparation

Bit 50-HT Mastic Pipe Coating is designed to be used over surfaces that have been prepared in accordance with SSPC-SP2 Hand Tool Clean specification. In many cases High Pressure Water Blast will suffice.

Mixing

Mix Bit 50-HT Mastic Pipe Coating well prior to application.

IMPORTANT: Must be thoroughly mixed before application to ensure proper use.

Thinning

Thinning is not required for most applications; however HT-50 Mastic maybe thinned with up to 1 pint of Acetone per gallon for spray application. No other thinner is authorized.

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Applications Conditions

	Material	Surface	Ambient
Minimum	50°F	50°F	50°
Maximum	100°F	120°F	120°F

Special thinning and application procedures are required outside these temperatures.

Application Equipment

Conventional Spray: Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8' I.D. minimum material hose and a .070" I.D. fluid tip and air cap are recommended.
Airless Spray: Sprayer such as Graco's Bulldog with a 30:1 ratio and a .035" to .080" tip is recommended. A 30 mesh inline filter is recommended.
Brush : Use medium brush; Roller: Application by roller is not recommended.

Drying Time

The following minimum times are based on 10 mils DFT and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

Surface Temperature	To Touch	To Handle	To Recoat
77°F	45 min.	90 min.	45 min

Less at higher temperatures

Maximum Recoat

Bit 50-HT Mastic Coating can be recoated with itself as soon as the first coat is tack free and well set.

Cleanup

Cleanup spill spatters and equipment using Orange Hand Cleaner or Acetone before the coating sets or dries hard