



## ARMOR GARAGE INC.

Manufacturers of High Performance Industrial Coatings

Phone: 866-532-3979

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# CHEMICAL MASTIC AGCM-15

HIGH BUILD STEEL EPOXY MASTIC

### PRODUCT DESCRIPTION

A two component, high solids, chemical resistant amine cured epoxy mastic. Chemical Mastic AGCM-15 is specially modified epoxy with a proprietary blend of selective resins and wetting agents that penetrates to provide excellent adhesion and protection of steel pipe, steel surfaces, and to upgrade old, deteriorated coatings. Ideal as a coating system over marginally prepared surfaces where blasting is impractical or prohibited. Recommended as a high build mastic with a wide variety of topcoats.

**Recommended for:** Structural steel, tanks, vessels, water towers, equipment, pipe lines, racks, metal buildings, fences, catwalks, bridges, railings, fire escapes in chemical processing plants, pulp and paper mills, sewage/waste water treatment facilities, refineries, power stations, and marine installations.

USDA Approved	Chemical Resistant	Self-Priming on Steel	Multiple Colors	High Build
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### PRODUCT FEATURES

- Excellent adhesion to steel
- USDA Approved
- High build primer or finish coat
- Outperforms standard epoxies
- Excellent against “undercutting”
- Easy to apply, self-priming on steel
- Excellent build to protect sharp edges
- Tight film, low permeability
- Good chemical, abrasion & impact resistance
- Available in many colors
- Low temp cure & fast cure versions available

### TECHNICAL DATA

Property	Value	Property	Value
<b>COLORS:</b>	Std Industrial Colors & Aluminum, Tint, Deep, Neutral Base	<b>CLEAN UP:</b>	S-74 or SA-17
<b>FINISH:</b>	Gloss	<b>POT LIFE:</b>	3 hrs @ 75°F (reduced w/ S-74)
<b>VOLUME SOLIDS:</b>	82% ± 3%	<b>RECOAT TIME:</b>	8 hrs at 75°F (5 mils)
<b>COVERAGE:</b>	1,315 sq ft @ 1.0 mil DFT	<b>APPLICATION:</b>	Spray, brush or roller
<b>REC. THICKNESS:</b>	5.0–7.0 dry mils (188–263 sq ft/gal)	<b>APPLICATION TEMP:</b>	45°–120°F
<b>MIX RATIO:</b>	4:1 by volume (4 parts A : 1 part B)	<b>DRY SERVICE TEMP:</b>	170°F Max
<b>INDUCTION TIME:</b>	None	<b>SHELF LIFE:</b>	1 year minimum
<b>THINNING:</b>	S-74 Reducer	<b>PACKAGING:</b>	5 gal or 1 gal units
		<b>V.O.C. (WHITE):</b>	1.34 LBS/GL (161 GMS/L)



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### CHEMICAL RESISTANCE

*Splash/Spillage and short term immersion service. For Internal Lining Service, contact ArmorGarage.*

Aluminum Nitrate - 50%	Ethylene Glycol	Linseed Oil	Rock Salt
Aluminum Sulfate - 50%	Fish Oil	Lactic Acid - 25%	Sodium Bisulfate - 50%
Apple Juice	Fuel Oil	Milk	Sodium Bromide - 40%
Beer	Gasoline (unleaded)	Mineral Oil	Sodium Carbonate - 30%
Brine	Glycerin	Mineral Spirits	Sodium Hydroxide - 50%
Barium Chloride - 50%	Glyoxal	Molasses	Sulfuric Acid - 20%
Boric Acid - 25%	Grape Fruit Juice	Motor Oil	Transmission Fluid
Calcium Chloride - 50%	Hexylene Glycol	Mustard	Tomato Juice
Castor Oil	Hydraulic Fluid	Naptha (Aliphatic)	Vegetable Oil
Copper Sulfate - 50%	Hexane	Oleic Acid	Whiskey
Corn Oil	Honey	Olive Oil	Wine
Cutting Oil	Iodine	Orange Juice	Xylene
Diesel Fuel	Jet Fuel (JP4/5/7)	Peanut Oil	
Diethylene Glycol	Kerosene	Phosphoric Acid - 20%	
Distilled Water	Ketchup	Power Steering Fluid	

### SURFACE PREPARATION

Remove all dirt, grease, oil, soil, chemical contaminants, and other matter before mechanical preparation. Surface must be free of salt contamination. Prepare and paint only clean surfaces per SSPC or N.A.C.E. specifications.

Substrate	Preparation
<b>Steel</b>	Coat surfaces the same day as prep.
<b>Galvanized Steel / Aluminum</b>	Solvent clean per SSPC-SP1 or steam clean. Sweep blast to min 1 mil profile. Apply one coat AGCM-15 at 4–5 mils DFT.
<b>Previously Painted Surfaces</b>	Solvent clean per SSPC-SP1 and/or power wash. Remove loose paint by wire brush or hand tools. Feather edges. Test for compatibility.

### V.O.C. COATING SYSTEM

Condition	LBS/GL	GMS/L
<b>Unthinned</b>	1.34	161
<b>Thinned 5%</b>	1.60	192
<b>Thinned 10%</b>	1.83	219
<b>Thinned 20%</b>	2.23	267



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### MIXING INSTRUCTIONS

Stir each component to a uniform consistency using a slow speed explosion proof drill with a Jiffy Mixer. Do not mix by hand. Ensure any settled pigment is fully incorporated. Do not vary proportions.

AGCM-15 is prepared by mixing **4 parts Base (Part A) to 1 part Hardener (Part B)** with a power mixer. May be thinned up to 10% by volume with Xylene for airless spray, up to 20% for conventional spray. When rolling, thin 10–20% by volume. Only thin if absolutely necessary. Best applied as is.

### APPLICATION PROCEDURE

Airless Spray (Graco)		Conventional Spray (DeVilbiss)	
<b>Gun</b>	Silver Plus	<b>Gun</b>	MBC or JGA
<b>Pump</b>	33:1 Extreme	<b>Fluid Tip</b>	D
<b>Tip Range</b>	.019 to .023	<b>Air Cap</b>	64
<b>Hose</b>	3/8" I.D.	<b>Atomizing Press.</b>	60 psi
<b>Pressure</b>	2,400–2,700 psi	<b>Hose</b>	1/2" I.D.
<b>Filter Size</b>	60 Mesh		

**Roller:** 3/8"–1/2" nap, phenolic core, shed resistant cover. Roll in same direction, keep wet edge. Do not over roll. **Brush:** Pure bristle brush.

When spraying, use 50% overlapping crosshatch pattern to minimize pinholes. Do not apply below 45°F or above 120°F. Do not apply over dew or frost. Surface must be dry and 5°F above dew point.

### RECOAT TIME

Temperature	Tack Free	Min Recoat	Max Recoat
90°F	1–2 hours	5–6 hours	3 days
75°F	3–4 hours	7–8 hours	7 days
50°F	8–12 hours	36–48 hours	10 days

Times may be longer for thickness above 5 dry mils. Good ventilation required when painting indoors or in confined areas. Ensure batch numbers match for uniform color.

Epoxy coatings may yellow or darken during application and after final cure — this affects color but not performance. Heaters emitting CO/CO2 can cause yellowing. For maximum interior gloss and color retention, apply one topcoat of AGARM-370 polyurethane.

### CAUTIONS

AGCM-15 is flammable. Keep away from all sources of ignition during mixing, application and cure.

AGCM-15 Hardener is corrosive. The Hardener and Base can cause eye and skin burns as well as allergic reactions. Use goggles, fresh air masks or NIOSH approved respirators, protective gloves and clothing.

This product is sold without warranty as to performance, expressed or implied. Users are urged to make their own tests to determine suitability for their particular conditions.

**SEE SAFETY DATA SHEET FOR FULL SAFETY PRECAUTIONS.**

**FOR PROFESSIONAL AND INDUSTRIAL USE ONLY  
KEEP AWAY FROM CHILDREN — NOT FOR RESIDENTIAL USE**

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