



DESCRIPTION

- a two pack high build polyamide cured epoxy undercoat
- conforms to AS/NZS 3750.13

PRINCIPAL CHARACTERISTICS

- may be used as a primer or undercoat in a system
- excellent adhesion to non ferrous metals and fibre glass
- resistant to spillage and splashing of mild chemicals
- excellent abrasion and impact resistance
- excellent sanding properties
- non reactive pigmentation - suitable for use on aluminium
- excellent flow and wetting properties
- may be overcoated with a range of finish coats
- suitable for immersion in fresh and salt water
- use with Epiname EH90 Part B

COLOURS AND GLOSS

- white - flat

BASIC DATA AT 25 °C

- solids contentapprox. 44% by volume
- mix ratio4A:1B by volume
- typical film thickness (per coat)125 microns(dry), 285 microns(wet)
- theoretical spreading rate3.5 m²/l for 125 microns(dry)
- touch dry after2 hours
- overcoatingmin 4 hours, max 5 days
- full cure after5 days
- shelf life (cool and dry place)at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- galvanised steel; lightly blast using an inert grit or power tool clean to achieve a roughened uniform flat appearance
- aluminium; lightly blast clean using an inert grit and achieve a surface profile of 35-50 microns or mechanically abrade using 80 grit paper/disc
- hot metal spray; high pressure water wash
- fibreglass; mechanically abrade using 120 grit paper/disc
- ZINCALUME® or COLORBOND®; lightly sand the surface
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be above 10 °C during surface preparation, application and curing and at least 3 °C above dew point
- relative humidity should not exceed 85%



INSTRUCTIONS FOR USE

- mixing ratio by volume 4A:1B
- mix with Epinamel EH90 Part B only
- induction time - 20 minutes at 15 °C, 10 minutes at 25 °C
- stir thoroughly after the induction time before using
- pot life at 25 °C 4 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15 °C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION

- **AIRLESS SPRAY**
 - recommended thinnerL760
 - volume of thinnerup to 5%
 - nozzle orificeapprox. 0.46 mm (=0.018 inch)
 - nozzle pressure15 MPa (2100 psi)

- **AIR SPRAY**
 - recommended thinnerL760
 - volume of thinnerup to 10%
 - nozzle orifice1.5 - 2mm
 - nozzle pressure0.3 - 0.3 MPa (43 - 57 psi)

- **BRUSH/ROLLER**
 - recommended thinnerL760
 - volume of thinnerup to 5%
 - the maximum dry film thickness that can be achieved when brushing/rolling is 75 microns. Multiple coats may be required to achieve the recommended dry film thickness

- **CLEANING SOLVENT**L760

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA****Overcoating table**

Substrate temperature	15° C	25° C	35° C
Minimum interval	8 hrs	4 hrs	2 hrs
Maximum interval	5 days	5 days	2 days

- surface must be dry and free from chalking and contamination

Curing table

Substrate temperature	Touch dry	Dry to handle	Full cure
15° C	4 hrs	8 hrs	7 days
25° C	2 hrs	4 hrs	5 days
35° C	1 hr	2 hrs	3 days

- adequate ventilation must be continuously maintained during application and curing

Pot life (at application viscosity)

Paint temperature	Pot Life
15° C	8 hrs
25° C	4 hrs
35° C	2 hrs

CUSTOMER SERVICE HOTLINE 132101 (Aust), 0800 735 551 (NZ)

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