



DESCRIPTION

- two part high build polyamide-cured recoatable epoxy maintenance coating
- approved to APAS-2972 (micaceous iron oxide colours)
- approved to APAS-2973 (solid colours)
- conforms to AS/NZS 3750.14

PRINCIPAL CHARACTERISTICS

- unlimited recoatability
- general purpose epoxy build or finish coat for steel and concrete structures exposed to atmospheric conditions
- can be recoated with various two component and conventional coatings even after long weathering periods
- tough, with long term flexibility and excellent durability
- will cure at temperatures down to -5°C although curing rate is reduced
- can be applied under high relative humidity conditions up to maximum of 95%
- excellent adhesion to suitably prepared aged epoxy coatings
- easy application, both by airless spray and brush
- resistant to water and splash of mild chemicals

COLOURS AND GLOSS

- AS2700 colour card, micaceous iron oxide colour range - semi gloss

BASIC DATA AT 25°C

- solids content approx. 65% by volume
- mix ratio 4A:1B by volume
- typical film thickness (per coat) 100 - 150 microns(dry), 155 - 230 microns(wet)
- theoretical spreading rate 6.5m²/l for 100 microns(dry), 4.3 m²/l for 150 microns(dry)
- touch dry after..... 2 hours
- overcoating interval refer to overcoating table for details
- full cure after..... 4 days
- shelf life (cool and dry place) at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated should be clean, dry and free from contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- previous suitable coat; dry and free from contamination
- substrate temperature must be at least 5°C during application and be at least 3°C above dew point
- concrete; acid etch to remove all laitance (atmospheric exposure only)
- concrete; blast clean to remove all laitance
- moisture content of concrete should be max. 4%

**INSTRUCTIONS FOR USE**

- mixing ratio by volume 4A:1B
- mix with EpinameL EH100 standard hardener only
- induction time 20 minutes if applied at temperatures below 10°C, none if applied above 10°C
- pot life at 25°C 6 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 thinner Thinner L760
 - volume of thinner up to 10%, depending on required dft
 - nozzle orifice..... approx. 0.48 mm (0.019 inch)
 - nozzle pressure 15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinner Thinner L760
 - volume of thinner up to 10%
 - nozzle orifice..... 1.5 - 2 mm
 - nozzle pressure 0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**
 - recommended thinner Thinner L760
 - volume of thinner up 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** Thinner 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 - with Epiname1 EB600**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	10 hrs	4 hrs	3 hrs	2 hrs
Maximum interval	unlimited when free from chalking and contamination			

Overcoating table - with chlorinated rubber, polyurethane, catalysed acrylic and alkyd coatings

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	2 days	1 day	12 hrs	8 hrs
Maximum interval	unlimited when free from chalking and contamination			

Overcoating table - with epoxy coatings

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	5 days	2 days	16 hrs	8 hrs
Maximum interval	unlimited when free from chalking and contamination			

Curing table

Substrate temperature	Dry to handle	Full cure
5°C	18 hrs	8 days
15°C	8 hrs	5 days
25°C	6 hrs	4 days
35°C	4 hrs	3 days

- adequate ventilation must be continuously maintained during application and curing

Pot life (at application viscosity)

Paint temperature	Pot life
15°C	10 hrs
25°C	6 hrs
35°C	4 hrs

CUSTOMER SERVICE HOTLINE 132101 (Aust)

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