



DESCRIPTION

- an amine adduct-cured epoxy coating, reinforced with mineral flake

PRINCIPAL CHARACTERISTICS

- designed essentially for areas of extreme wear and abrasion such as wharfs, drilling rigs, helicopter pads, various types of heavy equipment, etc.
- mineral flake modification
- extremely high abrasion resistance
- excellent weather and corrosion resistance (the coating tends to chalk on exposure but this does not detract from its performance)
- exceptional flexibility
- very high water impermeability
- suitable for immersion in fresh and salt water when applied over suitably prepared surfaces
- excellent chemical resistance
- good curing down to 5°C
- excellent application properties

COLOURS AND GLOSS

- grey, gloss

BASIC DATA AT 25°C

- solids content approx. 82% by volume
- mix ratio 3A:1B by volume
- typical film thickness (per coat) 250 microns(dry), 305 microns(wet)
- theoretical spreading rate 3.3 m²/l for 250 microns(dry)
- touch dry after 6 hours
- overcoating interval..... refer to overcoating table for details
- full cure after 7 days
- shelf life (cool and dry place) at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 85%



INSTRUCTIONS FOR USE

- mix ratio 3A:1B by volume
- mix with Epinamel MF920 Part B only
- induction time - none
- pot life at 25°C 1 hour. 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 Watty!

APPLICATION

- **CONVENTIONAL AIR SPRAY**
 - Thinner L760
 - Thinner addition up to 10%
- **AIRLESS SPRAY**
 - Thinner L760
 - Thinner addition up to 5%
 - Nozzle orifice approx. 0.53 - 0.66 mm (= approx. 0.021 -0.026 inch)
 - Nozzle pressure approx. 19-22 MPa (2700 - 3200 psi)
 - Note:..... use abrasion resistant tips and diffusers. In line filters must be removed prior to spraying
- **BRUSH/ROLLER**
 - Thinner L760
 - volume of thinner up to 5%
 - For touch-up only, as the thixotropic nature of the product makes it difficult to obtain a smooth film
 - The maximum dry film thickness that can be achieved when brushing/rolling is 50 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 with Epiname MF920 or other Epiname epoxies**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	24 hours	16 hours	8 hours	8 hours
Maximum interval	7 days	7 days	7 days	7 days

- surface must be dry and free from chalking and contamination

Overcoating table with Poly U400, Poly U750 or Paracryl IF540

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	24 hours	16 hours	8 hours	8 hours
Maximum interval	5 days	5 days	5 days	5 days

- surface must be dry and free from chalking and contamination
- overcoating with chlorinated rubbers (including SeaPro TC90) or enamels is not recommended

Curing table

Substrate temperature	Touch Dry	Dry to handle	Full cure
5°C	24 hours	4 days	14 days
15°C	12 hours	30 hours	10 days
25°C	6 hours	16 hours	7 days
35°C	4 hours	10 hours	4 days

- adequate ventilation must be continuously maintained during application and curing

Pot life (at application viscosity)

Paint temperature	Potlife
15°C	90 mins
25°C	60 mins
35°C	30 mins

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

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