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 ferrous, 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
• suitable primer for immersion systems (in fresh and salt water) when applied over suitably prepared surfaces
• cure with Epinamel EH100 standard Part B or Epinamel EH120 low temperature Part B

COLOURS AND GLOSS
• white - flat
• N33 Light Box Grey (tint) available on request (for atmospheric exposure only)

BASIC DATA AT 25°C
• solids content ......................... approx. 44% by volume
• mix ratio ............................ 4A:1B by volume
• typical film thickness (per coat)...... 125 microns(dry), 285 microns(wet)
• theoretical spreading rate ........... 3.5 m²/l for 125 microns(dry)
• touch dry after ....................... 2 hours
• overcoating .......................... min 4 hours, max 5 days
• full cure after ......................... 5 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
• mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
• mild steel; power tool clean in accordance with AS 1627.2 to St 2 minimum (AS 1627.9) (atmospheric exposure only)
• 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 EH100 standard Part B or EH120 low temperature Part B only
- induction time - none
- stir thoroughly after the induction time before using
- pot life at 25°C - 6 hours (Epinamel EH100). 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
- note: ensure the dry film thickness after sanding meets the requirements of the specified coating system. Low film builds may result in poor corrosion protection
- Wattyl recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION

- **AIRLESS SPRAY**
  - recommended thinner ........ Thinner L760
  - volume of thinner............... up to 5%
  - nozzle orifice ................ 0.46 mm (=0.018 inch)
  - nozzle pressure................ 15 MPa (2100 psi)

- **AIR SPRAY**
  - recommended thinner ........ Thinner L760
  - volume of thinner............... up to 10%
  - nozzle orifice ................ 1.8 – 2mm
  - nozzle pressure................ 0.3 - 0.3 MPa (43 - 57 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

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>Epinamel EH100</th>
<th>Epinamel EH120</th>
</tr>
</thead>
<tbody>
<tr>
<td>15°C</td>
<td>8 hrs</td>
<td>6 hrs</td>
</tr>
<tr>
<td>25°C</td>
<td>4 hrs</td>
<td>3 hrs</td>
</tr>
<tr>
<td>35°C</td>
<td>2 hrs</td>
<td>1 hr</td>
</tr>
</tbody>
</table>

Note: surface must be dry and free from chalking and contamination prior to overcoating. If overcoating interval is exceeded, the surface must be dry and free from chalking and contamination and sufficiently roughened.

Curing table

<table>
<thead>
<tr>
<th>Substrate temperature</th>
<th>Epinamel EH100</th>
<th>Epinamel EH120</th>
</tr>
</thead>
<tbody>
<tr>
<td>Touch dry</td>
<td></td>
<td>Full cure</td>
</tr>
<tr>
<td>Dry to handle</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15°C</td>
<td>4 hrs</td>
<td>3 hrs</td>
</tr>
<tr>
<td>25°C</td>
<td>2 hrs</td>
<td>1½ hrs</td>
</tr>
<tr>
<td>35°C</td>
<td>1 hr</td>
<td>45 min</td>
</tr>
<tr>
<td>Dry to handle</td>
<td>8 hrs</td>
<td>6 hrs</td>
</tr>
<tr>
<td>Full cure</td>
<td>7 days</td>
<td>5 days</td>
</tr>
<tr>
<td></td>
<td>5 days</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3 days</td>
<td></td>
</tr>
<tr>
<td></td>
<td>2 days</td>
<td></td>
</tr>
</tbody>
</table>

Pot life (at application viscosity)

<table>
<thead>
<tr>
<th>Paint temperature</th>
<th>Epinamel EH100</th>
<th>Epinamel EH120</th>
</tr>
</thead>
<tbody>
<tr>
<td>15°C</td>
<td>10 hrs</td>
<td>6 hrs</td>
</tr>
<tr>
<td>25°C</td>
<td>6 hrs</td>
<td>3 hrs</td>
</tr>
<tr>
<td>35°C</td>
<td>3 hrs</td>
<td>2 hrs</td>
</tr>
</tbody>
</table>

• Adequate ventilation must be continuously maintained during application and curing.

For the most up to date information contact Wattyl Customer Service Hotline or visit the Wattyl Website.

CUSTOMER SERVICE HOTLINE
Australia: 132 101
New Zealand: 0800 735 551
WEBSITE
http://www.wattyl.com.au
http://www.wattyl.co.nz

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