EPINAMEL® UHB1000

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Description

- Ultra-high build, solvent-free two pack amine cured epoxy coating
- Conforms to AS/NZS 3750.2 Type 1

Product Characteristics

- Solvent-free, eliminates risk of explosion or fire
- Single coat protection for wharf piles, wharf decking or other structures
- Can be applied to existing piling between tides
- Can be exposed to water immersion shortly after application
- Suitable for immersion in fresh and salt water

Colours and Gloss

- Neutral Grey - gloss

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	500	1500	1000
Wet film thickness (µm)	500	1500	1000
Theoretical spreading rate (m^2/l)	2.0	0.7	1.0

Basic Data at 25°C

Solids content approx.	100% by volume
Mix ratio	4A:1B by volume
Touch dry after	10 hours
Full cure	Refer to curing table
Temperature Resistance	100°C (dry), 35°C (wet)

Surface Preparation

- 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.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination and sufficiently roughened if necessary.
- Substrate temperature must be at least 5°C during application and curing and at least 3°C above dew point
- Relative humidity should not exceed 85%
- Exposure to unacceptably low temperatures and/or high humidity during or immediately after application may result in incomplete cure and surface contamination that could adversely affect subsequent inter-coat adhesion

MILD STEEL

- Blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 50-100 microns.
- If oxidation occurs between blasting and application, the surface should be re-blasted to the specified visual standard
- Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

CONCRETE

- Must be free from bond breakers, curing agents or any other contaminants that may interfere with adhesion.
- Should be blast cleaned to remove all laitance; moisture content should be maximum 4%.
- Ensure all new concrete is fully cured prior to coating. Typically, this may take a minimum of 4-6 weeks.

Application Instructions

- Mixing ratio by volume: 4A:1B.
- Mix Epinamel UHB1000 Part A with Epinamel UHB1000 Part B only.
- Induction time – none.
- Pot life at 25°C: 40 minutes. 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 at least 20°C
- Product must not be thinned
- Do not apply this product with conventional air spray equipment
- Freshly catalysed material should not be added to product that has been mixed for some time.
- 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 Methods

	AIRLESS SPRAY	BRUSH/ROLLER
Recommended thinner	Do not thin	Do not thin
Tip	0.53-0.66mm (0.021-0.026 inch)	• The maximum dry film thickness that can be achieved when brushing/rolling is 150 microns.
Fluid/ Atomised pressure	Paint temperature of 20°C: 28 MPa (4000 psi) Paint temperature of 30°C: 22 MPa (3200 psi)	
Pump	60:1 or 68:1	

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Hose	3/8" ID (10mm) Maximum length 15m	• Multiple coats may be required to achieve the recommended dry film thickness

CLEANING SOLVENT | Thinner L760

- Inline heating or insulated hoses may be necessary to avoid cooling down at low temperatures
- Application with 45:1 pump ratio is possible provided in-line heated high pressure fluid hoses are used and the mixed paint is heated to 30°C to reduce viscosity
- All paint must be removed from the spray equipment immediately after use. Clean thoroughly with the recommended solvent before the pot life expires.

Safety Precautions

- 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 safety data sheet (SDS).

Additional Data

WET/DRY FILM THICKNESS

- Product thixotropy and surface tension will retard the release of entrapped air after application and may result in a deviation between the wet film thickness (wft) measured immediately after application and the dry film thickness (dft) of the cured coating
- To ensure that the correct specified dft is achieved it is recommended that applied wft is equal to the specified dft plus 60 microns
- When measuring the dft in the early stages of cure it is recommended that a calibration shim of a known thickness be placed between the film thickness gauge and the surface of the coating to avoid penetration into the soft coating

OVERCOATING TABLE

Overcoating interval for Epinamel UHB1000 when top coating with itself

Interval	5°C	15°C	25°C	35°C
Min	3 days	2 days	1 day	1 day
Max	28 days	21 days	14 days	14 days

- Suitable for application between tides, allow 30 minutes set up time before immersion
- Coating will continue to cure when immersed in water
- Premature exposure to water may cause colour or gloss change but will not affect the coating performance
- 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

Curing Table for Epinamel UHB1000

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	3 days	2 days	24 hrs	12 hrs
Full cure	15 days	10 days	5 days	3 days

POTLIFE TABLE

Potlife Table for Epinamel UHB1000

Paint temperature	20°C	25°C	30°C
Potlife (at applicable viscosity)	50 mins	40 mins	30 mins

- Adequate ventilation must be continuously maintained during application and curing.
- Due to an exothermic reaction the temperature of the product may increase during and after mixing

Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.

Product Compatibility

PRIMERS – N/A

TOPCOATS

- Epinamel UHB1000

Storage and Packaging

- Shelf life at least 12 months.
- All components shall be stored in a dry internal environment at between 5°C and 35°C.
- Packaging: 16 litre kit (12.8 litre Part A, 3.2 litre Part B)
- Product line: 2003.

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For the most up to date information, please visit our website at www.wattylpc.com.au,
or contact us at Australia 132 101 (Australia) 0800 825 7727 (New Zealand).

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