

EPINAMEL® MF920

P36.01

Description

A two-component, amine adduct-cured epoxy coating, reinforced with mineral flake and conforms to AS/NZS 3750.14.

Product 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.

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	225	275	250
Wet film thickness (µm)	275	335	305
Theoretical spreading rate (m ² /l)	3.6	3.0	3.3

Basic Data at 25°C

Solids content approx.	82% by volume
Mix ratio	3A:1B by volume
Touch dry after	6 hours
Full cure	7 days
Abrasion resistance	70mg (AS1580.403.2-2006, CS17 wheel, 1000g, 1000 cycles)
Adhesion	11MPa (1600psi) (AS1580.408.5, applied to abrasive blasted mild steel (AS1627.4 Sa2.5))
Temperature resistance	95°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.

MILD STEEL

- Blast clean in accordance with AS 1627.4 to Sa 2 ½ 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%.

Application Instructions

- Mixing ratio by volume: 3A:1B.
- Mix Epiname MF920 Part A with Epiname 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.
- 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*	AIR SPRAY	BRUSH/ROLLER
Recommended thinner	Thinner L760	Thinner L760	Thinner L760
Volume of thinner	0-5%	0-10%	0-5%
Nozzle orifice approx.	0.53-0.66mm (0.021-0.26inch)	1.8 - 2.0mm	For touch-up only, as the thixotropic nature of the product makes it difficult to obtain a smooth film.
Nozzle pressure	19-22 MPa (2700-3200psi)	0.3 - 0.4 MPa (50 - 60 psi)	Multiple coats may be required to achieve the recommended dry film thickness.

*For Airless Spray - Use abrasion resistant tips and diffusers. In line filters must be removed prior to spraying.

CLEANING SOLVENT | Thinner L760

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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

Overcoating interval for Epinamel MF920 when top coating with **Epinamel MF920 or other compatible Epinamel Epoxies.**

Interval	5°C	15°C	25°C	35°C
Min	24 hrs	16 hrs	8 hrs	8 hrs
Max	7 days	7 days	7 days	7 days

Overcoating interval for Epinamel MF920 when top coating with **Poly U400, Poly U750 or Paracryl IF540.**

Interval	5°C	15°C	25°C	35°C
Min	24 hrs	16 hrs	8 hrs	8 hrs
Max	5 days	5 days	5 days	5 days

- Overcoating with chlorinated rubbers (including SeaPro TC90) or enamels is NOT recommended.
- 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 AND POTLIFE TABLE

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	4 days	30 hrs	16 hrs	10 hrs
Full cure	14 days	10 days	7 days	4 days
Potlife (at application viscosity)	-	90 mins	60 mins	30 mins

- Adequate ventilation must be continuously maintained during application and curing

Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.
- Epoxy coatings characteristically chalk or discolour on exterior exposure- this does not detract from their protective performance. For exterior atmospheric coating systems requiring colour retention and resistance to chalking, topcoat with a suitable product. Such products may include Poly U400, Poly U750 or Paracryl IF540. Ensure the system is suitable for your intended application.

Product Compatibility

PRIMERS

- Epinamel PR250

TOPCOATS

- Epinamel DTS680
- Poly U400 (colours)
- Poly U750
- Paracryl IF540 (colours)

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 20 litre kit (15 litre Part A, 5 litre Part B),
- Product line: 2026.

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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