

EPINAMEL® UC230

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Description

A two-pack high build polyamide cured epoxy undercoat and conforms to AS/NZS 3750.13.

Product 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 #60012) available on request (for atmospheric exposure only).

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	75	125	125
Wet film thickness (µm)	170	285	285
Theoretical spreading rate (m ² /l)	5.9	3.5	3.5

Basic Data at 25°C

Solids content approx.	44% by volume
Mix ratio	4A:1B by volume
Touch dry after	2 hours (Epinamel EH100)
Full cure	5 days (Epinamel EH100)
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.
- 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.
- Mechanically abrade using 80 grit paper/disc.

FIBREGLASS

- Mechanically abrade using 120 grit paper/disc.

ZINCALUME® or COLORBOND®

- Lightly sand the surface.

HOT METAL SPRAY

- High pressure water wash.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination and sufficiently roughened if necessary.

Temperature and Humidity Conditions

- Substrate temperature must be at least 10°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: 4A:1B.
- Mix Epinamel UC230 Part A with Epinamel EH100 Standard (Std) Part B or Epinamel EH120 Low Temperature (LT) Part B only.
- Induction time – none.
- 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.

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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.	0.46mm (0.018 inch)	1.8-2.0 mm	The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns.
Nozzle pressure	15 MPa (2100 psi)	0.3-0.4 MPa (50-60 psi)	Multiple coats may be required to achieve the recommended dry film thickness.

CLEANING SOLVENT | Thinner L760

- If spraying for extended periods or if stopping work it is recommended to intermittently flush out spray lines.

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 safety data sheet (SDS).

Additional Data

OVERCOATING TABLE

Overcoating interval for Epiname UC230 cured with Epiname EH100 Standard Part B when top coating with compatible **two-pack epoxy and polyurethane coatings**.

Interval	15°C	25°C	35°C
Min	6 hrs	3 hrs	1,5 hrs
Max*	5 days	3 days	2 days

*Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight

Overcoating interval for Epiname U230 cured with Epiname EH100 Standard Part B when top coating with compatible **chlorinated rubber, alkyd and catalysed acrylic coating**.

Interval	15°C	25°C	35°C
Min	8 hrs	4 hrs	2 hrs
Max*	5 days	3 days	2 days

Overcoating interval for Epiname UC230 cured with Epiname EH120 Low Temperature Part B when top coating with compatible **two pack epoxy and polyurethane coatings**.

Interval	15°C	25°C	35°C
Min	6 hrs	3 hrs	1 hr
Max*	4 days	2 days	1 day

Overcoating interval for Epiname UC230 cured with Epiname EH120 Low Temperature Part B when top coating with compatible **chlorinated rubber, alkyd and catalysed acrylic coatings**.

Interval	15°C	25°C	35°C
Min	6 hrs	3 hrs	1.5 hr
Max*	4 days	2 days	1 day

*Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight

- When using Epiname EH120 Part B for immersion applications the minimum overcoating times applicable for Epiname EH100 Part B must be observed,
- 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.

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CURING AND POTLIFE TABLE

Epinamel UC230 cured with Epinamel EH100 Standard Part B.

Paint temperature	15°C	25°C	35°C
Touch dry	4 hrs	2 hrs	1 hr
Dry to handle	8 hrs	4 hrs	1 hr
Full cure	7 days	5 days	3 days
Potlife (at application viscosity)	10 hrs	6 hrs	3 hrs

Epinamel UC230 cured with Epinamel EH120 Low Temperature Part B.

Paint temperature	15°C	25°C	35°C
Touch dry	3 hrs	1.5 hrs	45 mins
Dry to handle	6 hrs	3 hrs	1.5 hrs
Full cure	5 days	3 days	2 days
Potlife (at application viscosity)	6 hrs	3 hrs	2 hrs

- 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

- Galvit EP100
- Galvit ES510
- Galvit ES600
- Epinamel PR250

TOPCOATS

- Epinamel DTS680
- Epinamel DTM985
- Duranamel BR22
- Colourthane PF330
- Colourthane C-Series
- Poly U400 (colours)
- Poly U750
- Paracryl IF540 (colours)
- SeaPro TC170 Tiecoat

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 (16 litre Part A, 4 litre Part B)
5 litre kit (4 litre Part A, 1 litre Part B)
- Product line: 201311 (Epinamel UC230 Part A)
200301 (Epinamel EH100 Part B)
200302 (Epinamel EH120 Part B)

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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