

EPINAMEL® EB600

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Description

- A two-pack polyamide-cured, recoatable epoxy maintenance coating.
- Approved to APAS-2973.
- Conforms to AS/NZS 3750.14

Product Characteristics

- Unlimited recoatability.
- General purpose epoxy build for finish coat for steel and concrete structures exposed to atmospheric conditions.
- Can be recoated with various two component and conventional coatings even after long weathering periods.
- Cures at temperatures down to -5°C, although curing rate is reduced.
- Can be applied under high relative humidity conditions up to a maximum of 95%
- Excellent adhesion to suitably prepared aged epoxy coatings.
- Easy to apply, both by airless spray and brush
- Resistant to water and splash of mild chemicals.

Colours and Gloss

- AS2700 colour card (using the Ultratint tint system) and common concrete flooring colours (using Ectotint colourants) – semi gloss

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	100	150	150
Wet film thickness (µm)	155	230	230
Theoretical spreading rate (m ² /l)	6.5	4.3	4.3

Basic Data at 25°C

Solids content approx.	65% by volume
Mix ratio	4A:1B by volume
Touch dry after	2 hours (Epinamel EH100)
Full cure	4 days (Epinamel EH100)

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.
- Substrate temperature must be at least 5°C during application and be at least 3°C above dew point.

CONCRETE & MASONRY

- Must be free from bond breakers, curing agents or any other contaminants that may interfere with adhesion.
- Acid etch to remove all laitance.
- Blast clean to remove all laitance.
- Moisture content of concrete should be a max. 4%.

- Ensure all new concrete is fully cured prior to coating; typically, this may take a minimum of 4-6 weeks.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination.
- Oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning.

Application Instructions

- Mixing ratio by volume: 4A:1B.
- Mix Epinamel EB600 Part A with Epinamel EH100 Standard (Std) Part B or Epinamel EH120 Low Temperature (LT) Part B only.
- Induction time – none, if applied above 10°C.
- Induction time – 20 minutes if applied at temperatures below 10°C.
- Stir thoroughly after the induction time before using.
- Pot life at 25°C (untinted) - 6 hours (Epinamel EH100), 3 hours (Epinamel EH120) - 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 application to concrete Epinamel EB600 may be tinted with either Ultratint or Ecotint colourants. When tinted with Ecotint colourants the product has a reduced potlife, refer to the potlife tables for more information.
- Epinamel EB600 tinted with Ecotint colourants may be used for application to concrete substrates only and is not suitable for use as part of an anticorrosive system for steel.
- 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	0-10%	0-10%	0-10%
Tip	0.48- (0.019 inch)	1.8- 2.0mm	• The maximum dry film thickness that

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Fluid/ Atomised pressure	15 MPa (2100 psi)	0.3-0.4 MPa (50-60 psi)	can be achieved when brushing/rolling is 75 microns.
Pump	30:1		• Multiple coats may be required to achieve the recommended dry film thickness.
Hose	¼" ID (6.3mm)		• Nylon/polyester or natural bristle brushes recommended.
Filter	60 mesh		• Recommended roller cover should be 10mm woven with a solvent resistant core.

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 Epinamel EB600 cured with Epinamel EH100 Standard Part B when top coating with **Epinamel EB600**.

Interval	5°C	15°C	25°C	35°C
Min	10 hrs	4 hrs	3 hrs	2 hrs
Max	Unlimited when dry & free from chalking & contamination.			

Overcoating interval for Epinamel EB600 cured with Epinamel EH20 Low Temperature Part B when top coating with **Epinamel EB600**.

Interval	5°C	15°C	25°C	35°C
Min	8 hrs	3 hrs	2 hrs	1 hrs
Max*	Unlimited when dry & free from chalking & contamination.			

Overcoating interval for Epinamel EB600 cured with Epinamel EH100 Low Temperature Part B when top coating with **chlorinated rubber, polyurethane, catalysed acrylic and epoxy coatings**.

Interval	5°C	15°C	25°C	35°C
Min	24 hrs	12 hrs	8 hrs	4 hrs
Max*	Unlimited when dry & free from chalking & contamination.			

Overcoating interval for Epinamel EB600 cured with Epinamel EH120 Low Temperature Part B when top coating with compatible **chlorinated rubber, alkyd and catalysed acrylic coatings**.

Interval	5°C	15°C	25°C	35°C
Min	16 hrs	8 hrs	6 hrs	4 hr
Max*	Unlimited when dry & free from chalking & contamination.			

- 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

Epinamel EB600 cured with Epinamel EH100 Std Part B.

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	18 hrs	8 hrs	6 hrs	4 hrs
Full cure	8 days	5 days	4 days	3 days
Potlife (factory colours or tinted with Ultratint)	-	10 hrs	6 hrs	4 hrs
Potlife (tinted with Ecotiint)	-	4 hrs	3 hrs	2 hrs

Epinamel EB600 Cured with Epinamel EH120 Low Temperature Part B.

Paint temperature	5°C	15°C	25°C	35°C
Dry to handle	12 hrs	6 hrs	4 hrs	2 hrs
Full cure	6 days	4 days	3 days	2 days
Potlife (factory colours or tinted with Ultratint)	9 hrs	6 hrs	3 hrs	1.5 hrs
Potlife (tinted with Ecotiint)	4.5 hrs	3 hrs	1.5 hrs	45 mins

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

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Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.
- This product is not suitable for waterproofing applications, or to withstand hydrostatic pressure.
- Do not apply to concrete where a silicate hardener has been applied.
- Smooth surfaces coated with this product may become slippery when wet. For improved resistance to slipping, add an anti-slip texture additive to the coating, following the usage instructions on the label.
- 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.

Product Compatibility

PRIMERS

- Galvit EP100
- Galvit ES510
- Galvit ES600
- Epiname! PR250

TOPCOATS

- Epiname! EB600
- Poly U400
- Poly U750
- Paracryl IF540

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: 2009.

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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