



**DESCRIPTION**

- a two component surface tolerant high solids, direct to metal high build polyamide adduct cured epoxy coating
- approved to APAS-2973
- conforms to AS/NZS 3750.14

**PRINCIPAL CHARACTERISTICS**

- maintenance coating for use in a wide range of industrial applications as a primer, build coat or finish coat
- tolerant to lower grades of steel preparation for atmospheric exposure
- excellent recoatability
- cures down to 5°C
- excellent abrasion resistance
- resistant to splash of alkali, salt and freshwater, mineral oils, solvents and dilute acids
- not recommended for immersion

**COLOURS AND GLOSS**

- AS 2700 Colour card, micaceous iron oxide colour range - gloss

**BASIC DATA AT 25 °C**

- solids content..... approx. 80% by volume
- mix ratio ..... 3A:1B by volume
- recommended dry film thickness ..... 150 - 400 microns(dry), 190 - 500 microns(wet)
- theoretical spreading rate ..... 5.4 m<sup>2</sup>/litre for 150 microns; 2.0 m<sup>2</sup>/litre for 400 microns
- touch dry after ..... 2 - 4 hours
- overcoating interval..... refer to overcoating table for details
- full cure ..... 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, dry and free from chalking and contamination
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- 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)
- 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
- substrate temperature must be at least 5°C during application and 3°C above dew point
- relative humidity should not exceed 85%



**INSTRUCTIONS FOR USE**

- mixing ratio by volume: base to hardener 3A:1B
- mix with Epinamel DTM800 Part B only
- induction time - 15 mins at 15°C, 5 mins at 25°C
- stir thoroughly after the induction time before using
- pot life at 25°C - 2 hours
- 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 recommendations outside those contained in this data sheet, refer to WattyL

**APPLICATION**

- **AIRLESS SPRAY**
  - recommended thinner .....L760
  - volume of thinner .....0-5%
  - nozzle orifice .....approx. 0.53 - 0.58 mm (0.021 - 0.023 inch)
  - nozzle pressure .....15 MPa (2100 psi)
- **AIR SPRAY**
  - recommended thinner .....L760
  - volume of thinner .....0-10%
  - nozzle orifice .....1.5-2mm
  - nozzle pressure .....0.2-0.4 MPa (30-60 psi)
- **BRUSH/ROLLER (only for touch up and spot repair)**
  - recommended thinner .....L760
  - volume of thinner .....0-10%
- **CLEANING SOLVENT .....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 with Epinamel DTM800**

Substrate Temperature	5 °C	15 °C	25 °C	35 °C	45 °C
Minimum interval	24 hrs	12 hrs	6 hrs	4 hrs	3 hrs
Maximum interval	unlimited	unlimited	unlimited	unlimited	unlimited

- surface must be dry and free from chalking and contamination

**Overcoating table with two pack polyurethane and epoxy coatings**

Substrate Temperature	5 °C	15 °C	25 °C	35 °C	45 °C
Minimum interval	24 hrs	12 hrs	6 hrs	4 hrs	3 hrs
Maximum interval	2 months	2 months	2 months	1 month	1 month

- surface must be dry and free from chalking and contamination
- overcoating with catalysed acrylics is not recommended

**Curing Table**

Paint temperature	Dry to handle	Full cure
5 °C	24 hours	14 days
15 °C	12 hours	7 days
25 °C	6 hours	5 days
35 °C	4 hours	3 days
45 °C	3 hours	2 days

- adequate ventilation must be continuously maintained during application and curing

**Potlife (at application viscosity)**

Paint temperature	Potlife
15 °C	4 hrs
25 °C	2 hrs
35 °C	1 hr

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