



**DESCRIPTION**

- two part high build polyamide-cured recoatable epoxy maintenance coating
- approved to APAS-2973 (solid and micaceous iron oxide colours)
- conforms to AS/NZS 3750.14
- FDA Food Contact Compliant (refer below)

**PRINCIPAL CHARACTERISTICS**

- unlimited recoatability
- general purpose epoxy build or 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
- tough, with long term flexibility and excellent durability
- will cure at temperatures down to -5°C although curing rate is reduced
- can be applied under high relative humidity conditions up to maximum of 95%
- excellent adhesion to suitably prepared aged epoxy coatings
- easy application, both by airless spray and brush
- resistant to water and splash of mild chemicals

**COLOURS AND GLOSS**

- AS2700 colour card, micaceous iron oxide colour range - semi gloss

**BASIC DATA AT 25°C**

- solids content ..... approx. 65% by volume
- mix ratio ..... 4A:1B by volume
- typical film thickness (per coat) ..... 100 - 150 microns(dry), 155 - 230 microns(wet)
- theoretical spreading rate ..... 6.5m<sup>2</sup>/l for 100 microns(dry), 4.3 m<sup>2</sup>/l for 150 microns(dry)
- touch dry after ..... 2 hours
- overcoating interval..... refer to overcoating table for details
- full cure after ..... 4 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
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- previous suitable coat; dry and free from contamination
- substrate temperature must be at least 5°C during application and be at least 3°C above dew point
- concrete; acid etch to remove all laitance (atmospheric exposure only)
- concrete; blast clean to remove all laitance
- moisture content of concrete should be max. 4%



## INSTRUCTIONS FOR USE

- mixing ratio by volume 4A:1B
- mix with Epiname EH100 standard hardener 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 6 hours. 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 recommendations outside those contained in this data sheet, refer to Watty!

## APPLICATION

- **AIRLESS SPRAY**
  - recommended thinner ..... Thinner L760
  - volume of thinner ..... up to 10%, depending on required dft
  - nozzle orifice..... approx. 0.48 mm (0.019 inch)
  - nozzle pressure ..... 15 MPa (2100 psi)
- **AIR SPRAY**
  - recommended thinner .... Thinner L760
  - volume of thinner ..... up to 10%
  - nozzle orifice..... 1.5 - 2 mm
  - nozzle pressure ..... 0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**
  - recommended thinner .... Thinner L760
  - volume of thinner ..... up to 5%
  - The maximum dry film thickness that can be achieved when brushing/rolling is 75 microns
  - Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** ..... Thinner 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 EB600**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	10 hrs	4 hrs	3 hrs	2 hrs
Maximum interval	unlimited when dry and free from chalking and contamination			

**Overcoating table - with chlorinated rubber, polyurethane, catalysed acrylic and alkyd coatings**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	2 days	1 day	12 hrs	8 hrs
Maximum interval	unlimited when dry and free from chalking and contamination			

**Overcoating table - with epoxy coatings**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	5 days	2 days	16 hrs	8 hrs
Maximum interval	unlimited when dry and free from chalking and contamination			

**Curing table**

Substrate temperature	Dry to handle	Full cure
5°C	18 hrs	8 days
15°C	8 hrs	5 days
25°C	6 hrs	4 days
35°C	4 hrs	3 days

- adequate ventilation must be continuously maintained during application and curing

**Pot life (at application viscosity)**

Paint temperature	Pot life
15°C	10 hrs
25°C	6 hrs
35°C	4 hrs

**FOOD APPROVAL**

- The film forming components of Epiname! EB600 are allowed by the Food and Drug Authority (FDA), U.S. Code of Federal Regulation, Section 175.300 for use in food processing environments in contact with dry food stuffs. The film shall be fully cured prior to exposure and is subject to the limitations and conditions of use prescribed in the above Section. For use in other food contact environments please contact Wattyl Technical Services for advice.

For the most up to date information contact Wattyl Customer Service Hotline or visit the Wattyl Website.

	<b>Australia</b>	<b>New Zealand</b>
<b>CUSTOMER SERVICE HOTLINE</b>	<b>132 101</b>	<b>0800 735 551</b>
<b>WEBSITE</b>	<a href="http://www.wattyl.com.au">http://www.wattyl.com.au</a>	<a href="http://www.wattyl.co.nz">http://www.wattyl.co.nz</a>

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