DESCRIPTION
• a two pack high build polyamide cured epoxy undercoat
• conforms to AS/NZS 3750.13

PRINCIPAL 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 for coating 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)

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Maximum</th>
<th>Typical</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry film thickness microns</td>
<td>75</td>
<td>125</td>
</tr>
<tr>
<td>Wet film thickness microns</td>
<td>170</td>
<td>285</td>
</tr>
<tr>
<td>Theoretical spreading rate m²/l</td>
<td>5.9</td>
<td>3.5</td>
</tr>
</tbody>
</table>

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 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 2½ minimum (AS 1627.9), surface profile 40-70 microns
• if oxidation occurs between blasting and application, the surface should be blast cleaned in accordance with 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
• Valspar 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 Valspar

Note: Before use, thoroughly mix the components in a mechanical mixer, stir the components and mixed product well using a mechanical mixer after this time even if the mix is still liquid. 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.
APPLICATION METHODS

- **AIRLESS SPRAY**
  - recommended thinner .......... Thinner L760
  - volume of thinner .................. 0-5%
  - nozzle orifice approx. ........... 0.46 mm (0.018 inch)
  - nozzle pressure .................. 15 MPa (2100 psi)

- **AIR SPRAY**
  - recommended thinner .......... Thinner L760
  - volume of thinner .................. 0-10%
  - nozzle orifice .................... 1.8-2.0 mm
  - nozzle pressure .................. 0.3-0.4 MPa (50-60 psi)

- **BRUSH/ROLLER**
  - recommended thinner .......... Thinner L760
  - volume of thinner .................. 0-5%
  - The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns
  - 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 Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

**Overcoating Table**

<table>
<thead>
<tr>
<th>Interval</th>
<th>15°C</th>
<th>25°C</th>
<th>35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Overcoating interval for Epinamel UC230 cured with Epinamel EH100 Standard Part B when top coating with compatible two pack epoxy and polyurethane coatings</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Min</td>
<td>6 hrs</td>
<td>3 hrs</td>
<td>1 ½ hrs</td>
</tr>
<tr>
<td>Max*</td>
<td>5 days</td>
<td>3 days</td>
<td>2 days</td>
</tr>
</tbody>
</table>

Overcoating interval for Epinamel UC230 cured with Epinamel EH100 Standard Part B when top coating with compatible chlorinated rubber, alkyd and catalysed acrylic coatings

<table>
<thead>
<tr>
<th>Interval</th>
<th>15°C</th>
<th>25°C</th>
<th>35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min</td>
<td>8 hrs</td>
<td>4 hrs</td>
<td>2 hrs</td>
</tr>
<tr>
<td>Max*</td>
<td>5 days</td>
<td>3 days</td>
<td>2 days</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Interval</th>
<th>15°C</th>
<th>25°C</th>
<th>35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min</td>
<td>6 hrs</td>
<td>3 hrs</td>
<td>1 hr</td>
</tr>
<tr>
<td>Max*</td>
<td>4 days</td>
<td>2 days</td>
<td>1 day</td>
</tr>
</tbody>
</table>

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

- when using Epinamel EH120 Part B for immersion applications the minimum overcoating times applicable for Epinamel 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
Curing and Potlife Table

<table>
<thead>
<tr>
<th>Product</th>
<th>Paint temperature</th>
<th>Touch Dry</th>
<th>Dry to handle</th>
<th>Full Cure</th>
<th>Potlife (at application viscosity)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Epinamel UC230 cured with Epinamel EH100 Standard Part B</td>
<td>15°C</td>
<td>4 hrs</td>
<td>8 hrs</td>
<td>7 days</td>
<td>10 hrs</td>
</tr>
<tr>
<td></td>
<td>25°C</td>
<td>2 hrs</td>
<td>4 hrs</td>
<td>5 days</td>
<td>6 hrs</td>
</tr>
<tr>
<td></td>
<td>35°C</td>
<td>1 hr</td>
<td>1 hr</td>
<td>3 days</td>
<td>3 hrs</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Product</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Epinamel UC230 cured with Epinamel EH120 Low Temperature Part B</td>
<td>15°C</td>
<td>3 hrs</td>
<td>6 hrs</td>
<td>5 days</td>
<td>6 hrs</td>
</tr>
<tr>
<td></td>
<td>25°C</td>
<td>1 ½ hrs</td>
<td>3 hrs</td>
<td>3 days</td>
<td>3 hrs</td>
</tr>
<tr>
<td></td>
<td>35°C</td>
<td>1 ½ hrs</td>
<td>½ hrs</td>
<td>2 days</td>
<td>2 hrs</td>
</tr>
</tbody>
</table>

**PRODUCT COMPATIBILITY**

**Primers**
- Galvfit EP100
- Galvfit EP102
- Galvfit ES510
- Galvfit ES600
- Epinamel PR250

**Topcoats**
- Epinamel EB600
- Epinamel CF602
- Epinamel DTS680
- Epinamel DM985
- 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)

Valspar is committed to quality in the design, production and delivery of its products and services. Valspar’s Australian manufacturing facilities quality management systems are certified to ISO9001.

Valspar's laboratory facilities are accredited for technical competence with the National Association of Tests Authorities, Australia (NATA) and comply with the requirements of ISO/IEC 17025. Accreditation No.104 (Footscray), 1154 (Glendenning) and 931 (Kilburn).

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

Australia: 132 101 (New Zealand: 0800 735 551)
Website: www.wattylpc.com

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