EPINAMEL® EB600 P31.01

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
- heat resistant up to 200°C. (MIO version only) Refer to Wattyl Protective and Marine Coatings System Guide for system details

COLOURS AND GLOSS

- AS2700 colour card (using the Ultratint tint system),
- factory manufactured colours White, Y14 Golden Yellow, micaceous iron oxide colour range
- common concrete flooring colours (using Ecotint colourants)
- semi gloss

RECOMMENDED FILM THICKNESS (PER COAT)

	Minimum	Maximum	Typical
Dry film thickness microns	100	150	150
Wet film thickness microns	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
- full cure .....4 days
- 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
- substrate temperature must be at least 5°C during application and be at least 3°C above dew point

PREVIOUS SUITABLE COAT

- dry and free from contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning

CONCRETE

- 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 max. 4%
- ensure all new concrete is fully cured prior to coating. Typically this may take a minimum of 4-6 weeks

APPLICATION INSTRUCTIONS

- mixing ratio by volume: base to hardener 4A:1B
- mix with Epinamel EH100 standard 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 (Std Part B), 3 hours (LT Part B). 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
- Note: 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
- 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

APPLICATION METHODS

- **AIRLESS SPRAY**
  - recommended thinner .....Thinner L760
  - volume of thinner .....0-10% depending on required dft
  - nozzle orifice approx. .....0.48mm (0.019 inch)
  - nozzle pressure .....15 MPa (2100 psi)

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

- **BRUSH/ROLLER**
  - recommended thinner .....Thinner L760
  - volume of thinner 0-10%
  - 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

- 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

Overcoating interval for Epinamel EB600 cured with 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 EH120 LT Part B when top coating with **Epinamel EB600**

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

Overcoating interval for Epinamel EB600 cured with EH100 Standard Part B when top coating with **chlorinated rubber, polyurethane, catalysed acrylic, alkyd 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 EH120 LT Part B when top coating with **chlorinated rubber, polyurethane, catalysed acrylic, alkyd and epoxy coatings**

Interval	5°C	15°C	25°C	35°C
Min	16 hrs	8 hrs	4 hrs	2 hrs
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 Table

Curing Table for Epinamel EB600 cured with **EH100 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

Curing Table for Epinamel EB600 cured with **EH120 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

- adequate ventilation must be continuously maintained during application and curing

Potlife Table

Potlife Table for Epinamel EB600 **factory colours** or colours tinted with the **Ultratint** tint system

Paint temperature	15°C	25°C	35°C
Potlife (cured with EH100 Part B)	10 hrs	6 hrs	4 hrs
Potlife (cured with EH120 Part B)	5 hrs	3 hrs	2 hrs

Potlife Table for Epinamel EB600 colours tinted with **Ecotint** colourants

Paint temperature	15°C	25°C	35°C
Potlife (cured with EH100 Part B)	4 hrs	3 hrs	1 hr
Potlife (cured with EH120 Part B)	3 hrs	1 ½ hrs	45 mins

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar
- this product may chalk or discolour on exterior exposure however it does not detract from its performance.
- 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.

PRODUCT COMPATIBILITY

Primers

- Galvit EP100
- Galvit EP102
- Galvit ES510
- Galvit ES600
- Epinamel CP502
- Epinamel PR250
- Epinamel PR360ZPS

Topcoats

- Epinamel 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

FOOD APPROVAL

- The film forming components of Epinamel EB600 (factory and Ultratint colours) 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 Valspar Technical Service for advice.

Certified System Quality ISO 9001

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), 166 (Blacktown), 1154 (Glendenning) and 931 (Kilburn).

NATA ACCREDITED FOR TECHNICAL COMPETENCE

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

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