Manufacturers of UTHANE Polyurethane Coatings
14a Williamson Road, Ingleburn NSW 2565
Phone +612 9729-2000 1300 BCC OAT (222 628)
Email: orders@bccoatings.com.au
Text Orders/Enquiries: 0487 800 090

TECHNICAL DATA SHEET

PRODUCT **PE235 WHITE POLYESTER UNDERCOAT**

DESCRIPTION PE235 Polyester Undercoat is a two part high build undercoat for use on very absorbent substrates.
Combined with its excellent sanding properties, it provides a smooth surface for top coating to matt and high gloss finishes.

USED FOR Furniture, various wood substrates (M.D.F., chipboard) and fibreglass.

PROPERTIES

COLOUR	White
SOLVENT RESISTANCE	Very Good
SANDABILITY	Excellent
BUILD	Excellent
SINKBACK	Minimal
WATER RESISTANCE	Very Good
VERTICAL HOLD UP	Good
HARDNESS	Excellent after full cure
LEVELLING & FLOW	Good

TECHNICAL DATA

1. Viscosity Ford 4 Cup at 20°C.	90 ± 5 seconds
2. Solids content Part "A"	94 ± 1%
3. Pot Life at 20 °C	60 - 90 minutes
4. Dust Free at 20 °C	1 hour
5. Touch dry at 20 °C	3 hours
6. Through cure 20 °C	12 - 14 hours
7. Flash Point (mixed)	> 21°C
8. Specific Gravity	1.325

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COVERAGE From 200 to 300 gm / m² for each coat, depending on type of substrate.

THEORETICAL 2.3 square metres / litre at 300 microns.

MIXING RATIO

PE235 Part "A"	1 litre	20 litres
PE230/PE330 Hardener	25 ml.	500 ml.

POT LIFE AT 25 °C 60 - 90 minutes @ 25 °C

APPLICATION METHODS Conventional spray / Pressure Pot.

MINIMUM FLASH OFF TIME 5 minutes

SANDING AND TOP COATING

Allow 10 Hours before Top Coating
MUST BE SANDED before top coating - remove sanding dust.
If more than 24 hours between sanding and top coating, lightly abrade and remove sanding dust.

SHELF LIFE

At 20 ° C - 6 months (sealed in original pack) - Part A
At 20 ° C - 12 months (sealed in original pack) - Part B

PACKAGING

Part A	4 litre	20 litre
Part B	100 ml.	500 ml.

SYSTEM RECOMMENDATIONS

SUBSTRATE	PREPARATION	COATING SEQUENCE	FILM BUILD WET (DRY)
TIMBER M.D.F., PARTICLE BOARD	Sand and remove dust.	1st Coat: PE235 2-Pack White Polyester Undercoat Finish coat: UT900 2-Pack Topcoat or UT100 Series 2-Pack Topcoat or Other suitable lacquer or 2-pack Topcoats.	300 microns 80 - 100 microns (36 - 45 microns) 100 - 120 microns (40 - 50 microns) T.B.A.
FIBREGLASS	Sand and remove dust.	1st Coat: PE235 2-Pack White Polyester Undercoat. 2nd Coat : 2K Auto Primer Finish coat: UT100 Series 2-Pack Topcoat or other suitable 2-K Topcoat.	

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SURFACE PREPARATION

TIMBER / M.D.F. Surface should be dry, clean and free from large gaps or imperfections. An initial sand with 180 grit Fre-cut paper is recommended prior to sealing.

PARTICLE BOARD Remove by blow-off or vacuum all excess dust then apply PE235 Undercoat according to instructions.

FIBREGLASS Surface should be dry, clean and free from large gaps or imperfections. An initial sand with 180 grit or Fre-cut paper followed by wiping with PE100 Thinner is recommended to remove moulding agents & etc.

APPLICATION

MIXING See MIXING RATIO on page 2.

THINNING PE235 Undercoat is designed as a ready for use system, but up to 5% thinners may be required.
If thinning is necessary, PE100 Thinner is recommended.
Use PE105/PE110 thinners for warm to hot conditions.

SPRAYING SUCTION GUN - using 72 - 86 thou orifice
at 300 - 350 kPa (40 - 50 p.s.i.)

For PRESSURE POT applications use 40 - 50 thou orifice with a pressure pot air cap, air pressure of 350 kPa (50 p.s.i.) and a MAXIMUM pot pressure of 45 kPpa (6 p.s.i.).

EQUIPMENT CLEANUP

All equipment should be thoroughly cleaned with PE100 Thinner.

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PRECAUTIONS

Do **NOT** smoke, when using this product

This product is peroxide catalysed and the necessary precautions must be observed when handling this material. REFER TO SDS

GENERAL Freshly mixed material must not be added to material which has been in use for some time.
Rate of cure is dependent upon temperature.
Do not apply this product at temperatures below 10°C or relative humidity above 85%.
Ensure maximum recoat interval is not exceeded otherwise surface must be lightly abraded and then dusted to ensure maximum inter-coat adhesion.
Shelf life is normally 12 months but depends on storage conditions.

DANGEROUS GOODS

Part A - Class 3	UN 1263	PAINT
Part B - Class 5.2	UN 3105	ORGANIC PEROXIDE TYPE D, LIQUID