

TECHNICAL DATA SHEET

PRODUCT **PE060 WHITE POLYESTER UNDERCOAT**

DESCRIPTION PE060 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 gms/m ² for each coat, depending on type of substrate.		
(THEORETICAL)	2.3 square metres / litre at 300 microns.		
MIXING RATIO	PE060 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	25 Kilos
	Part B	100 ml.	500 ml.

SYSTEM RECOMMENDATIONS

<u>SUBSTRATE</u>	<u>PREPARATION</u>	<u>COATING SEQUENCE</u>	<u>FILM BUILD</u> <u>WET (DRY)</u>
TIMBER M.D.F., PARTICLE BOARD	Sand and remove dust	1 st Coat: PE060 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 (wet) 80 - 100 microns (wet) (36 - 45 microns) (dry) 100 - 120 microns (wet) (40 - 50 microns) (dry) T.B.A.
FIBREGLASS	Sand and remove dust	1 st Coat: PE060 2-Pack White Polyester Undercoat 2 nd Coat : 2K Auto Primer Finish coat: UT100 Series 2-Pack Topcoat or other suitable 2-K Topcoat	300 microns (wet) 125 - 150 microns (wet) (70 - 80 microns) (dry) 100 - 120 microns (wet) (40 - 50 microns) (dry)

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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 or Fre-cut paper is recommended prior to sealing.
- PARTICLE BOARD** Remove by blow-off or vacuum all excess dust then apply PE060 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** 30 % thinners is required.
PE100 Thinner is recommended. See Temperature Application Guide for more information. Available at www.bccoatings.com.au.
- 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 kPa (6 p.s.i.).
- EQUIPMENT CLEANUP** All equipment should be thoroughly cleaned with PE100 Thinner.

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PRECAUTIONS

SAFETY

Provide adequate ventilation during use.

Airflow should be adequate to ensure a comfortable working atmosphere.

When spray painting, users should comply with the provisions of the State Spray Painting Regulations.

Where this is not possible, operators must use an air supplied respirator complying with Australian Standards AS1715 and AS1716.

This product is flammable and all sources of ignition (flame, pilot lights, furnaces, spark producing switches & etc.) must be eliminated in, or near, the application area.

Do **NOT** smoke.

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

Avoid contact with skin and eyes.

Wear protective goggles and gloves when handling the material.

In the case of skin contact, remove contaminated clothing and wash skin thoroughly with clean water.

Seek medical attention if eyes are affected by splashes or fumes.

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 3 months but depends on storage conditions.

DANGEROUS GOODS

Part A - Class 3

UN 1263

PAINT HFP

Part B - Class 5.2

UN 3105

ORGANIC PEROXIDE TYPE D, LIQUID

This data sheet is based on information in BC Coatings possession at date of issue.

BC Coatings supplies its products only on condition that the consumer is satisfied as to the performance of the product in meeting his particular requirements.