

TECHNICAL DATA SHEET

PRODUCT PE236 MACHINE WHITE POLYESTER PRIMER

DESCRIPTION PE236 - Machine Polyester Primer is a two (2) part, high build undercoat for use on very absorbent substrates. It has been designed for conventional applications as well as application via Robotic Spraying Machines. Used in conjunction with PE250 Hardener it gives extended Pot Life without sacrificing drying and sanding times.. It provides a similar quality and ease of application to our noted PE230 Polyester Undercoat. Combined with its excellent sanding properties, it provides a smooth surface for finish coats ranging in gloss from matte to full high gloss.

USED FOR Furniture, various wood substrates (M.D.F., chipboard) and fibreglass.
NOT suitable for use on metal substrates.

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 at 25°C	1,500 ± 200 cPs
2. Solids content	80.5 ± 1% by weight
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)	< 0 °C
8. Specific Gravity	1.240 ± 0.010

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

(THEORETICAL) 2.3 square metres / litre at 300 microns.

PE236 - MACHINE WHITE POLYESTER PRIMER

MIXING RATIO - BY WEIGHT - POT SPRAY

PE236 Machine		
Primer - Part "A"	1000 gm	25Kg
PE230/PE330 or PE250 Hardener	16 - 20 gm	400 - 500 gm

Ready for spray for smaller areas and edges.

ADD - to spray larger areas.

PE100 Polyester Thinner	80 - 100 gm	1.6 - 2.0 Kg
PE105 In Hot Weather		

MIXING RATIO - BY VOLUME - POT SPRAY

PE236 Machine Primer		
Primer - Part "A"	1.0 litre	20.0 litres
PE230/PE330 or PE250 Hardener	14 - 18 ml	280 - 360 ml

Ready for spray for smaller areas and edges.

ADD - to spray larger areas.

PE100 Polyester Thinner	100 - 125 ml	2.0 - 2.5 Litres
PE105 In Hot Weather		

Do NOT mix more material than can be comfortably applied during a single spraying session.

Freshly mixed material must not be added to material which has been in use for some time.

Rate of cure is dependent upon ambient temperature and film builds.

Too low a film build will result in retarded drying times.

Do not apply this product at temperatures below 10°C &/or relative humidities above 85%.

Ensure maximum recoat interval is not exceeded otherwise surface must be lightly abraded and then dusted to ensure maximum inter-coat adhesion.

POT LIFE 60 - 90 minutes @ 25 °C

APPLICATION METHODS Conventional spray / Pressure Pot / Robotic Spray Machines

MINIMUM FLASH OFF TIME 5 minutes

SANDING AND TOP COATING

Allow 12 - 14 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 the surface and remove sanding dust.

SHELF LIFE @ 20°C

PE236 MACHINE PRIMER - 12 months (in original sealed containers)

PE230/PE330 & PE250 HARDENER - 6 months (in original sealed containers)

PACKAGING

PE236 -MACHINE PRIMER - 25 Kg Litres Open Top Pails

PE230/PE330 OR PE250 HARDENER - 500 ml Plastic Screwtop Containers

**PE236 MACHINE WHITE POLYESTER PRIMER
SYSTEM RECOMMENDATIONS**

<u>SUBSTRATE</u>	<u>PREPARATION</u>	<u>COATING SEQUENCE</u>	<u>FILM BUILD WET (DRY)</u>
TIMBER, MELAMINE COATED MDF & PARTICLE BOARD	Sand thoroughly and remove dust.	1 st Coat: PE236 White Machine Polyester Primer Finish coat: UT900 2-Pack Topcoat or	300 microns (wet) 80 - 100 microns (wet) (36 - 45 microns) (dry)
RAW M.D.F & PARTICLE BOARD	Sand thoroughly to remove mould release agents & etc, Remove dust. Degrease & let dry thoroughly.	UT100 Series 2-Pack Topcoat or Other suitable 2-Pack Topcoats or lacquer .	100 - 120 microns (wet) (40 - 50 microns) (dry) T.B.A.
FIBREGLASS	Sand and remove dust.	1 st Coat: PE236 White Machine Polyester Primer 2 nd Coat : 2K Auto Primer Finish Coat: UT100 Series 2-Pack Topcoat or other suitable 2-Pack Topcoat.	300 microns (wet) 125 - 150 microns (wet) (70 - 80 microns) (dry) 100 - 120 microns (wet) (40 - 50 microns) (dry)

SURFACE PREPARATION

**TIMBER /
MELAMINE COATED
BOARDS**

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.
Remove sanding dust prior to sealing.
Then apply PE236 -Machine Primer according to instructions.

**RAW PARTICLE
BOARD**

Remove dust by blow-off or vacuum all excess dust.
Surface should be dry, clean and free from imperfections.
Sand thoroughly to remove residual release agents & etc.
Remove dust.
Degrease with PE100 Polyester Thinner and allow to dry.
Then apply PE236 – Machine Primer 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 Polyester Thinner is recommended to remove moulding agents & etc.
Then apply PE236 -Machine Primer according to instructions.

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APPLICATION

MIXING See MIXING RATIOS on page 2.

THINNING No thinner is required for spraying smaller areas and for edging
For larger areas reduce up 10 - 15 % by volume..
PE100 Thinner is recommended.

See Temperature Application Guide for more information.

Available at BC Coatings website - www.bccoatings.com.au.

SPRAYING

SUCTION GUN

Use 1.5 - 2 mm (0.040 - 0.050") spray tip orifice at 300 - 350 kPa (40 - 50 p.s.i.)

PRESSURE POT applications use 1.5 - 2 mm (0.040 - 0.050") spray tip
with a pressure pot air cap, air line pressure of 350 kPa (50 p.s.i.) and
a MAXIMUM pot pressure of 55 kPa (6 p.s.i.)

ROBOTIC MACHINE applications – the parameters of each Robotic Machine may vary
so the pressures and gun set ups need to be individually tested and evaluated. It is
recommended that PE250 Hardener should be used with Robotic Spraying Machines

Ensure efficient application by cleaning spray tips, pump nozzles & etc. at regular intervals to remove build up.

Ensure air supply is free from condensed oil &/or water especially in hot ambient conditions &/or after prolonged spraying sessions.

EQUIPMENT CLEANUP

All equipment should be thoroughly cleaned with PE100 Polyester Thinner or similar.



PE236 - MACHINE WHITE POLYESTER PRIMER

PRECAUTIONS

SAFETY Do NOT smoke.

Avoid contact with skin and eyes.

Further safety information is provided in the relevant Safety Data Sheets for each component.

DANGEROUS GOODS

PE236 UNDERCOAT	Class 3	UN 1263	PAINT
PE230/PE330 HARDENER	Class 5.2	UN 3105	ORGANIC PEROXIDE TYPE D, LIQUID
PE250 HARDENER	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.