

TECHNICAL DATA SHEET

PRODUCT **PE231 LS WHITE POLYESTER UNDERCOAT**

DESCRIPTION PE231 LS Polyester Undercoat is a 3 (three) 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. PE231 LS Polyester Undercoat has been designed to contain less than 10 % by weight styrene monomer unlike conventional high build polyester undercoats which may contain up to 20 % by weight of styrene monomer. This minimizes the odor problem some people find objectionable with higher levels of styrene

For industrial use only in spray areas complying with relevant regulations.

Ensure PE230 Accelerator and PE230/PE330 Hardener are kept **WELL AWAY** from each other as **VIOLENT REACTIONS may occur.**

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
COMPONENTS	3 (Three) All components must be mixed together immediately prior to use.

MIXING RATIO

PE231 WHITE LS NCA UNDERCOAT - PART "A"	-	1000 gm by weight
PE230 POLYESTER ACCELERATOR - PART "C"	-	4.5 gm by weight

Stir thoroughly **BEFORE** adding the PE230/PE330 Hardener otherwise **VIOLENT REACTIONS** may occur.

PE230 / PE330 POLYESTER HARDENER - PART "B"	-	16.7 gm by weight
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POLYESTER THINNER	-	5 - 10 % by volume
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Due to the short pot life of catalysed materials, do NOT mix any more than can be comfortably sprayed in a 15 - 20 minute spraying session.

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TECHNICAL DATA

SOLIDS CONTENT	82 ± 1% (Part "A")
POT LIFE	30 - 60 minutes at 20 °C (when thinned down with PE100 Thinner) this will vary depending on spray equipment, thinner selection and thinner quantity
THINNER SELECTION	Refer to the attached THINNER SELECTION GUIDE
DUST FREE	1 hour at 20 °C
TOUCH DRY	3 hours at 20 °C
THROUGH CURE	12 - 14 hours @ 20 °C
FLASH POINT	< 0 °C
SPECIFIC GRAVITY	1.450
COVERAGE	200 - 300 gms/m ² for each coat, depending on type of substrate.
(THEORETICAL)	2.3 square metres / litre at 300 microns.
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 container) - Part "A"
	At 20 °C - 12 months (sealed in original container) - Part "B"
	At 20 °C - 6 months (sealed in original container) - Part "C"

PACKAGING	Part "A"	21.8 Kg	(20 litre Open Head metal pail)
	Part "B"	580 gm	(500 ml) (Plastic Screw Top bottle)
	Part "C"	440 gm	(500 ml) (Screw Top metal can)
	Part "C"	880 gm	(1 Litre) (Screw Top metal can)

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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: PE231 White LS 3-Pack 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: PE231 White LS 3-Pack 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 PE231 White LS NCA 3K Polyester 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

PE231 White LS NCA 3K Polyester Undercoat is designed as a ready for use system, but 5- 10% thinners may be required. If thinning is necessary, PE100 Thinner is recommended. Refer to the attached THINNER SELECTION GUIDE.

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 55 kPa (6 p.s.i.).

EQUIPMENT CLEANUP

All equipment should be thoroughly cleaned with PE100 Thinner.

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PRECAUTIONS

For industrial use only in spray areas complying with relevant regulations.

Ensure PE400 Accelerator and PE400 Hardener are kept **WELL AWAY** from each other as **VIOLENT REACTIONS** may occur.

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 12 months but depends on storage conditions.

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.