



TECHNICAL DATA SHEET

PRODUCT PE230ES WHITE EASY SAND POLYESTER UNDERCOAT

DESCRIPTION PE230ES Polyester Undercoat is a two part high build undercoat for use on very absorbent substrates.
Combined with its specifically formulated excellent sanding properties, it provides a smooth surface for top coating from matt to 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	4000 ± 300 cps
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)	< 0°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	<table border="0" style="width: 100%;"> <tr> <td>PE230 Part "A"</td> <td style="text-align: center;">1 litre</td> <td style="text-align: right;">20 litres</td> </tr> <tr> <td>PE230/PE330 Hardener</td> <td style="text-align: center;">25 ml.</td> <td style="text-align: right;">500 ml.</td> </tr> </table>	PE230 Part "A"	1 litre	20 litres	PE230/PE330 Hardener	25 ml.	500 ml.
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POT LIFE AT 25 °C	60 - 90 minutes @ 25 °C						
APPLICATION METHODS	Conventional spray / Pressure Pot.						
SANDING AND TOP COATING	<p>Allow 10 Hours before Top Coating at normal temperature & relative humidity 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. For best hold out of full gloss topcoats use 400 grit sandpaper, finishing with 500 as a final sand.</p>						
SHELF LIFE	<p>At 20° C - 6 months (sealed in original pack) - Part A At 20° C - 12 months (sealed in original pack) - Part B</p>						
PACKAGING	<table border="0" style="width: 100%;"> <tr> <td>Part A</td> <td style="text-align: center;">4 litre</td> <td style="text-align: right;">20 litre</td> </tr> <tr> <td>Part B</td> <td></td> <td style="text-align: right;">500 ml.</td> </tr> </table>	Part A	4 litre	20 litre	Part B		500 ml.
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Part B		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: PE230 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: PE230 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
PE230 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.

Under warm conditions (30° C) PE105 Medium Polyester Thinner should be
used.

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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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.

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.