Product Data

BLAKES EPOXY PRIMER UNDERCOAT

MIXED PRODUCT 45551

BASE 45559

CURING AGENT 95360

Description: BLAKES EPOXY PRIMER UNDERCOAT is a two component epoxy high build paint. It forms a hard and tough coating resistant to water and petroleum products.

Recommended use: As a primer below and above the water line on boats made of aluminium, glass fibre reinforced polyester, plywood, steel and ferrocement. Also for protection of keels and rudders.

Availability: Subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Off-white/11630 - Grey/12170 - Blue/30180.
Finish:	Flat
Volume solids, %:	52 ± 8
Theoretical spreading rate:	8.5 micron
Flash point:	25°C/77°F
Specific gravity:	1.3 kg/litre - 10.9 lbs/US gallon
Dry to touch:	3-4 hours at 20°C/68°F 6-8 hours at 10°C/50°F
Fully cured:	7 days at 20°C/68°F 14 days at 10°C/50°F
V.O.C.:	445 g/litre - 3.7 lbs/US gallon

The physical constants stated are nominal data according to the BLAKES Group's approved formulas. They are subject to normal manufacturing tolerances and where stated, being standard deviation according to ISO 3534-1. Further reference is made to "Explanatory Notes" in the BLAKES PAINT MANUAL.

APPLICATION DETAILS:

Mixing ratio for 45551:	Base 45559 : Curing agent 95360 2 : 1 by volume	
Application method.:	Spray	Brush/Roller
Thinner:	BLAKES THINNERS No 5 (5%)	BLAKES THINNERS No 5 (5%)
Pot life:	2 hours (20°C/68°F)	6 hours (20C°/68°F)
Nozzle orifice:	.019"-.023"	
Nozzle pressure:	175 bar/2450 psi	

Cleaning of tools:	BLAKES THINNERS No 5 or BLAKES DEGREASER
Indicated film thickness, dry:	100 micron/4 mils
Indicated film thickness, wet:	200 micron/8 mils
Recoat interval min:	See separate APPLICATION INSTRUCTIONS
Recoat interval max:	See separate APPLICATION INSTRUCTIONS

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult BLAKES PAINTS Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.

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2. BLAKES EPOXY PRIMER UNDERCOAT

SURFACE PREPARATION:	Depends on the type of surface. See separate APPLICATION INSTRUCTIONS.
APPLICATION CONDITIONS:	Apply only where application and curing can proceed at temperatures above -10°C. At the freezing point and below be aware of the risk of ice on the surface, which will hinder the adhesion. The temperature of the paint itself should be 15°C/59°F or above to secure proper application properties. Best result is obtained at temperatures between 15-20°C/59-68°F. The surface must be clean and dry and its temperature must be above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.
SUBSEQUENT COAT:	BLAKES POLYGLOSS. We do not recommend that a two pack epoxy such as EPU is overcoated promptly with a single pack product such as Yacht Enamel or Brilliant Enamel. The EPU should be fully cure for 10 days at 20^{0}C.
REMARKS:	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval. Launching should not take place until the last coat of BLAKES EPOXY PRIMER UNDERCOAT has cured for 1 week at 20°C/68°F, 2 weeks at 10°C/50°F. The first coat of the chosen coating must be applied after the last coat of BLAKES EPOXY PRIMER UNDERCOAT according to the interval given in separate APPLICATION INSTRUCTIONS. If this interval is exceeded, the surface must be sanded and a new thin coat of BLAKES EPOXY PRIMER UNDERCOAT must be applied. Before overcoating after exposure in contaminated environment clean surface thoroughly by high pressure fresh water hosing and allow to dry. **Thinning:** The dilution of paint depends on product use e.g high build primer or a thin undercoat. Thinning adjustment will also be needed for application conditions such as temperature, application, equipment etc. If required EPU can be thinned up to 40% **Film Thickness:** The normal dry film thickness is 60 - 100 microns. It may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoat interval.
NOTE:	**The information given in the Technical Data Sheet is intended for commercial use.**
ISSUED:	JUNE 2004 - 455511630CR002 BLAKES PAINTS