



# Rhinamel<sup>®</sup> Undercoat

2K undercoat for epoxy and polyurethane coatings

7000 - line

## Description

- 2-pack epoxy / polyamide undercoat for use under 2K topcoats

## Properties

- Tough, durable coating
- Strong adhesion to steel and other metals
- Easy sanding
- High corrosion, chemical and abrasion resistance

## Typical Applications

- Steel fabrications
- Timber products

## General Data

- Weather resistance Not recommended as finish coat. Apply Rhinamel<sup>®</sup> or Rhinothane<sup>®</sup> topcoats
- Solvent resistance Good
- Chemical resistance Good
- Abrasion resistance Excellent
- Recommended topcoats Rhinamel<sup>®</sup>, Rhinothane<sup>®</sup> T, Rhinothane<sup>®</sup> AC

## Specifications (at 25°C and 50% relative humidity)

- Resin type..... Epoxy / polyamide
- Mixing ratio..... 3 : 1
- Solids content..... 50% (by volume)
- Typical film thickness (per coat)..... 50 microns (dry)  
100 microns (wet)
- Theoretical coverage..... 10 - 12m<sup>2</sup> / L @ 50 microns dry film thickness
- Touch dry..... 4 - 6 hours
- Hard dry..... 16 hours
- Full cure..... 7 days (will not cure at temperatures below 10°C)
- Recoating..... within 24 hours to ensure good intercoat adhesion
- Pot life..... 4 - 8 hours (depending on temperature and level of thinner added)
- Gloss..... Low sheen
- Colour..... White
- Shelf life..... minimum 12 months (in cool, dry conditions)

## Surface Preparation

- **Steel** surfaces must be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion with a suitable power cleaning tool (e.g. disc sander). Apply Rhinamel<sup>®</sup> Undercoat before flash rusting occurs.
- **Timber** Sand and dust down. Remove all traces of previous coatings. Not recommended for softer timbers, e.g. pine, cedar, etc. Timber should be well seasoned and of less than 10% moisture content prior to coating.

## Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 3:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Allow mixture to stand for 30 minutes in warm conditions, and up to 2 hours in cool conditions, prior to application
- Thin up to 20% with Wagon Paints' T3 Epoxy Thinner (see Application directions), and stir as above

# Rhinamel<sup>®</sup> Undercoat

## Application

- Recommended for application airless or conventional air spray equipment
- Small areas may be coated by brush
  
- **Airless Spray**    nozzle size.....0.33 - 0.38 mm  
                          nozzle pressure.....2800 - 4000 psi    (19 - 27mPa)  
                          volume of thinner.....up to 10%
- **Air Spray**        nozzle size.....1.8 - 2.2 mm  
                          nozzle pressure.....45 - 60 psi (300 - 400kPa)  
                          volume of thinner.....10 - 20%
  
- **No. of Coats**.....Two
- **Cleaning solvent** .....T3 Epoxy Thinner

## Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

**Packaging Group III**      **UN No.** 1263 (Pack A); 1866 (Pack B)

**Pack sizes**            3 litre, 15 litre (Pack A)  
                              1 litre, 5 litre (Pack B)

Authorised:            A. De Mello, Sales Manager

June 2008

These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



**Wagon Paints**

**5 Stephenson Road, Bayswater North, Victoria 3153 Australia**  
**Phone: 61 3 97291344 Fax: 61 3 97202179 Email: sales@wagonpaints.com.au**