

UNDERCOAT PRO

700.670

Description

Two component poly-acrylic undercoat with good adhesion to both epoxy and polyester, such as aged gelcoat, with excellent sanding properties and good opacity. The semi-gloss finish can help accentuate the final surface finish as a show coat.

Use

Fast drying coloured undercoat used before topcoat application, or as a sealer of porous substrates for topcoating. Available in white and grey colours to match light or dark topcoats.

Informations

Finish	Semi-gloss	
Colours	.001 White - .359 Dark grey	
Pack	2,5 l	
Solids by Volume	60 ± 2%	ISO 3233-2
Specific Gravity	1,40 g/cm ³	ISO 2811-1
Flash Point	23 - 55 °C	ISO 3679
VOC	360 g/l	Calculated
Shelf Life	Comp. A 36 months Comp. B 24 months	

Application

SURFACE PREPARATION

All surfaces must be perfectly clean, dry and free of oil and contaminants before application of recommended products. Existing paint/materials must be dry, undamaged and compatible. Sanding sequence should be followed to achieve maximum gloss and image distinction. Avoid skipping more than 100 µm between sanding grade steps. Start with manual sanding/cornering, followed by mechanical sanding with an orbital sander 2,5 mm or 3 mm. Recommended roughness after sanding is 5 - 7µm (Rz). Minimum dry film thickness after sanding is 80µm. After application, Epopoly must be cured before sanding: at 20°C, minimum drying time 3 days, recommended 7 days, allow 14 days of curing for maximum DOI performance. After sanding, maximum 15 days of holding time is recommended to apply Topcoats. If this time is exceeded, re sanding is recommended. Supplied air for surface preparation and cleaning must be dry and clean.

NEW BUILD

Finishing Fillers: uniformly abraded with sandpaper grade P240.

High Build Primers: clean, dry and undamaged compatible primers or undercoats, uniformly abraded with sandpaper grade P220.

Fine Undercoats: clean, dry and undamaged compatible primers or undercoats, uniformly abraded with sandpaper grade P320- P400.

MAINTENANCE

For optimum performance of the topcoat system, a full coat of undercoats Epopoly or Undercoat Pro is recommended.

High Build Primers: clean, dry and undamaged compatible primers or undercoats, uniformly abraded with sandpaper grade P220.



Fine Undercoats: clean, dry and undamaged compatible primers or undercoats, uniformly abraded with sandpaper grade P320- P400.

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700.670

Aged topcoats: clean, dry and compatible topcoats, uniformly abraded with sandpaper grade P320-P400. Testing on a non-critical area should be carried out to test compatibility.

How to Apply

Conventional Spray		Pressure 3,5 bar Nozzle 1,2 – 1,4 mm
Airless		Not recommended

Film Thickness per Coat

DFT	<u>As sealer</u> Recommended: 100 µm Standard application range: 80 - 120 µm <u>As undercoat</u> Recommended: 150 µm Standard application range: 120 - 200 µm
WFT	<u>As sealer</u> Recommended: 170 µm Standard application range: 130 - 200 µm <u>As undercoat</u> Recommended: 250 µm Standard application range: 200 - 330 µm

Additional Application Information

Theoretical spreading rate	Application range at the recommended thickness: 100 µm – 6 m ² /l 150 µm – 4 m ² /l
Thinner	Thinner PRO 698 15-25 % as sealer Thinner PRO 698 15-20 % as undercoat
Mixing ratio by volume	4:1
Mixing ratio by weight	87:13
Pot-life at 20 °C	2 h
Spray viscosity	18" – 25" DIN 4 at 20° C based on use
Notes	

Application notes

Prepare the painting by mixing the components in the correct proportions. It is recommended to mix complete kits to avoid a wrong mixing ratio that may reduce the paint designed protection. If less paint is needed, smaller amount may be prepared in a mixing ratio cup.

Dilute the mixed product, not the components separately.

When used as an undercoat, dilute between 15-20%.

When used as a sealer of porous substrates, dilute between 15-25%

Total thickness per coat to be achieved in 2/3 wet on wet coats. Apply 3 wet on wet coats when using a coloured Undercoat Pro. The physical data of two-component products refer to components that have been already mixed.

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700.670

Compatibility

Previous Coat

Epoxy undercoats and primers, gelcoat, etc.

Proceeding Coat

Topcoats

Drying Time

	10 °C		15 °C		20 °C		30 °C	
	Min	Max	Min	Max	Min	Max	Min	Max
Wet on wet overcoating interval			60'	240'	30'	120'	20'	90'
Sanding			48 h	48 h	24 h	24 h	24 h	24 h
Complete curing			7 days	7 days	7 days	7 days	7 days	7 days

N.B. The drying times and the overcoating intervals increase with higher thickness of the applied film. Always check that the existing painting film is perfectly dry before applying a further product coat. The surface must be superficially sanded if the overcoating interval is exceeded.

Conditions during application

During application and curing:

Ambient temperature: minimum 10°C, maximum 35 °C.

Minimum substrate temperature 10 °C (if during the curing the temperature drops below 10 °C, overcoating will take additional time).

Avoid the formation of condensation, the surface temperature should be at least 3 °C above dew point.

Maximum relative humidity 85%.

Painting area should be well ventilated, during application and drying/curing.

Storage

It is recommended to avoid exposure to air and extreme temperatures. To maximize the shelf life in the can, check that the container is closed during the storage and the temperature is between 5 °C and 35 °C.

Avoid exposure to direct sunlight.

Safety Rules

Comply with the provisions set by the local health and safety at work regulations. Avoid contact with the skin, operate in well-ventilated places and, if in closed areas, use vacuum cleaners, fans and air conveyors. During the application use appropriate PPE - Personal Protections Equipment (masks, gloves, glasses, etc.). Before using, read sections 7-8 of the SDS

INSTRUCTIONS FOR THE DISPOSAL OF THE BIOCIDAL PRODUCTS AND PACKAGING

Empty packaging containing biocidal products: disposal of empty packaging according to the requirements of the waste disposal law, for example by taking them to the recycling centre. Packages containing the unused biocidal product: Dispose of the product not used in accordance with the law of disposal of such waste, for example by taking it to a recycling centre, recycling of packaging is prohibited in this case. Do not empty into drains or watercourses.

INSTRUCTIONS FOR THE SAFETY SECURITY OF THE BIOCIDAL PRODUCTS AND PACKAGING

Empty containers and containers still containing the biocidal product: Packaging must be disposed of as hazardous waste under the full responsibility of the holder of such waste. Do not empty into drains or watercourses.

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700.670



Disclaimer

The values indicated in the present technical sheet can have slight variations from one batch to another. The applied product must not come in contact with water, chemicals or subjected to mechanical stress before the curing is complete. The wet film thickness refers to the undiluted product. In case of dilution, this value increases. The above information is the result of accurate laboratory tests and practical experience, however, since the product is predominantly used outside the manufacturer's control, Boero Bartolomeo S.p.A. can only guarantee their quality. The information contained in this sheet may be subject to revision by the Company. For clarification, updates or further information, it is recommended to contact Boero Bartolomeo S.p.A. directly. The present datasheet annuls and replaces every other precedent to this one.