



DESCRIPTION

- an ultra-premium, pigmented two-pack polyurethane undercoat for interior timber

PRINCIPAL CHARACTERISTICS

- a high build product, offering fast set-up, free sanding and good hold-out on raw MDF edges
- resistant to edge rub throughs when sanded, resists sagging on sharp edges and provides a sound base for optimum hold-out of polyurethane topcoats
- suitable for use on open-grained timbers, particle-board, MDF, Melamine etc.
- designed specifically for use under Spectrothane and Colourthane topcoats

Note: We advise that you test this product to determine if it is suitable for your particular use.

COLOUR AND GLOSS

- white, low gloss

BASIC DATA AT 25° C and 50% RELATIVE HUMIDITY

- mix ratio 2A:1B by volume
- dust free 5-10 minutes
- touch-dry 15-20 minutes
- sandable 3 hours
- recoat 4 hours - better hold out is obtained if the film is left to cure for between 24 and 72 hours
- practical spreading rate 8-10 m²/L
- shelf life (cool, dry place) at least 12 months in unopened container

SURFACE PREPARATION

- all surfaces must be free from wax, silicone, oil and other contaminants
- fill holes and minor imperfections with WattyI Full Stop Timber Putty
- sand smooth with 180-240 grade fre-cut paper, and remove all sanding dust

INSTRUCTIONS FOR USE

- mixing ratio by volume: 2A : 1B
- induction time- 5 minutes, mix again after this time
- potlife at 25°C- 3-5 hours; at 35°C- 1-2 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- apply two to three passes by spray. Best results are obtained by using a medium fan-setting, and applying medium to wet coats allowing to "flash off" for 3-5 minutes between coats
- may be overcoated after 4 hours
- better hold out and quality of finish will be achieved if overcoating is performed between 24 and 72 hours
- must be sanded if overcoating after 24 hours
- sand with 320-400 grade fre-cut paper, remove all sanding dust
- maximum topcoat adhesion is obtained by overcoating within 72 hours
- finish with Spectrothane or Colourthane topcoats
- do not apply or attempt to cure at temperatures below 10°C
- relative humidity should not exceed 75% during application and before the dry to handle time
- **Warning:** Excessive builds on timber can lead to stress-cracking as the timber adjusts to its new conditions of temperature and moisture content. The recommended maximum total build is 150 microns (dry film) for the total system.
- for recommendations outside those contained in this data sheet, refer to WattyI



SPECTROTHANE[®] UNDERCOAT TM6.80

APPLICATION

- **CONVENTIONAL SPRAY**
 - recommended thinner Spectrothane Undercoat Thinner
 - volume of thinner up to 20%
 - fluid nozzle 1.5 - 2.0 mm
 - pressure to the gun..... 250 - 350 kPa (30 - 50 psi)

- **AIR-ASSISTED AIRLESS SPRAY**
 - recommended thinner Spectrothane Undercoat Thinner
 - volume of thinner up to 10%
 - fluid nozzle 0.23 - 0.28 mm (0.009- 0.11inch)
 - pump ratio 12 - 20 : 1
 - pump pressure 7 - 10 MPa (1000 - 1500 psi)

- **HVLP CONVENTIONAL**
 - recommended thinner Spectrothane Undercoat Thinner
 - volume of thinner up to 10%
 - fluid nozzle 1.5 - 2.0 mm
 - pressure to the gun..... 250 - 350 kPa (30 - 50 psi)
 - pressure to air cap 70 kPa (10 psi)

- **CLEANING SOLVENT** Industrial Universal Thinner or Spectrothane Undercoat Thinner

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- contains 0.05% monomeric diisocyanate when mixed. Provide adequate ventilation during use. Breathing the vapour is dangerous. Avoid prolonged breathing of fumes. Where ventilation is poor or where applied by spray, use suitable respiratory equipment at all times
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

PACKAGING

Part A 4 litres, 20 litres

Part B 1 litre

For the most up to date information contact Watty! Customer Service Hotline or visit the Watty! Website.

CUSTOMER SERVICE HOTLINE	Australia 132 101	New Zealand 0800 735 551
WEBSITE	http://www.watty! .com.au	http://www.watty! .co.nz

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