

# UNDERCOAT EP 215 HB

**EPOXY POLYAMINO-AMIDE TWO COMPONENT COATING.**  
**High build intercoat or finishing.**  
**Can be applied with high thickness**

**PRIMER**  
**Two component**

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## FEATURES

**UNDERCOAT EP 213 HB** Can be applied with high thickness.

**UNDERCOAT EP 213 HB** ensure an excellent protection and insulation of epoxy under and above the waterline.

Excellent chemical and physical properties.

Excellent resistance :

- to dry heat
- in immersion
- to solvents

Good spreading rate

Easy to sand

**UNDERCOAT EP 213 HB** can be applied in 2 crossed coats wet on wet.

## RECOMMENDED USES

Bonding primer on :

- gelcoat polyester, vynilester, epoxy
- all composites

Application :

- 2 or 3 coats as sandable filler
- on composite and filler insulation
- on microporous gelcoats
- chemical reinforcement of primers
- good antifouling intercoat (if compatibility with epoxy)
- recoat by itself , no sanding required

**UNDERCOAT EP 213 HB** is compatible with primer EPZ 210, EP 211, EP 140, systems EPOXYGUARD 455, filler MIX FILL , SPRAYABLE FILLER 500/700, systems EP 215 HB, EP 200 and accept systems PU 228, EPU 221, PU 77, PU 99 and TOPCOAT COLOR 320.

## SPECIFICATION DATA

**COATING TYPE:** Epoxy polyamide undercoat-

**COLOR :** White

**GLOSS:** Semi-gloss

**COMPONENT:** Two component

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**COMPONENT RATIO :**

- Weight : 100 Base / 15 Hardener
- Volume : 4 Base / 1 Hardener

**INDUCTION TIME** (at 20°C) :

15 minutes with standard hardener  
10 minutes with fast hardener

**POT LIFE** (à 20°C) :

6 hours with standard hardener  
2 hours with fast hardener

**THINNER:** EP N° 3

**DENSITY AT 23°C :** 1,46 approx.

**VOLUME SOLIDS :** 51 +/-3 %

**VOC :** 424 g/l

**THEORETICAL SPREADING RATE :**

5 Sq.m/L at 100 dry microns

**RECOMMENDED FILM THICKNESS PER COAT :**

Dry: 100 à 130 microns

Wet: 175 à 230 microns

**DRY TIME** (at 23°C – 50 to 60 % HR) :

dustfree: 1 h with standard hardener  
30 minutes with fast hardener  
to handle: 4 h with standard hardener  
1h30 with fast hardener  
to sand: 24 h with standard hardener  
15h with fast hardener

**DRY TIME TO RECOAT** (at 23°C – 40 to 60 % HR) :

Minimum: 6 h with standard hardener

3 h with fast hardener

Maximum: 3 months with standard hardener

6 days with fast hardener

**MAXIMUM TEMPERATURE RESISTANCE :** 100°C

## SURFACE PREPARATION

All surfaces to be coated must be free of grease, dust, water marks, moisture and other foreign matter and must be properly primed with a compatible epoxy primer. To insure the best appearance, the primer or undercoat should be smooth and free of any surface defects such as runs, dry spray or heavy orange peel.

UNDERCOAT EP 215 HB must be applied on compatible primer.

UNDERCOAT EP 215 HB is compatible with primers AEROPRIM 140 et WOOD IMPREG 120, and it can be recoated by systems PORE FILLER PU 228 HB, EPU 221, AEROXYGLASS 560, PU 77, PU 99, TOPCOAT COLOR PU 320, before MPO 500 and majority of Antifouling.

For all other types of coating, contact our technical department

## MIXING AND THINNING

Before mixing components, mix carefully the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion, add the hardener slowly with continued agitation. After adding the hardener, continue to mix slowly.

After 30 minutes of induction time, it's possible to diluate from 0 to 20 % of EP N°3 (depends on application condition or method). You must check the viscosity.

Spray gun application : check the viscosity every 2 hours. Don't forget to mix after every dilution.

## APPLICATIONS

APPLICATION METHOD		THINNER	TIP SIZES	PRESSURE
BRUSH	YES (spot finishing)	0 to 10%	1,5 to 2,2 0,019 to 0,021 mm (30 to 60°)	2 to 5 BARS 250 BARS
ROLLER	YES (medium hair)	0 to 10%		
SPRAY GUN	YES	5 to 20%		
AIRLESS SPRAY	YES	2 to 5%		

### CONDITIONS FOR APPLICATION :

Optimum : 20 to 25 °C for 50 to 70 % HR

Limit : 15 to 35°C for 30 to 80 % HR

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The substrate temperature must be at least 3°C above the dew point to avoid any condensation - consult the conversion table available at Map Yachting.

**VISCOSITY** : 18 s to 22 s Cup AFNOR n°4

## PRECAUTIONS AND SHELF LIFE

See the material safety data sheet and product label for complete safety and precaution requirements

**PACKAGING** : KIT 2,5 or 5 Liters

**CLASS ONU** : 1263

**SHELF LIFE** : 12 months in original unopened cans at + 10 and + 25 °C away from humidity - 9 months in tropical climate

**FLASH POINT** : **Base and fast hardener** = between 23 to 55°C **Standard hardener** = <+21°C

**LABEL** : **Base** = Xi : Irritant **Hardener** = F : Highly Flammable **Xi** : Irritant



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