TOPKOTE

Product Data Sheet

# NuCharge It Low VOC Epoxy

## 215 series

## PRODUCT DESCRIPTION

**Type**

Electrostatically applied two component polyamide epoxy

**Description**

**NuCharge It Electrostatic Low VOC Epoxy** is a two-component, high performance epoxy designed for interior usage on all metals where durability is required. It provides a finish comparable to factory baked finishes when cured.

**Uses**

- Office furniture
- Restroom partitions
- Medical equipment
- Machinery and other uses

**Features**

- Gloss, semi-gloss, and satin finishes available
- Custom color bases including metallic and mica
- Fast drying
- V.O.C. less than 2.8 lbs. / gal.
- Long pot life
- Can be used direct to metal applications

## SUBSTRATE & SURFACE PREPARATION

**All**

Substrate must be clean, dry and free of contaminants.

**Steel & Iron**

The minimum surface preparation for steel and iron is Hand Tool Cleaning per SSPC-SP2. Power Tool Cleaning per SSPC-SP3 is preferred for better performance. Prior to either procedure, the surface should be solvent cleaned per SSPC-SP1. Feathering around scratches is recommended because certain surfaces may lift when coated. A quick test should be conducted in an inconspicuous area to determine if a base coat should be removed or primed.

**Primer**

Use as is. If extra corrosion protection is desired, then use NuCharge It Low VOC Epoxy Primer 214D7185B.

## MIXING & THINNING

**Ratio**

2 – components. Mix components A & B at a 1:1 ratio. Allow a 20-minute induction time after mixing before use. Three hardeners are available. 215X2222A (Gloss), 214X4444A (semi-gloss), 213X6666A (satin).

**Mixing**

Mix the base and hardener components thoroughly before use by boxing or with mechanical agitation.

**Thinning**

Thinning is not normally needed. Add **560X1557 NuCharge It VOC Exempt Reducer** as required. Add 3-4 ounces of **480X9999 Roll-A-Glaze** per mixed gallon to reduce dry spray and orange peel, if required. **480X9999 Roll-A-Glaze** can be added to help add a wet edge for spraying large parts and to aid in brush and roll applications.

**Pot Life**

6 hours sprayable, usable to 12 hours @ 70°F.

**Cleanup**

Use NuCharge It Reducer (560X2005).

## APPLICATION GUIDANCE

**Application Conditions**

Excessive film or surface contamination may cause adhesion problems and solvent entrapment. DO NOT USE IN HEATED AIRLESS EQUIPMENT, as gelling will occur.

**Brush**

Brush application in small areas

**Roller**

Short nap or mohair phenolic core roller

**Spray**

This product may be applied by electrostatic, conventional, HVLP, and airless equipment. Dry times can be accelerated by using **NuCharge It Epoxy Accelerator 480X4530.**

## CURE TIME & RECOAT WINDOW

| Substrate Temperature | To Touch | Tack Fee | To Recoat | Full Cure |
|---|---|---|---|---|
| 75°F (24°C) | 30 minutes | 1 hour | 2 hours | 7 days |

Drying times are dependent upon film thickness, temperature and humidity.

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## PACKAGING, ESTIMATING & HANDLING

| Product | Code | Packaging |
|---|---|---|
| NuCharge It Low VOC Epoxy | 215 series | 1-gallon pails fully filled. Tint bases are short filled. |

**Theoretical Coverage**

350-700 ft$^2$ / catalyzed gallon @ 1.0 – 2.0 mils dry film thickness.

**Storage & Shelf Life**

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.

**Safety**

Mixes and applications of this product present several hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

**Ventilation**

Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

## TYPICAL PHYSICAL PROPERTIES

| Property | Typical Value |
|---|---|
| *Specific properties below are of **215T1000 Gloss White*** | |
| Colors | Full range |
| Gloss | • High Gloss 85+ units, use hardener **215X2222A**<br>• Semi-gloss 45-55 units, use hardener **214X4444A**<br>• Satin 20-25 units, use hardener **213X6666A** |
| Pot Life | Sprayable to 6 hours, usable to 12 hours |
| Volume Solids | 44% |
| Viscosity | 15-20" Zahn 3 |
| Recommended DFT | 350-700 ft$^2$ / catalyzed gallon @ 1.0 – 2.0 mils dry film thickness. |
| Flash Point | Mixed 64°F |
| VOC | <2.8 lbs. / gal. (334 g/L) |
| Weight / gallon | 12.2 lb./gal. base component |
| Temperature Resistance | 250°F |
| Shelf Life | 2 years unopened and unactivated |

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