



WHITECOTE

Application Information

Warning: Please read and understand these instructions thoroughly - failure to do so can result in premature coating failure and/or a big mess!

NOTE: Whitecote and its hardener will absorb moisture if the cans are left open and the adhesion properties are greatly reduced.

PRODUCT DESCRIPTION

Whitecote is a high gloss rock hard, extremely durable, white coloured topcoat that can be applied over a number of surfaces; including heavy duty vehicle chassis and trailers, floor pans and agricultural machinery; and many marine applications as well, including motors, heat exchangers, pumps, masts, decks and hand rails. Whitecote coatings can also be used to protect equipment from strong acids, alkali and other aggressive materials. Whitecote will not leave brush marks, and will dry in less than 1 hour, but will take 3 or 4 days to reach maximum hardness. When Whitecote is first dry to the touch, it will appear very soft. Avoid touching it for several days until becomes hard and tough. Accidental contact could damage the surface before full cure has taken place. Like many other POR 15 coatings, Whitecote is a moisture cured coating, which means it is strengthened by exposure to moisture.

PRODUCT COMPOSITION

Your Whitecote purchase consists of two items: 1) a paint can, labelled Whitecote which is the basic resin formulation; and 2) a smaller can, labelled Hardener/Activator. Mix the two products together by blending the two products together in a separate, resealable clean container, a clean glass jar works best. Stir the combined contents thoroughly. After the coating is thoroughly mixed, wait one hour before using it. This will give the two components time to blend and the molecules to link together properly.

Waiting for one hour after mixing is very important; do not ignore this instruction.

Warning: Your can of Hardener/Activator is sealed tightly. Remove lid carefully, cover with a paper towel while prying it off to avoid accidental spillage or splash. Your Hardener/Activator is very sensitive to moisture and humidity, so try to open it in a dry area. Keep it tightly capped when not in use.

PARTIAL MIXES

You may mix partial quantities of Whitecote for small jobs, and you may use any measuring device you happen to have around (coffee scoop, measuring spoons, cups etc.). All you have to do is follow this formula:

Mix 1 part Hardener/Activator with 4 parts Whitecote

Allow to sit for an hour before painting. Whitecote has a long pot life, up to 8 hours, if the lid is kept on the mixed batch when not in use.

SURFACE PREPARATION

Will depend on the type of surface you are overcoating and the finish you are looking for.

Enamel Baths:

Roughen surface with a 600 grit sand paper, clean with a diluted 50:50 Marine Clean. Apply a thin coat of TieCoat or Self Etching Primer. Allow at least 24 hours to cure or longer if the temperature is below 18 degrees centigrade.

Overcoating existing primers.

Whitecote can be overcoated on both single and 2 Pak primers. Clean surface with Marine Clean (ratio of 8 parts water to 1 part Marine Clean) for light contamination. Rinse with clean water, allow to dry. Key with 240 grit paper. Tack wipe with dry tack cloth and paint. Apply 2 coats of Whitecote.

Painting over cured POR 15 Rust Preventive Paint.

Clean with Marine Clean (ratio of 8 parts water to 1 part Marine Clean) for light contamination. Key with 300 grit then apply one light coat of Tiecoat, thin approx. 10%. Allow to cure for 1 - 2 days (longer in cooler temperatures). Sand with 300 grit tack wipe with dry cloth and apply 2 coats of Whitecote as final finish.

As a complete POR 15 paint system.

Apply two coats of POR 15 Rust Preventive Paint over a sandblasted surface or a surface prepared with Marine Clean and Metal Ready. Then apply one light coat of TieCoat or Self Etching Primer as soon as POR 15 Rust Preventive Paint has cured (24hrs) to ensure maximum adhesion. Allow to cure for 2 to 3 days, at 20°C lightly sand with 300 grit. Wipe down with dry tack cloth and apply 2 coats of Whitecote if necessary.



APPLICATION

Apply a minimum of 2 full coats for general automotive use, and a minimum of 3 full coats marine use, plus a dust or tack coat if spraying. Whitecote may be applied with any type of brush you prefer. It can also be rolled. It will flow out immediately, eliminating brush marks. Lay down a covering coat, but be careful to avoid runs. A second coat may be applied when touch dry, usually 15 - 25 minutes later at 20°C, though the second coat may be left up to 2 days before recoating without sanding, best method, recoat at 2 - 3 hourly intervals. In temperatures below 18°C drying times will be extended and consequentially runs maybe more likely, to minimise this in colder temperatures small items can be warmed with a heat gun, or air temperature raised for larger items, do not over heat items above 24°C.

THINNING: Thin only with POR 15 Solvent, if required. POR 15 Solvent or lacquer thinners may be used for clean up. You can thin up to 20%, though you will need more coats to retain dry film thickness,

Note, when applying, by brush, a second or third coat there can be lot of surface tension between coats some solvent maybe needed to be added to reduce the coating surface tension to allow it to drop and flow out. For best results apply in 18-24°C and less than 70% humidity.

Spray Painting / Spray Booths - Whitecote prefers low pressure application.

Syphon or Pot Gun application use approx. 25 psi (180 kpa).

HV or top container gun use approx. 15 - 18 psi (120 kpa).

At 16-22°C thin 10 to 20%. At 22 -28°C thin 20 to 30%.

Avoid temperatures over 28°C were possible.

Spray Booth, best temperature 22°C, 50% humidity, low air flow.

Remember thinning rates are a guide only, consider also the type of gun, air temperature and humidity.

Whitecote can be cut with regular compounds if you have a run or imperfections, though it is best if you leave it for a week or 2 before cutting to make sure coating is hard (runs may take longer to fully cure due to added thickness).

Humidity Control when spraying Whitecote.

Humidity should be 60% or lower when spraying Whitecote because the higher humidity may cause it to set up too quickly before it has a chance to flow out evenly, thus resulting in a wavy appearance. This is especially true in high-humidity northern climates in summertime. Whenever possible, spray in a humidity-controlled (air conditioned) environment. Best temperature 18 – 24 C. If this is not possible apply Whitecote in the morning when temperatures are at their lowest. Whitecote can be applied successfully in higher humidity, but temperatures must be below 25 C. In temperatures over 30 C the humidity must be low. Avoid high humidity and high temperatures.

Curing

Remember Whitecote will not perform as specified until it has cured for a minimum of 4 days, at an average temperature of no less than 18°C, eg. Do not put engine parts and the like into service before the 4 day cure time. Elevated temperatures will not speed up cure.

Cutting

Whitecote can be cut with regular compounds if you have a run or imperfections, though it is best if you leave for a week or 2 before cutting to make sure coating is hard (runs may take longer to fully cure due to added thickness)

QUESTIONS AND ANSWERS?

Can I apply Whitecote straight over metal?

Yes, you can but you won't get the same adhesion or leveling as you do with Rust Preventive Paint as a prime.

Can I apply Whitecote straight over POR 15 Rust Preventive Paint with out Tie-Coat?

Yes, you can but, because of the smooth and shiny nature of POR 15 Rust Preventive Paint you can get the colour bleeding through, especially on edges and corners; runs are also more likely.

Why only thin coats of TieCoat?

Because Tie-Coat is an inter-medial coating - the thinner it is, the more impact resistance the coat will have.

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