Cladcote 515 HS

fast dry epoxy

Cladcote 515 HS is a high performance epoxy intermediate/base coat which forms an excellent corrosion barrier. Fast dry characteristics are especially beneficial where early handling of coated items or same day application of multi-coat systems is required. Excellent low temperature cure properties allow use of the product over winter when application of conventional epoxy cure based systems is not possible. Suitable for use in most industrial and marine environments.

Formulated for spray application.

Physical properties

Vehicle type	Two component epoxy
Hardener	Modified amine
Pigmentation	Aromatic/ketone/alcohol
Mix ratio	4:1 (by volume)
Pot life	3 hours at 20°C; 6 hours at 10°C
Finish	Low gloss
Colour	Off-white, pastels and micaceous grey
Dry time (minimum)	Touch dry: 45 minutes at 20°C; 90 minutes at 10°C Dry to handle: 2½ hours at 20°C; 5 hours at 10°C Full physical properties: 12 hours (minimum) at 20°C; 24 hours (minimum) at 10°C. Drying is affected by low temperatures and high humidity
Recoat time (minimum)	2½ hours at 20ºC (by spray); 5 hours at 10ºC (by spray). Maximum: 7 days (self); 2 days (Uracryl 400 Series, Imperite I.F. 503, Imperite 413). Sanding of Cladcote 515 HS is required if recoating beyond these times
Primer required	Yes, dependent upon substrate and service conditions (compatible zinc rich primers include Zincilates, CladZincs, inhibitive epoxy primer Cladcote 220 or 221)
Theoretical coverage	7 sq. metres per litre (100 microns DFT) 4.7 sq. metres per litre (150 microns DFT)
Volume solids	70% (calculated)
Recommended DFT	100-150 microns per coat
Usual no. of coats	1-2
Dry heat resistance	90ºC (continuous, some discolouration may occur after prolonged continuous heat exposure)
Solvent resistance	Excellent (splash and spillage, specific resistance dependent on chemical and topcoat)
Thinning and clean up	Thin with Thinner No.12 (general use) or Thinner No.11 (over zinc rich primers or for application temperatures in excess of 35ºC). Clean up with Thinner No.12 4 and
Pack Size	20 litre composite
VOC	270 grams per litre (mixed, unthinned)

Typical uses

- Aluminium
- Concrete
- Galvanised steel
- Marine/industrial use
- Repaints
- Steel (primed)

Performance and limitations

Performance

1. Fast dry, high build.
2. Positive cure down to 0ºC.
3. Excellent adhesion to a wide range of substrates and zinc rich or epoxy primers.
4. Early topcoating potential.
5. Suitable for immersion in fresh or salt water.
6. Basecoat for a wide range of high performance topcoats.

Limitations

1. Do not apply over thermoplastic or chlorinated rubber based coatings.
2. Applied coating is susceptible to mechanical damage before cure to full physical properties has occurred.
3. Contact manufacturer for details concerning cure times prior to use in immersion applications.
4. Brush and roller application not recommended except for small areas or minor touch-up.

Please ensure the current Data Sheet and Safety Data Sheet are consulted prior to specification or application of product. If in doubt contact .