

Instruction for use

High Performance Clear Coatings

UNIGRIP
DANTECH ELITE COMPOSITES

Surface Preparation recommendations.

Surface preparations must always be in compliance with clients specifications or job requirements.

1. Commonly used standards for surface preparations:

Recommended:

- SSPC-SP 10/NACE No. 2. ISO 85011-1:1988 (E) (SIS 05 59 00) Sa 2 1/2

Alternative:

- SSPC-SP 11 - Power Tool Cleaning to Bare Metal
2. Clean and degrease all surfaces, including cut-outs, rat holes and welds shall be rounded to a radius of at least 2 mm, weld splatter removed.
 3. Weld seams burned, and rusty areas blast cleaned to min ISO-Sa 2½ or power tool cleaned to min SPSS-Pt3 prior Grit Blasting
 4. Rough to an angular profile between 75 – 100 microns (in accordance with ISO 8503 parts 1 and 2)
 5. Abrasive blasting to a cleanliness of white metal (Sa3/SP5) or near-white metal (Sa 2½ /SP10) followed by removal of all abrasive residues.
 6. The purity of the sandblasting is visual checked.
 7. Bresle Sampler test for measuring soluble salts / chlorides in the steel surface (ISO 8502-6) limit value <20 mg / m2.
 8. Distance to Dew Point of minimum 3 degrees Celsius throughout the application process.
 9. Brush away any loose contamination Degrease with Item 903 UNIGRIP Bio cleaner (Cleaner Degreaser) or any other effective cleaner which does not leave a residue e.g., methyl ethyl ketone (MEK).

Application:

Brush, roller, air-spray or airless-spray

- Transparent-Gloss:
 - Processing Brush/roller 15 - 20% water
- Transparent-Semi Gloss:
 - Processing Brush/roller 10 - 15% water
- Transparent-Matt:
 - Processing Brush/roller 15 - 20% water

Spraying:	Air-spray	Airless-spray
Pressure 1.0 1.5 mm	0.3 0.4 mPa (3-4 atm.)	8 10 mPa (80 -100 atm.)
Opening	1.0 1.5 mm	0.23 mm (0.009 inch)
Dilution	20 25% water	20% water

Application Temperature 5 - 35°C

Remark: The application of two component products should happen at a relative humidity between 40 & 85% in an ambient and substrate temperature higher than 5 degrees centigrade; the temperature of the substrate has to be 3 degrees centigrade above dew point. The maximum strength and resistance of the applied system is reached after sufficient curing This corresponds with a drying period of 7 days at 20 degrees centigrade or so much shorter or longer corresponding to a higher or lower curing temperature

Mixing instructions

Add component B to component A. Mix intensive and mechanically till homogenous. Thereafter add water to get to the ideal viscosity for the application (see chart above).

Best result: please consult technical data sheet - section: "For best result"

Substrate:

- General compatible with Epoxy and PU primers & coatings.

Substrate conditions

- The substrate must be clean, dry, grease & dust-free and comply with the normal applicable conditions and requirements
- Overcoating Epoxies and PU's (based on intervals as stated in the PDS's "Over-coating Intervals")

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Drying time (20°C / 65% R.H.)

-Wet in Wet applications
-Dust-free:
-Re-Coatable¹⁾:
-Light traffic

- After approx. 60-75 min (Allow approx. 60-75 minutes between layers before applying the next layer)
 - After approx. 3 hours
 - After approx. 60-75 min
 - After approx. 7 hours
- 1) PU Topcoats-Ensure the epoxy primer is fully cured according to the manufacturer's specified curing time

Over-coating epoxies / intervals

Estimates "only" for the over-coating interval (without sanding) using a common curing heuristic

20 °C (68 °F) → 16–24 hrs. / 65% RH

- 25 °C (77 °F): ≈ 11.5–17.0 hrs
- 30 °C (86 °F): ≈ 8.0–12.0 hrs
- 35 °C (95 °F): ≈ 5.5–8.5 hrs

20 °C (68 °F) → 18–26 hrs. / 80% RH

- 25 °C (77 °F): ≈ 13.0–20.0 hrs
- 30 °C (86 °F): ≈ 9.0–14.0 hrs
- 35 °C (95 °F): ≈ 6.5–10.0 hrs

Notes: These are practical estimates; actual windows depend on resin/hardener, film build, airflow, and substrate temperature. Always follow your product TDS (including max recoat window) and keep the surface ≥ 3 °C (~5 °F) above dew point.

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