

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	<ul style="list-style-type: none"> • Office furniture • Restroom partitions • Medical equipment • Machinery and other uses
Features	<ul style="list-style-type: none"> • 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 Free	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
<i>Specific properties below are of 215T1000 Gloss White</i>	
Colors	Full range
Gloss	<ul style="list-style-type: none">• High Gloss 85+ units, use hardener 215X2222A• Semi-gloss 45-55 units, use hardener 214X4444A• 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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