



# 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 Paint is a high-gloss extremely durable 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. It can be applied over existing single and two-component primers. Whitecote coatings will not leave brush marks and will dry in less than an hour but will take 3 or 4 days to fully cure. It 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.
  - 2) A smaller can, labelled Hardener/Activator.
- Mix the two products together by blending in a separate, resealable clean container, a clean glass jar works best. Stir the combined contents thoroughly. Allow to sit for an hour. This will give the two components time to blend and the molecules to link together properly.

**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 spoon, 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 Paint has a long pot life, up to 8 hours, if the lid is kept on the mixed batch when it is not in use.

### SURFACE PREPARATION

Will depend on the type of surface you are over coating 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 Tie-Coat or Acid 8.
- Allow at least 24 hours to cure or longer if the temperature is below 18 degrees centigrade.

#### **Over coating existing primers.**

- Whitecote can be over coated on both single and 2 pack primers.
- Key with 240 grit paper. 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.
- 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,
- Allow to cure for 1 - 2 days (longer in cooler temperatures).
- Sand with 300 grit if needed, tack wipe if necessary 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 Tie-Coat or Acid 8 as soon as POR 15 Rust Preventive Paint has cured (24hrs) to ensure maximum adhesion. Allow the Tie-coat to cure for a min 24 hours up to 2 to 3 days at 20°C (68°F).
- Lightly sand with 300 grit if needed.
- Wipe down with dry tack cloth and apply 2 coats of Whitecote if necessary.

### APPLICATION

#### **Number of Coats:**

- Minimum of 2 full coats for General Automotive use.
- Minimum of 3 full coats for Marine Use.
- Plus a dust or tack coat if spraying.

#### **Brushing / Rolling:**

- Whitecote may be applied with any type of brush you prefer. It will flow out immediately, eliminating brush marks. It can also be rolled.
- Lay down a covering coat, but be careful to avoid runs.

#### **Second Coat:**

- 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 can have a lot of surface tension between coats, some solvent maybe needed to be added to reduce the tension to allow it to drop and flow out. For best results apply in 18-24°C and less than 70% humidity.

## Spray Painting

*Note: it is illegal to spray a two pack paint in Australia without a spray booth)*

- Whitecote prefers low pressure application.
- Syphon or Pot Gun application use approx. 25 psi (180 kpa).
- HVLP 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%.
- Remember thinning rates are a guide only, consider also the type of gun, air temperature and humidity.
- Avoid temperatures over 28°C were possible.

## Spray Booth:

- Best temperature 22°C, 50% humidity, low air flow.

## Humidity Control when spraying Whitecote.

- Humidity should be 60% or lower when spraying Whitecote because the higher humidity may cause it to set 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°C- 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.
- 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 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).

## 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 primer.

### Can I apply Whitecote straight over POR 15 Rust Preventive Paint without 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 Tie-Coat?

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

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