



No.

# UNDERCOAT 215HB +

UNDERCOAT  
Two-component

July 2020 edition

**TWO-COMPONENT EPOXY COATING  
ANTI-CORROSION POLYAMINO-AMIDE.**  
Intermediate or "High Build" finish Applicable in  
very thick.

## PROPRIETES

**THE UNDERCOAT 215HB +** is an anti-corrosion epoxy polyaminoamide system applicable in very thick. It combines the chemical resistance performance of polyamines and the tolerance of polyamide coatings.

**THE UNDERCOAT 215HB +** provides an excellent chemical barrier as an intermediate sub-layer between plasters and lacquers and ensures good stabilization of bases.

**THE UNDERCOAT 215HB +** ensures excellent chemical resistance of primers on the live works of ships.

Excellent resistance:

- in dry heat (100 ° C continuously)
- immersion in fresh water and sea water
- to most solvents and greases
- Excellent covering performance and filling power
  
- Very easy to sand
- Excellent film quality and fineness after sanding

Possible application of a wet film up to 250 µm in 1 coat or 2 crossed coats wet on wet.

## UTILISATION

**THE UNDERCOAT 215HB +** ideally suited for the treatment and anti-corrosion protection of:

- Steel or aluminum hulls and hulls.
- On metals it can be applied directly after abrasive stripping (SA 2.5 Minimum - SA 3 recommended).

Application as an adhesion primer on:

- Polyester gelcoat, Vynilester, epoxy
- All composites

Application :

- In 2 or 3 coats as a sandable primer
- On composites and insulation of epoxy plasters and mastics
  
- On earthenware or microporous gelcoats
  
- Chemical reinforcement of intermediate primers
- membership of Antifouling (if compatible with epoxy)
- Covering with epoxy plasters, without sanding between coats if the recovery times are respected.

## CARACTERISTIQUES

**TYPE OF PRODUCT :** Anticorrosive polyamide epoxy undercoat

**COLOR :** White

**ASPECT :** Satin

**PRESENTATION :** Two-component

**MIXING PROPORTION (dosage)**

- weight: **90** Base / **10** Hardener
- volume: **5** Base / **1** Hardener

**CURING DURATION ( at 20 ° C):** 10 minutes

**MIXTURE LIFETIME ( at 20 ° C):** 6 hours

**THINNER:** THINNER EP N ° 17

**DENSITY AT 23 ° C MIXTURE:** About 1.38

**DRY EXTRACT BY VOLUME OF THE MIXTURE:** 50 +/- 3%

**WEIGHT OF DRY FILM for a thickness of 100µm:** 276 g / m<sup>2</sup>

**VOC:** 450 g / l

**THEORETICAL YIELD:**

5 m<sup>2</sup> / L for 100 µm dry

**RECOMMENDED THICKNESS PER LAYER:**

Dry: 100 - 200 µm Wet: 200  
to 400 µm

**DRYING TIME ( at 23 ° C - 50 to 60% RH):** Dust free: 1 h 30

Dry to touch: 3 h 30 Sandable  
at 23 ° C: 24 h

**RECOVERY ( at 23 ° C - 40 to 60% RH):** Minimum:

6 h  
Maximum: 3 months

**LIMIT OF USE TEMPERATURE:** 100 ° C

## PREPARATION DE SURFACE

All surfaces to be covered must be free from dirt, pollution due to grease, water vapor, dust or mold.

**THE UNDERCOAT 215 HB +** can be applied directly to pickled steel or aluminum or must be applied over a compatible primer.

For any other type of covering, consult our technical service.

## EMPLOI ET DILUTION

Before mixing the two components. The base should be mixed thoroughly for at least 10 minutes using a clean disperser mounted on an explosion proof stirrer. Then add the part of hardener. Pour it slowly and continuing to mix until obtaining a smooth and homogeneous liquid.

Since the two components are of different viscosities, the edges of the mixing container should be carefully scraped with a spatula. Mixing containers should be well-bottomed and have perfectly smooth edges. The use of the original containers is possible.

After 15 minutes of curing, a dilution (with EP THINNER N ° 17) from 0 to 20% is possible depending on the application conditions or the equipment used. The viscosity should be checked using DIN or AFNOR cups and readjusted if necessary. In air gun applications, a viscosity check is recommended every 2 hours. Remember to mix well after each readjustment by diluting.

## APPLICATIONS

METHODS		DILUTION	NOZZLES	PRESSURE
BRUSH	YES (alterations)	0 to 10%	1.5mm to 2.2mm	2 to 5 BARS
ROLLER	YES (medium hairs)	0 to 10%		
PNEUMATIC	YES	5 to 20%	0.019 to 0.021 mm (30 to 60 °)	250 BARS
AIRLESS	YES	2 to 5%		

### CONDITIONS OF APPLICATION:

Optimum: 20 to 25 ° C for 50 to 70% RH Limit: 15 to 35 ° C for 30 to 80% RH

Substrate temperature must be at least 3 ° C above dew point

**VISCOSITY:** 48s AFNOR cup n ° 4, at 20 ° C without dilution.

## PRECAUTION D'EMPLOI ET STOCKAGE

**CONDITIONING :** KIT 4 Liters and KIT 15 Liters

**STORAGE DURATION:** In closed original packaging at a temperature of + 10 to + 25 ° C: 24 months & 9 months in tropical conditions.

**FLASH POINT :** Base and Hardener: between 23 and 55 ° C                      NORMAL hardener:> 23 ° C

**TRANSPORT and LABELING:** Get closer to the safety sheets established according to the European Directives in force.

**PRECAUTION FOR USE:** Consult the hygiene and safety sheets for the products in force.

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