

## ViterBond WG500 HS Epoxy Int/Finish

Product Description	A two pack epoxy, high solids, low temperature curing intermediate/finish.				
Features & Use	<ul style="list-style-type: none"><li>• Cures down to 2°C</li><li>• Approved to UK Network Rail specification as the intermediate coat of a 3 coat system</li><li>• Applied as a two coat system over ViterBond ST200 or WG200 to provide 250 microns dft in 2 brush coats</li><li>• Good chemical and solvent resistance</li><li>• Use to upgrade a conventional system to high performance epoxy/polyurethane system</li><li>• Can overlap onto aged, sound chlorinated rubber, vinyl or alkyd products</li><li>• Suitable for either winter or summer application</li></ul>				
Approvals/ Certification	UK Network Rail M24 (Item 7.1.7)				
Finish	High sheen				
Volume Solids	82 ± 2%				
VOC Content	173 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	125 µm	152 µm	6.6 m²/litre	
	Maximum	200 µm	244 µm	4.1 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 125 microns DFT		+5°C	+10°C	+23°C
	Dust Free		19 hr	6 hr	3 hr
	Hard Dry		15 hr	10 hr	6 hr
	Overcoating*	Minimum	See Product Notes		
		Maximum	Indefinite if clean and sound, with itself		
	* See Product Notes Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	BS and RAL shades via our in-can tinting system				
Mix Ratio/ Product Code	Base	2931	1 part by volume		
	Hardener	4056 043	1 part by volume		
Pot Life	3½ hours at 23°C				
SG	1.46 – 1.50 kg/lit mixed, varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	<ul style="list-style-type: none"><li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li><li>This product is an intermediate/finish coat and should be applied over an appropriate primer or intermediate coat, such as ViterBond ST200 or ViterBond WG200 primers</li></ul>				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.				
Thinner	1031 Thinner <b>Equipment Cleaner</b> 950 Thinner				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	No
	<ul style="list-style-type: none"><li>Airless Spray: Output fluid pressure at tip 2000-3000 psi, Tip Size: 19-27 thou (0.48-0.68mm)</li><li>Brush application will typically achieve up to 125 microns dft, airless spray up to 200 microns dft</li><li>Avoid exceeding the maximum stated dry film thickness</li><li>Refer to Spencer <b>‘Epoxy Application and Curing Notes’</b></li></ul>				
Product Notes	<b>Overcoating</b> <ul style="list-style-type: none"><li><b>With conventional, chlorinated rubber or vinyl:</b> ideally overcoat between 24-48 hours at 23°C. Maximum is 7 days or abrading is required</li><li><b>With epoxy or two pack polyurethane:</b> min 24 hours, max 3 months, at 23°C</li><li><b>With alkyds:</b> starting with ViterLac AM112 MIO is recommended for good intercoat adhesion. Min 24 hours, max 7 days, or abrading will be required</li><li>Extend min/max drying and overcoating times at lower temperatures and for dft’s above 125 microns</li></ul> <b>Other</b> <ul style="list-style-type: none"><li>Do not apply below 2°C</li><li>For an anti-graffiti finish, overcoat with ViterThane PLS in a colour followed by ViterThane PDV Clear. Alternatively, apply ViterThane PDV in a colour directly</li></ul>				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Spencer Coatings.				