



Approved By Major  
Motor Manufacturers

PRODUCT DATA  
**COPON**  
**HYCOTE**  
**100 WT**

## PRODUCT DESCRIPTION SINGLE COMPONENT WATER-BORNE PRIMER

COPON HYCOTE 100WT high performance primer/finish coating systems have been developed primarily for long term corrosion protection of blast cleaned mild steel and cast ferrous substrates.

COPON HYCOTE 100WT as a single component water-borne coating demonstrates superior corrosion resistance to a wide range of traditional solvented paints.

COPON HYCOTE 100WT Primer can be overcoated with COPON HYCOTE 100 WT SEMI-GLOSS FINISH or with a variety of Finish colours if required.

COPON HYCOTE 100WT being water-borne is safe to use and presents no hazards during storage or application.

**Standard Colour Availability** As a primer, supplied only in Black and Red Oxide. As a finish can be manufactured in a very limited range of semi-gloss colours, (subject to minimum batch manufacture).

## GENERAL PROPERTIES AND APPROVALS

<b>Adhesion</b>	Excellent to blast cleaned mild steel and in certain operating conditions to degreased and mechanically abraded mild steel surfaces and cast ferrous substrates.
<b>Corrosion Resistance</b>	Outstanding resistance on correctly prepared surfaces at the appropriate dft.
<b>Impact Resistance</b>	Excellent impact resistance.
<b>Drying/Overcoating</b>	Exceptionally fast drying and overcoating times under moderately elevated temperatures with good air movement.
<b>Application</b>	Suitable for a wide range of application methods including electrostatic airless spray.
<b>Rover</b>	Tested to Rover RES 30 CT 117/8 - 240 hours
<b>Ford</b>	Tested to Ford SDM-2P-9560-A

## FIRE PERFORMANCE TEST DATA

COPON HYCOTE 100 WT systems have been tested on mild steel substrates to a range of British Fire Standards. Full test details and results are available on request from the E Wood Technical Centre. Tests carried out include:

BS476 - Part 7	Class 1 Surface Spread of Flame.
BS476 - Part 6	Class 0 Designation in accordance with UK Building Regulations.
BS6853	Annex D Section 8.4 (Panel Test)
	NFP 92-501

## SURFACE PREPARATION

<b>METHOD</b>	Surfaces should be degreased and free from dirt, rust, millscale and other contamination. Rust and/or millscale should be removed by:- a) Abrasive blasting to Sa2 <sup>1/2</sup> BS 7079 Part A1 1989/ISO 8501-1 1988 - with a fine profile - 30 microns average. b) Mechanical grinding or abrading using 80 or 120 grade abrasive paper. c) Cast ferrous surfaces should be thoroughly cleaned and degreased. Any resultant dust and debris must be removed prior to application.
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## MIXING

<b>Number of Components</b>	Single component material supplied ready for use.
<b>Method of Mixing</b>	Stir contents of container thoroughly prior to use.

(continued overleaf)

# APPLICATION

**Conditions for Application** Do not apply when Relative Humidity exceeds 85% or when the surface to be coated is less than 3°C above the dew point.

**METHOD** COPON HYCOTE 100WT PRIMER is supplied for application by airless, air assisted airless or water-based electrostatic spray. If COPON HYCOTE 100 WT PRIMER is required to be applied by conventional spray, brush or roller, it must be ordered as CS (conventional spray grade) or BR (Brushgrade). COPON HYCOTE 100 WT Finish is supplied in one grade, but will require thinning with water, for conventional spray, brush or roller application.

**Typical Spray Settings are:-  
Conventional Spray**

Pressure pot - Suction feed  
Needle setup 1.4 - 1.8 mm

Further advice on equipment and application procedures is available from the Copon Technical Centre.

Prior to use (especially where solvent based products have been used previously) equipment should be first flushed with water miscible solvent (such as COPON 3000 CLEANING SOLVENT) followed by clean water. After use, the equipment should be washed out with water. If solvent based products are then to be used, the equipment should now be flushed with water miscible solvent.

**Theoretical Coverage Rate** 9 sq metres per litre at 50 microns dft.  
**Film Thickness (Typical)** Wet 112 microns  
Dry 50 microns

## PHYSICAL CONSTANTS

<b>Drying &amp; Cure Times at 20°C</b>	Touch Dry	20 minutes
	Dry to Handle	30-40 minutes
	Hard Dry	2 hours
	Overcoating	20 minutes
	Full Cure	7 days

**NOTE:** For increased throughput and reduced drying periods of elevated temperatures, please refer to Copon Technical Centre.

**Total Solids Content** 45%  
**(Average) by Volume**  
**Specific Gravity** 1.4  
**V.O.C. (As Supplied)** Primer 38gm/litre Finish 27gm/litre **NOTE:** Thinning for spray application will reduce the applied V.O.C.

## HEALTH & SAFETY

1. COPON HYCOTE 100 WT is a water-borne system and does not present any health hazard during normal industrial use.
2. Skin contact should be avoided. Any affected areas should be washed with soap and water.
3. Where eye contact occurs, the eye should be washed immediately with copious quantities of clean water.

**NOTE:** Full Health and Safety Data is available from E Wood Ltd.

## PACKAGING AND STORAGE

Supplied in 5 litre, 20 litre or 180 litre units.

Use within 12 months of purchase. Store in original sealed containers at temperatures between 5°C and 30°C. Protect from frost during storage and use.

Copon System Recommendations take precedence over individual Copon Product Data Sheets and are available on request.



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