

Date: 12th June, 2025

Technical Data Sheet

Version: 01

Product Name	
Full Product Name	419 ST Epoxy - Factory Mixed Colours
Type of Product	2K Epoxy Polyamine
Description	Concept Unicote 419 ST Epoxy is a 2K chromate-free epoxy-polyamide high-solids coating, suitable for most industrial and commercial applications, including above the waterline marine. It is characterised by excellent adhesion and anti-corrosive properties with high abrasion and solvent resistance. Its unique formulation ensures it can be used as a primer or topcoat.

Products				
Product Name	Volume Solids %	Weight Solids %	Density g/mL	VOC g/L
419 ST Epoxy – Mixed Colours	78.0-83.0	88.0-93.0	1.71-1.75	175.0-185.0
419 ST Epoxy Hardener	91.9	94.7	1.31	69.8
Mixed Product without Thinner	81.0-84.0	90.0-95.0	1.65-1.70	150.0-160.0
419 Thinner	0.0	0.0	0.87	868.0

Properties
• Excellent anti-corrosive properties • Excellent chemical and water resistance • Good flexibility • Excellent adhesion – Surface Tolerant • Easy to sand • Factory colours available on request

Substrates

- Mild Steel
- Aluminium
- Galvanised Steel
- Stainless Steel 304L
- Glass Reinforced Plastics (GRP)
- Concrete
- Previously painted substrates in sound condition

Substrate Preparation



All Substrates

Solvent or chemical clean the surface

Good: Whip blast to Sa 2 or hand/power tool clean to St 2

Better: Blast to Sa 2 ½ or hand/power tool clean to St 3

Best: Blast to Sa 3

Solvent clean the surface again

Product Preparation

 		• Stir or shake for a minimum of 10 minutes. • Never leave the mixture stand for more than 30 minutes before mixing.				
 3:1 Mixing Ratio (by volume)			419 ST Epoxy - Factory Mixed Colours	419 ST Epoxy Hardener		
			3 parts		1 part	
	Reducer		Conventional Spray - Up to 40% (v/v) Concept 419 Thinner, if required			
			Airless Spray, Brush or Roller – No Thinning Required			
	Pot life @ 25°C (77°F)		90 minutes (without thinner)			
	Spray viscosity @ 25°C (77°F)		BSB 4 Cup Ford 4 Cup	Conventional Spray - 17-19 s Conventional Spray - 15-17 s Airless – As supplied		
   	Spray equipment		Gun type	Fluid tip	Spray pressure	Spray Distance
			Gravity Feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
			Suction feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
			Airless	517 tip, 2500-3000psi		

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Product Preparation

	Number of coats	2-3 5	Conventional Spray Airless
	DFT Recommended	Conventional Spray - 80-200 µm (3.1-7.9 mils) Airless - 200-400 µm (7.9-15.7 mils)	
	Flash off time @ 25°C (77°F)	Conventional Spray - 5 minutes between coats Airless - Not required	
	Drying	Air Dry @ 25°C (77°F)	Tack Free: 7 hours Print Free: 14 hours Recoat with itself after 16 hours minimum and 7 days maximum. Able to be overcoated with Concept Unicote 310 2K Polyurethanes or Unicote 307 2K Iso-Free after 24 hours minimum and 7 days maximum.
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification, and we assume no liability in connection with its use.			

Remarks

	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Before application a colour comparison is recommended
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.
	Clean equipment with 035 Gunwash or 808 Multi-Thinner

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Theoretical Coverage	Approx. 2.0-4.0 m ² /L (80-165 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

Product Packaging

Product Code	Product Name	Package Size
IN419XXXX0012 IN41992000001 IN419921000XX	419 ST Epoxy - Factory Mixed Colours 419 ST Epoxy Hardener 419 Thinner	12L 4L 4L, 20L

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Concept Paints
26-30 Charles Street
St Marys NSW 2760
Sydney, Australia

ph. +61 (2) 9673 2555
fax. +61 (2) 9623 1918
office@conceptpaints.com.au
www.conceptpaints.com.au