

ULTRIMAX PAINT PROCESS CHART



	ULTRIPRIME	ULTRIPRIME 2HS	ULTRIPRIME 2K ETCH	AQUIMAX PRIMER	ULTRIMAX 1	ULTRITHANE	ULTRIMAX GLOSS	ULTRIMAX MATT	HAMMER FINISH	ULTRIMAX SGX	ULTRITHANE 21	ULTRITHANE 31	ULTRITHANE 2	ULTRIMAX 2	AQUIMAX 1	AQUIMAX TOPCOAT
What and where is this product used?	Zinc-Phosphate primer for use on structural steelwork, plant, machinery, agricultural equipment and all steel fabrication works.	2-Pack, epoxy zinc-phosphate primer, which is ideal for structural steel situated in chemical or aggressive environments. Suitable to be used with most types of paint. Suitable for galvanised steel and aluminium after appropriate cleaning.	2-Pack, etch primer for pre-treating aluminium or galvanised metal prior to topcoating.	Single pack, waterbased primer; for use on all types of steel and sheet metal surfaces, whether they're decorative or structural.	Glossy finish paint that can be applied direct to metal; for use on plant, machinery, gates, railings, steel fabrications and architectural applications.	Single pack, high gloss polyurethane topcoat; for use on sheet metal, tools, gates, railings, plant, machinery and general steel fabrications.	Single pack, high gloss top coat; for use on sheet metal, tools, gates, railings, plant, machinery and general steel fabrications.	Single Pack, Matt, alkyd topcoat. Versatile easy to use topcoat, suitable for a wide range of industrial applications including plant, machinery, tools, sheet metalwork, gates and railings and general steel fabrications.	A decorative and protective finish for metal to hide surface imperfections can be used as a one coat finish for internal ferrous surfaces. External and internal non-ferrous metal surfaces should be primed with a suitable etch primer.	Single pack, direct-to-metal, semi-gloss topcoat; for use on cabins, containers, plant, machinery and general steel fabrications.	2-Pack, high gloss acrylic-polyurethane; for use on plant, agricultural machinery and general steel fabrications. This product can be applied direct to galvanised and aluminium substrates, without a primer.	2-Pack, direct-to-metal, glossy anti-corrosive coating; for use on plant, agricultural machinery and general steel fabrications.	2-Pack, high gloss polyurethane topcoat; for use on agricultural machinery, industrial equipment and metal structural work where a hard wearing, durable finish is required.	A two pack acrylic topcoat that is isocyanate free with good gloss and colour retention. As a topcoat over an epoxy primer where a durable, high gloss finish is required.	Fast drying water based anti-corrosive primer finish coat combination. Suitable for use on decorative and structural steel, sheet metal and many other substrates.	Water based, single pack glossy topcoat.
Preparation	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Blast-cleaning to SA2.5 (ISO-8501-1:2007). Power tool cleaning to min. St 2 (ISO8501-1:2007)	Mild steel: surfaces must be clean, dry and free from dust, grease, oil, millscale, etc. For best results blast clean to SA2 and coat with a suitable blast primer within 4 hours. Aluminium & galvanised steel: for best results apply a suitable etch primer.	All surfaces should be clean, dry and free from grease, rust, millscale, etc. The primer base component should be well mixed and then the acid component should be added and mixed in the correct proportion. Apply in the normal manner ensuring that all areas are completely covered.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Blast-cleaning to SA2.5 (ISO-8501-1:2007). Power tool cleaning to min. St 2 (ISO8501-1:2007)	All substrates to be free from oil, dirt, rust, grease and any other contaminants. For best adhesion, blast clean steel to SA2.5 or apply to undamaged, compatible primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Apply over a compatible primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Apply over a compatible primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Blast clean steel to SA2.5 or apply to undamaged, compatible primer.	Mild steel: Surfaces must be clean, dry and free from dust, grease, oil, millscale, etc. For best results blast clean to SA2 and coat with a suitable blast primer within 4 hours. Aluminium & Galvanised steel: Apply Two pack etch primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants.	Metal: clean, dry, degreased, and free from rust. Galvanized sheet: verify the perfect cleaning of the support and eliminate, through brushing, the white corrosion. If the galvanized sheet is new, perfectly degrease and pre-treat. Light alloys: clean, dry, degreased; make a careful sandpapering to abrade the surface.	Metal: clean, dry, degreased, and free from rust. Galvanized sheet: verify the perfect cleaning of the support and eliminate, through brushing, the white corrosion. If the galvanized sheet is new, perfectly degrease and pre-treat. Light alloys: clean, dry, degreased; make a careful sandpapering to abrade the surface.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Apply over a compatible primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Blast clean steel to SA2.5 or apply to undamaged, compatible primer.	All substrates to be free from oil, dirt, rust, grease and any other contaminants. Consult our technical staff for information.	Provides good adhesion on most substrates.
Volume Solids	58%	64%	N/A	Typically 50%	55%	42%	50%	50%	38%	47%	60%	66%	58%	50%	Typically 50%	40%
Spreading Rate	7.5m ² /L	8.5 m ² /L	15 m ² /L	10 m ² /L	4.5m ² /L	10 m ² /L	10 m ² /L	10 m ² /L	10 m ² /L	6.5 m ² /L	10 m ² /L	9 m ² /L	8 m ² /L	8 m ² /L	10 m ² /L	10 m ² /L
Primer	N/A	N/A	N/A	N/A	N/A	Ultraprime	Ultraprime	Ultraprime	Ultraprime	N/A	Ultraprime 2HS/Ultraprime 3 (Optional)	Ultraprime 2HS/Ultraprime 3 (Optional)	Ultraprime 2HS	Ultraprime 2HS	N/A	N/A
Thinner/Cleaner/Hardener	Xylene Thinner	Epoxy Thinner HS Hardener	2K Etch Thinner	Water	Xylene Thinner	Synthetic Thinner	Xylene Thinner	Xylene Thinner	Xylene Thinner	Xylene Thinner	Universal 2K Thinner Compliant Hardener Or, Fast Hardener	Universal 2K Thinner Compliant Hardener Or, Fast Hardener	Universal 2K Thinner Universal 2K Activator	Ultrimax Universal 2K	Water	Water
Drying Times	Touch dry: 20 minutes Hard dry: 2 hours	Touch dry: 2 hours Hard dry: 6 hours	Touch dry: 20 minutes Hard dry: 12 hours	Touch dry: 20 minutes Hard dry: 24 hours	Surface dry: 30 minutes Hard dry: 2-3 hours	Surface dry: 1 hour Hard dry: 6-8 hours	Surface dry: 30 minutes Hard dry: 4 hours	Surface dry: 30 minutes Hard dry: 2 hours	Surface dry: 30 minutes Hard dry: 24 hours	Surface dry: 1 hour Hard dry: 2 hours	Touch dry: 30 minutes Hard dry: 24 hours	Touch dry: 30 minutes Hard dry: 24 hours	Touch dry: 1 hour Hard dry: 24 hours	Touch dry: 4 hours Hard dry: 36 hours	Touch dry: 12 minutes Hard dry: 24 hours	Touch dry: 20 minutes Hard dry: 24 hours
Film Thickness	Dry: 75 microns Wet: 135 microns	Dry: 75 microns Wet: 100 microns	Weld through operation apply 12 - 15 microns	Dry: 30 microns Wet: 70 microns	Dry: 120 microns Wet: 245 microns	Dry: 40 microns Wet: 95 microns	Dry: 40 microns Wet: 85 microns	Dry: 40 microns Wet: 85 microns	Dry: 50 microns Wet: 120 microns	Dry: 75 microns Wet: 160 microns	Dry: 50 microns Wet: 80 microns	Dry: 50 microns Wet: 95 microns	Dry: 40 microns Wet: 90 microns	Dry: 75 microns Wet: 125 microns	Dry: 30 microns Wet: 70 microns	Dry: 25 microns
Application Method	☞ ☛ ☚ ☙ ☘	☚ ☙ ☘	☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☚ ☙ ☘	☚ ☙ ☘	☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘	☞ ☛ ☚ ☙ ☘
Spray Tip Sizes	0.015"-0.019"	0.015"-0.021"	0.011"-0.013"	0.013"-0.019"	0.015"-0.019"	0.011"-0.013"	0.015"-0.019"	0.015"-0.019"	0.015"-0.019"	0.015"-0.019"	0.011"-0.019"	0.011"-0.019"	0.011"-0.013"	0.013"-0.019"	0.013"-0.019"	0.013"-0.019"
Colours	Red, Grey, White, Buff and Black	Grey	Transparent Yellow	Grey, Red, Black & Green Other colours available on request	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	All RAL, BS and Fleet colours	Grey, Red, Black & Green Other colours available on request	All RAL, BS and Fleet colours
Mixing Ratios	Max 20% Thinner	4 parts paint, 1 part Hardener, 10-20% Thinner	1 part paint, 1 part Hardener	Max 5% water	Max 20% Thinner	Max 20% Thinner	Max 20% Thinner	Max 20% Thinner	Max 20% Thinner	Max 20% Thinner	4 parts paint, 1 part Fast Hardener Or, 7 parts paint, 1 part Compliant Hardener	4 parts paint, 1 part Fast Hardener Or, 7 parts paint, 1 part Compliant Hardener	2 parts paint, 1 part Hardener, 10-20% Thinner	2 parts paint, 1 part hardener	Max 5% water	Max 5% water
Pack Size	5, 20 or 200 litre	5 or 20 litre	5 litre	5, 20 or 200 litre	5, 20 or 200 litre	5 or 20 litre	5 or 20 litre	5, 20 litre	5 or 20 litre	5, 15 or 20 litre	4 or 16 litre	4 or 16 litre	5 or 20 litre	5, 20 litre	5, 20 litre	5, 20 litre

NEED SOME ADVICE? CALL THE TECHNICAL HELPLINE +44(0)1302 856666

☞ Roller ☛ Brush ☚ Spray ☙ Airless Spray ☘ Air Assisted Spray

☐ Primers ☐ Single Pack ☐ 2-Pack ☐ Isocyanate Free 2K ☐ Water Based

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