



## PRODUCT DATA SHEET

### INDUSTRIAL RANGE

### QUICK DRY ENAMEL

#### 1. DESCRIPTION

High quality finishing coat, based on modified short oil alkyd resin.

#### 2. PRINCIPAL CHARACTERISTICS

- Suitable for atmospheric exposure conditions only.
- Fast drying.
- Fast hardening.
- Good colour retention.
- Not suitable for immersion in water.

#### 3. PACKAGING, COLOURS AND GLOSS

- 1lt, 5lt and 20lt.
- Truck and tractor colours, SABS standard safety colours (other colours available on request).
- High gloss.

#### 4. BASIC DATA AT 23°

- Drying time:  $\pm 30$ min surface dry.  
 $\pm 5$ hrs hard dry.
- Recoating time:  $\pm$  min 3hrs for 50 $\mu$ m dft, max unlimited.
- Mass relative density:  $\pm 0.9 - 1.1$  g/cm<sup>3</sup>.
- Solids by volume:  $\pm 46\%$ .
- Viscosity:  $\pm 60 - 70$ sec.
- Recommended dft: 50 $\mu$ m per coat. (2 coats recommended.)
- Theoretical spreading rate: 9 - 11m<sup>2</sup>/lt for 50 $\mu$ m.
- Practical spreading rate: 8 - 10m<sup>2</sup>/lt for 50 $\mu$ m.
- Shelf life: at least 12 months in cool and dry conditions.



**PROTECTION WHERE YOU NEED IT!**

Limitation of liability applies. Refer to annexure for full disclosure.  
April 2009 - INDUSTRIAL RANGE - HB EPOXY PIPE COAT - revision 1 of 2009.



- Flash point: 18°C - 28°C.

## 5. RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Steel; previous suitable coat; (single pack etch coat) dry and free from any surface contamination.
- Substrate temperature should be between 10°C and 30°C and at least 3°C above dew point during application and curing.

## 6. INSTRUCTIONS FOR USE

- Stir well before use.
- Product temperature should be above 15°C to achieve application viscosity.
- Quick dry thinners can be introduced to lower the viscosity if necessary. Do not exceed 10% to volume.
- Too much solvent will reduce sag resistance.
- Always ensure adequate ventilation.

### • AIRLESS SPRAY:

- Recommended thinner: QD Thinners.
- Volume of thinner: 0 – 10%, depending on required thickness and application conditions.
- Nozzle orifice: ± 0.38 – 0.48mm.
- Nozzle pressure: 12 – 16MPa (± 120 to 160 bar).

### • AIR SPRAY:

- Recommended thinner: QD Thinners.
- Volume of thinner: 0 – 10%, depending on required thickness and application conditions.
- Nozzle orifice: ± 1.5 – 2mm.
- Nozzle pressure: 0.3 – 0.4MPa (± 3 to 4 bar).

### • BRUSH / ROLLER: (not recommended)

- Recommended thinner: QD Thinners.
- Volume thinner: 0 – 5%, depending on required thickness and application



**PROTECTION WHERE YOU NEED IT!**

Limitation of liability applies. Refer to annexure for full disclosure.  
April 2009 - INDUSTRIAL RANGE - HB EPOXY PIPE COAT - revision 1 of 2009.



- Cleaning solvent: conditions.  
QD Thinners.

## 7. SAFETY PRECAUTIONS

This is a solvent based paint, avoid inhalation of spray mist vapor as well as contact between the wet paint and exposed skin or eyes.



**PROTECTION WHERE YOU NEED IT!**

Limitation of liability applies. Refer to annexure for full disclosure.  
April 2009 - INDUSTRIAL RANGE - HB EPOXY PIPE COAT - revision 1 of 2009.