



## PRODUCT DATA SHEET

### INDUSTRIAL RANGE

### GLOSS ENAMEL

#### **1. DESCRIPTION**

Good quality gloss enamel paint based on a modified alkyd resin.

#### **2. PRINCIPAL CHARACTERISTICS**

- Finishing enamel in the ECONOMY RANGE.
- Good opacity gloss paint for internal and external substrates. Do not exceed maximum recommended spreading rate.
- Good UV resistance to direct outside exposure, however normal fading of colours over time can take place.
- Solvent based with good resistance to scuffing and marring.
- Gloss finish allows for low dirt retention. Is scrubable with detergents but take care not to use strong or abrasive cleaning agents when washing the coating.
- Good application properties and can be over coated with compatible conventional alkyd based paints. Cannot be over coated with QD enamels or flexible PVA's without sufficient abrasion and intermediate undercoats.
- Tough and durable for extended exterior maintenance cycles.

#### **3. PACKAGING, COLOURS AND GLOSS**

- 1lt, 5lt and 20lt.
- White, black and a wide range of standard colours.
- Gloss finish.

#### **4. BASIC DATA AT 23°**

- |                          |   |
|--------------------------|---|
| • Drying time:           | ± 6hrs surface dry.<br>± 18hrs full cure. |
| • Recoating time:        | ± min 16hrs for 40µm dft, max unlimited.  |
| • Pot life:              | N/a                                       |
| • Induction period:      | N/a                                       |
| • Mass relative density: | ± 0.95 – 1.1 g/cm <sup>3</sup> .          |
| • Solids by volume:      | ± 50%.                                    |
| • Viscosity:             | ± 70 – 75 Ku.                             |



**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.



- Recommended dft: 40µm per coat. (2 coats recommended.)
- Theoretical spreading rate: 13 – 15m<sup>2</sup>/lt for 40µm.
- Practical spreading rate: 9 – 11m<sup>2</sup>/lt for 40µm.
- Shelf life: at least 12 months in cool and dry conditions.
- Flash point: 38°C to 45°C.

## 5. RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Previous coat: (alkyd-based primer, gloss enamel) must be free from any contamination and sufficiently abraded if necessary.
- The substrate must be dry, surface moisture content less than 15%, before and during application of GLOSS ENAMEL.
- Substrate temperature should be between 10°C and 30°C and at least 3°C above dew point during application and curing.
- Maximum relative humidity during application and curing is 85%.

## 6. INSTRUCTIONS FOR USE

- Stir well before use.
- Product temperature of the stirred base should be above 15°C to achieve application viscosity.
- Product is formulated to be ready for use; the addition of mineral turpentine will reduce sag resistance and opacity.
- Always ensure adequate ventilation.
  
- AIRLESS SPRAY:
  - Recommended thinner: Mineral turpentine.
  - Volume of thinner: Thinning not recommended.
  - Nozzle orifice: ± 0.38 – 0.48mm.
  - Nozzle pressure: 12 – 16MPa (± 120 to 160 bar).
  
- AIR SPRAY:
  - Recommended thinner: Mineral turpentine.
  - Volume of thinner: 0 – 5%, depending on required thickness and application conditions.
  - Nozzle orifice: ± 1.5 – 2mm.
  - Nozzle pressure: 0.3 – 0.4MPa (± 3 to 4 bar).
  
- BRUSH / ROLLER: Long haired brush or mohair roller.



**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.



- Recommended thinner: Mineral turpentine.
- Volume thinner: Thinning not recommended.
- Cleaning solvent: Mineral turpentine.

## 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.