



DESCRIPTION

- a two pack, isocyanate free catalysed acrylic coating
- approved to APAS-2919
- conforms to AS/NZS 3750.5

PRINCIPAL CHARACTERISTICS

- unlimited recoatability
- good gloss off the gun
- fast drying
- excellent exterior durability
- good chemical and solvent splash resistance
- will cure down to 5°C
- isocyanate-free

COLOURS AND GLOSS

- AS 2700 Colour Card - full gloss

BASIC DATA AT 25°C

- solids content approx. 45% by volume
- mix ratio 4A:1B by volume
- typical film thickness (per coat) 50 microns(dry), 110 microns(wet)
- theoretical spreading rate 9.0 m²/l for 50 microns(dry)
- touch dry after 30 minutes
- overcoating interval min. 30 minutes, max. unlimited
ensure surface is free from chalking and contamination
- full cure after 7 days
- shelf life (cool and dry place) at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- previous suitable coat must be dry and free from chalking and contamination and sufficiently roughened if necessary
- do not apply over Epiname! DTM800 or DTM900
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 85%

INSTRUCTIONS FOR USE

- mixing ratio by volume 4A:1B
- induction time - none
- pot life at 25°C 8 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- this product must be thinned with the recommended thinner before application
- thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions



- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to Watty

APPLICATION

- **AIRLESS SPRAY**
 - recommended thinner Thinner L745
 - volume of thinner 10-20%
 - nozzle orifice approx. 0.38 mm (0.015 inch)
 - nozzle pressure 15 Mpa (2100 psi)
- **AIR SPRAY**
 - recommended thinner Thinner L707
 - volume of thinner 15-25%
 - nozzle orifice 1.4 - 1.8mm
 - nozzle pressure 0.3 - 0.4 Mpa (50 - 60 psi)

At temperatures greater than 30°C, or in windy conditions, or where slower drying is required, part, or all, of Thinner L707 may be replaced with Thinner L745. However, film thicknesses must be closely monitored as excessive film builds may result in sagging

- **BRUSH/ROLLER**
 - recommended thinner Thinner L753
 - volume of thinner up to 5-10%The maximum dry film thickness that can be achieved when brushing/rolling is 30 microns
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** Thinner L707

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA****Overcoating table**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	2 hrs	60 mins.	30 mins.	15 mins.
Maximum interval	Unlimited when dry and free from chalking and contamination			

Curing table

Substrate temperature	Touch dry	Dry to handle	Full cure
5°C	120 mins	72 hrs	28 days
15°C	60 mins	32 hrs	14 days
25°C	30 mins	16 hrs	7 days
35°C	15 mins	12 hrs	5 days

- adequate ventilation must be continuously maintained during application and curing

Pot life (at application viscosity)

Paint temperature	Pot life
15°C	12 hrs
25°C	8 hrs
35°C	4 hrs

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