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TECHNICAL INFORMATION SHEET

480 PREMIUM ENAMEL

FAST AIR DRYING ENAMEL

June 2009

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Description and uses:

480 Premium Enamel is a fast air drying industrial enamel ideal for agricultural, industrial machinery and earthmoving equipment that require minimum maintenance down time and outstanding exterior durability and weathering.

480 Premium Enamel has the following features:

- High gloss retention (interior and exterior).
- Excellent water and yellowing resistance.
- Resistant to overcoating without any time constraints.
- Compatible with all Lacnam Primers.
- Enhanced drying, gloss, durability and masking properties with addition of 298 Enamel Additive.

Typical areas of application are:

- Structural steel, trusses etc.
- Machinery, cranes, implements and forklifts.
- Trucks, tractors and trailers.

Technical Specifications:

FINISH: High Gloss.

THINNERS: T102 or T104 (or T124 for electrostatic application).

VOLUME SOLIDS: 35% - 40% depending on colour.

VOC: 520gms/litre. (White).

COVERAGE: 9-10 Square metres per litre (at a D.F.T. of 40 microns).

RECOMMENDED FILM THICKNESS: 25-40 microns.

APPLICATION: Conventional or Airless Spray.

DRYING AT 25°C / 50% Humidity: Touch dry:	1-2 hours
Recoat:	Preferable after 2hrs.
Hard dry:	Overnight.

Note: If this product is to be used where masking up and repainting, or where quicker drying is required, the use of 298 Enamel Additive is recommended. Refer to technical data sheet for 298 Enamel Additive before use.

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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 st Coat	40-60	210 Metalprime (thinner T102 or T104)
	2 nd Coat	25-40	480 Premium Enamel (thinner T102, T104 or T109)
	3 rd Coat	25-40	Optional 480 Premium Enamel (thinner T102, T104 or T109)

D.F.T. um			
System 2	1 st Coat	5-10	258 Twin Pack Etch or 260 Keycoat (thinner T166)
	2 nd Coat	25-40	480 Premium Enamel (thinner T102, T104 or T109)
	3 rd Coat	25-40	Optional 480 Premium Enamel (thinner T102, T104 or T109)

D.F.T. um			
System 3	1 st Coat	50-75	722 Iso-Free Primer(thinnerT154 or slow T156 or T159)
	2 nd Coat	25-40	480 Premium Enamel (thinner T102, T104 or T109)
	3 rd Coat	25-40	Optional 480 Premium Enamel (thinner T102, T104 or T109)

APPLICATION DETAILS – SURFACE PREPARATION		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 Or abrasive blast clean to AS1627.4 Class 2	1 or 3
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	2 or 3
Previously painted surfaces	Lightly sand glossy areas wash down with cleaning solvent.	1 or 2

Surface Preparation:

- When overcoating; Aged paint coatings should be tested for adhesion using Crosshatch or Crosscut methods. If aged paint coating lifts remove it.
- Remove all rust, oxides, millscale and loose paint from metal surface.
- Round off all sharp edges, welding joints and weld spatter.
- All surfaces to be painted should be clean and free from dust, dirt, oil, grease and moisture.
- All abrasive blast clean ferrous surfaces should be coated within 4 hours to avoid flash rusting.
- Do not apply at temperatures below 5° Celsius. Do not apply at relative humidity above 85%, or when the substrate surface is less than 3° Celsius above dewpoint.

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Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Suitable for small areas only.

Conventional Spray - 1.3 -2.0mm tip (or equivalent). Pressure pot set at 55 - 100kpa (8 - 15psi) and maintain gun air pressure 275 - 380kpa (40 -55psi).

Airless Spray – Use heavy-duty airless spray with 10 -15 “(0.25 – 0.38mm) plus tip and pump ratio 30:1

Application Thinning:

Brush or Roller – Suitable for small areas only; May require Slow or Retarding Thinners (T109 / T122), to improve brushability. Thin initially 5%, then increase to suit.

Conventional Spray – Thin approximately 20-25% and apply.

Airless Spray - Thin approximately 5-10% and apply.

Clean Up – T102, T104 or T134 All Purpose Thinner.

Safety Instructions:

Storage: Store in a cool, dry bunded area out of direct sunlight as required for Flammable liquids DG Class 3, PG II, Hazchem 3(Y)E.

Flammability: Highly flammable, all sources of ignition must be eliminated in or near area of use, on burning fumes emitted are toxic. Do not smoke in immediate area.

Handling: Adopt adequate Occupational Work Practices to avoid personal contamination with product. Always wash hands before smoking, eating, drinking or using toilet. Food and Drink should be to stored and consumed in separate area.

Personal Protection: Avoid contact with skin or eyes; wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles and face mask.

Using: Avoid inhalation of spray mist and vapours – use with adequate ventilation and suitable Personal Protection Equipment (PPE).

Engineering controls: Ensure ventilation is adequate. When spraying, ensure product is applied in a fully functional spray-booth. Keep containers closed when not in use. Do not use near ignition sources.

REFER MSDS BEFORE USE

(Phone 02 9688 1999 or refer to www.lacnam.com.au for copy MSDS)

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