

Product Data

304 Equipment Enamel

PRODUCTS

304 Equipment Enamel	Colour
304 Reducer	R303-Normal Conditions, R203-Hot Conditions

Product Description

A general purpose spraying enamel based on a blend of alkyd resins and pigmented with the highest quality light fast pigments for an equipment enamel. It is a moderately fast drying, high gloss, hard and durable coating suitable for all industrial applications, and can be applied over most sound and properly prepared surfaces including metal and timber.

- For a more durable exterior finish the product lines 342, 363 or 367 are recommended.

Resistance Properties

- **Abrasion:** Good
- **Solvent:** Fair
- **Chemical:** Fair
- **Oil:** Fair
- **Heat:** Satisfactory up to 120°C Dry Heat

Preparation of Substrate



Surfaces showing heavy scale or surface rust should be treated with Protec R971 Metal Conditioner and Degreaser.

Heavily rusted surfaces should be abrasively blast cleaned.

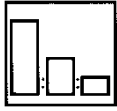
304 Equipment Enamel can be applied over a number of LIC primers such as, 426 Etch Pro, 426 Paralock, 426 Vinyl Etch Primer, 421 Etch Primer, 404 Auto Enamel Primer, 404 NS Primer, 402 Zinc Phosphate Primer, 411 Structural Primer.



Cleaning: Before and after any sanding operation, the substrate must be thoroughly degreased with Protec R123 wax & grease remover to remove all traces of dirt, oil, grease, silicone, wax etc.

Application Guide:

Mixing ratio:



By volume:

304 Equipment Enamel 100 Parts

Thinner Up to 15%

Spraygun Setup:



Suction

Conventional

1.6 – 2.0 mm

Spray Pressure:

45-65 psi
350 - 450 kPa

Application:



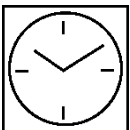
2 full, wet, even coats allowing flash-off between coats = 50-60 microns dry film build.

Flash Off Time:



10-15 minutes between coats @ 25 °C.
(dependant of film build)

Drying Times:



Air Dry Only:

Dust Free – 10 minutes

Touch Dry - 30 minutes

Dry To Handle – 45-60 minutes

Hard Dry Overnight

Recoat:



Can be re-coated by itself up to 4 hours drying and again after 72 hours drying under normal ambient conditions and normal film thickness.

Recoating should not be attempted after 4 hours drying and before 72 hours drying as the enamel is then in a sensitive dry stage and may react to overcoating.

Performance Guidelines

- Drying times will vary dependent on temperature, flash off between coats, number of coats used.
- Is suitable for brush application on small areas.
- 37% Volume Solids (Depending on Colour).
- At a dry film thickness of 25 microns the spreading rate of 9-12 square metres per litre should be used.
- Apply to 50-60 microns DFT, 1 full coat = 20-30 microns DFT

Health and Safety

Please refer to Material Health and Safety Datasheets for full health and safety details.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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