



**Sydney Head Office:**  
Phone: 02 9688 1999  
Fax: 02 9896 1606  
78 – 80 Mandoon Road  
Girraween, 2145, NSW  
[sales@lacnam.com.au](mailto:sales@lacnam.com.au)

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# 312 ENAMEL

## Drum Enamel

### Description and uses

312 Drum Enamel is a fast drying industrial spraying enamel based on a modified alkyd resin and high opacity pigments. Formulated for the drum reconditioning industry or applications where top quality exterior durability is not required.

312 Enamel has the following features:

- Fast drying and setup.
- Excellent spraying characteristics.
- Recoatable.
- One coat finish for economic work.

Typical areas of application are:

- Tools, machinery, pipelines etc.
- Structural steel and sheet metal.
- Drums, skip bins etc.

### Technical Specifications

**FINISH:** High gloss.

**THINNERS:** T102 or T104 thinners (T124 for electrostatic applications).

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

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

**RECOMMENDED FILM THICKNESS:** 25-45 microns dry.

**APPLICATION:** Conventional or airless spray.

**DRYING AT 25°C:** Touch dry 20-30 minutes

Recoat – 2 hours

Hard dry overnight



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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	50	210 Metalprime (thinner T102 or T104)
	2 <sup>nd</sup> Coat	25-45	312 Drum Enamel (thinner T102 or T104)

D.F.T. um			
System 2	1 <sup>st</sup> Coat	5-10	258 Twin Pack Etch or 260 Key-Coat (thinner T166)
	2 <sup>nd</sup> Coat	25-45	312 Drum Enamel (thinner T102 or T104)

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
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	2

**Note:** All surfaces to be painted should be clean and free from dust, dirt, oil, grease etc. All surfaces must be free of moisture and topcoat not applied when the substrate temperature is below 5°C.

#### Application

**Conventional spray:** Thin approximately 20% with T102 or T104. Apply 2 coats wet on wet using 350-400 kPa atomizing pressure.

**Airless spray:** Thinning is not normally required, however a small amount of T102 or T104 may assist atomization.

**Clean up:** T102, T104 or Gun and Brush Wash.

#### Safety Instructions

**Flammability:** Highly flammable, avoid heat and sources of ignition. Container should be earthed when pouring.

**Personal Protection:** Avoid contact with skin or eyes, wear suitable clothing such as impervious overalls, PVC or neoprene gloves, safety goggles. Wear an approved half-face respirator suitable for organic vapor, meeting AS1715/1716.

**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.

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