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314 DIPPING ENAMEL

Description and uses

314 Dipping Enamel is based on modified alkyd resins and formulated for use in dip tanks for the coating of metal objects.

314 Dipping Enamel has the following features:

- Fast drying and setup.
- Recoatable.
- Tough film properties.

Typical areas of application are:

- Coils, springs etc.
- Swaybars and tools.
- Scaffolding etc.

Technical Specifications

FINISH: Full gloss.

THINNERS: T102 or T104 thinners (other blends of solvents for specific use should be discussed with technical department)

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: 25-35 microns dry.

APPLICATION: Dipping.

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



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APPLICATION DETAILS – PAINTING SYSTEMS			
D.F.T. um			
System 1	1 st Coat	50	210 Metalprime (thinner T102 or T104)
	2 nd Coat	25-35	314 Dipping Enamel

D.F.T. um			
System 2	1 st Coat	5-10	258 Twin Pack Etch or 260 Key-Coat (thinner T166)
	2 nd Coat	25-35	314 Dipping Enamel

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. Care must be taken to avoid contaminants (such as cement from scaffolding) entering dip tanks.

Application

- Dipping tanks should be agitated regularly for optimum performance and stability. Regular addition of stabilizers are recommended.
- Reduction with thinners to achieve a suitable dipping viscosity must be performed and viscosity measured with a flow cup.
- As solvent evaporation will occur, viscosity should be monitored and thinners added when required.

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, and 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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