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TECHNICAL INFORMATION SHEET

312 ENAMEL

Drum Enamel

May 2009

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Description and uses:

312 Drum Enamel is 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 Drum 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, trailers, etc

Technical Specifications:

FINISH: High Gloss.

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

VOLUME SOLIDS: 39 - 42% depending on colour.

VOC: 490gms/litre. (White).

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

RECOMMENDED FILM THICKNESS: 25 - 45 microns DFT.

APPLICATION: Conventional or Airless Spray.

DRYING AT 25°C / 50% Humidity: Touch dry: 20 - 30 minutes

Recoat: 2 Hours

Hard dry: Overnight.

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APPLICATION DETAILS – PAINTING SYSTEMS			
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System 1	1 st Coat	40-60	210 Metalprime (thinner T102 or T104)
	2 nd Coat	25-45	312 Drum Enamel (thinner T102 or T104)
	3 rd Coat	25-45	Optional 312 Drum Enamel (thinner T102 or T104)

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System 2	1 st Coat	5-10	258 Twin Pack Etch or 260 Keycoat (thinner T166)
	2 nd Coat	25-45	312 Drum Enamel (thinner T102 or T104)
	3 rd Coat	25-45	Optional 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
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.

Equipment Application: (Conventional or Airless Spray Recommended).

As a Guide Use:

Brush or Roller - Suitable for small areas only, additional coats may be required to achieve specific film build.

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

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Application Thinning:

Brush or Roller – Suitable for small areas only; May require Slow or Retarding Thinners (T195 / T122), to improve brushability. Thin initially 5%, then increase to suit.

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

Airless Spray – Thinning not normally required, however a small amount of T102 or T104 may assist atomization.

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

Safety Instructions:

Storage: Store in a cool, dry banded 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)

Although this information is presented in good faith and compiled from sources believed to be accurate, Lacnam Paints make no representations or warranty as to the completeness or accuracy thereof. As the product's performance and suitability depends on various factors, the purchasers of our products should determine for themselves whether the product is suitable for their particular use.