



**LACNAM PAINTS AUSTRALIA**  
ABN 48 125 092 482  
78-80 MANDOON, ROAD, GIRRAWEE, SYDNEY  
NSW 2145 AUSTRALIA  
TELEPHONE: (02) 9688 1999 FACSIMILE: (02) 9896 1606  
EMAIL: [sales@lacnam.com.au](mailto:sales@lacnam.com.au) WEBSITE: [www.lacnam.com.au](http://www.lacnam.com.au)

## TECHNICAL INFORMATION SHEET

# 314 DIPPING ENAMEL

May 2009

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### Description and uses:

314 Dipping Enamel is formulated on modified alkyd resins for use in dipping 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.
- Colour identification

### 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: 37 - 42 %

VOC: 550 gms/ltr. (Black).

COVERAGE: Approximately 10 - 12 Square metres per litre (at a D.F.T. of 30 microns).

RECOMMENDED FILM THICKNESS: 25-35 microns dry.

APPLICATION: Dipping.

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

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<b>APPLICATION DETAILS – PAINTING SYSTEMS</b>			
D.F.T. um			
System 1	1 <sup>st</sup> Coat	40-60	210 Metalprime (thinner T102 or T104)
	2 <sup>nd</sup> Coat	25-35	314 Dipping Enamel
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	25-35	210 Fidax RFU Black
D.F.T. um			
System 3	1 <sup>st</sup> Coat	25-35	314 Dipping Enamel
	2 <sup>nd</sup> Coat	25-35	Optional 314 Dipping Enamel

<b>APPLICATION DETAILS – SURFACE PREPARATION</b>		
SUBSTRATE	DETAILS	RECOMMENDED SYSTEM
Steel	Power tool clean to AS1627.2 class 2 or abrasive blast clean to AS1627.4 Class 2	1,3
Aluminum and non-ferrous metals	Light abrasive blast or treat with 212 metal clean.	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.
- Care must be taken to avoid contaminants (such as cement from scaffolding) entering dip tanks as alkyls can gel this product.

## Application Dipping:

- Dipping tanks should be mechanically agitated regularly for optimum performance and stability. Regular addition of stabilizers is recommended.
- As solvent evaporation will occur, viscosity should be monitored and thinners added as required.
- Reduction with thinners to achieve a suitable dipping viscosity must be performed and viscosity measured with a flow cup [25 -30 seconds @ 25°c].

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## **Application Spray, Brush & Roll:** As a Guide Use:

Brush or Roller - Suitable for small areas only. Use soft bristle brushes.

Conventional Spray - 1.5 -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

## **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](http://www.lacnam.com.au) for copy MSDS)

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