

SURFACE PREPARATION

New Aluminium or Galvanised Surface

The surface to be coated must be dimensionally stable, dry, clean and free of oil, grease, release agents, curing compounds and other foreign materials. All bare areas must be primed with suitable primer i.e. kem etch primer .

WARNING! If you scrape sand or remove old paint, you may release lead dust. LEAD IS TOXIC. EXPOSURE TO LEAD DUST CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE.

SPECIAL NOTES

- Thinner consumption may vary depending upon site conditions.
- Practical covering capacity depends on application techniques, ambient conditions, wastage, surface conditions etc.
- Spray application is the desired method of application .
- It should be recoated with primer coat before exposure preferably within 24 hours .
- Product doesnot hide the base metal but gives yellowish tinge . Do not build up thickness more than 10 microns . Excess deposition can result in loss of adhesion of primer to the metal surface.

DIRECTION FOR USE

Mixing Instructions:

This is a Two component product is mixed thoroughly till homogenous mixing. If the settling is observed, loosen the settled material with help of hand stirrer followed by power driven stirrer. For best results, use a spiral mixing blade at a variable speed (400-600 rpm). Place the spiral mixing blade at the bottom of the container before turning on the mixer. This will help to avoid inducting air into the material. Inducted air will cause "bubbles" in the coating when applied. Gently move the mixer head up to the surface while running. Do not remove the head while it is still spinning. Allow the combined material to sit for an induction time of 30 minutes, and then lightly stir again to ensure uniformity. This product has workable pot life 4-6 hours at ambient temperature. Applying the material immediately after the 30minutes induction time will provide best results.

Note: Higher air & mixture temperatures will decrease the pot life and working time.

Application Information :

Generally this paint is best applied by spray. Due to the rapid dry of this coating, only small areas may be coated by brush, applicator pad, or roller. Care must be taken to achieve the specified wet and dry film thicknesses. Uniform, even coats must be obtained. Large horizontal surfaces should be spray applied, however roller application can be performed.

Application Methodes :

- **Spray**– Use conventional spray.
- **Brush**- Recommended for all areas, care must be taken to achieve the specified DFT.

DIRECTION FOR USE

Application Equipment:

Conventional , brush or roller. Certain colors may require two coats depending on method of application and colour of the primer or intermediate coat.

Conventional Spray: Equipment Recommendations: Binks Model 62 Spray Gun or Equivalent

Fluid Nozzle	Air Nozzle	Atomizing Air Pressure	Fluid Pressure
0.040"	0.40"	45 psi	25 psi

Low temperature or longer hoses require higher pot pressure. Proper atomization is necessary to obtain smooth finish.

Roller: Use a ¼" nap synthetic cover. Do not use medium or long nap roller covers.

Clean Up Instruction:

Clean all equipment immediately after use with thinner T-1. At the same time , flush out all fluid lines and carefully clean pressure pots. Use clean solvent only. It is also good practice to periodically clean the spray tip or the fluid tip / air cap combination during the course of the working day or shift.

PERFORMANCE STANDARDS

Description	Test	Results
Adhesion	ASTM D 3359 Cross Cut Tape test	Excellent
Impact Resistance	ASTM D 2794 Gardiner Impact, 7 Day Air Dry at 25°C	Good
Flexibility	ASTM D 522 Conical Mandrel Apparatus	Passes
Chemical Resistance	2% NaOH	No Effect
24hr Covered Watch	1% H ₂ SO ₄	No Effect
Glass Spot Test	100% Mineral Spirits	No Effect
Salt Fog Resistance	ASTM B 117 Salt Spray Test	96hrs –No Effect
Immersion	Ambient	500hrs-No Effect
Graffiti Resistance	Crayon, Ink Pen, Marker, Shoe Polish	Good
Hot Water Immersion	80°C	100hrs-No Effect

ENVIRONMENTAL, HEALTH & SAFETY INFORMATION

DANGER! Flammable Liquid and Vapor. Harmful if Inhaled or Swallowed. **Contains: Mineral Oils, Synthetic Resins.** May affect the brain or nervous system causing dizziness , headache or nausea. Causes Eye, Skin, Nose and Throat irritation. May cause allergic skin reaction.

IMPORTANT: Before opening packages read all warning labels. Follow all precautions.

NOTICE: Repeated and prolonged exposure to solvents may lead to permanent brain and nervous system damage. Eye watering , headaches, nausea, dizziness and loss of coordination are signs that solvents levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. To avoid breathing vapors or spray mist, open window and doors or use other means to ensure fresh air entry during application & drying.

Keep away from heat, sparks and flame. Vapors may cause flash fire. **Use only with adequate ventilation.**

Do not breathe vapors, spray mist or sanding dust. Do not get in eyes or on skin.

FIRST AID: If affected by inhalation of vapors or spray mist . remove to fresh air. In case of eye contact , flush immediately with plenty of water at least for 15 minutes and call a physician for skin, wash thoroughly with soap and water. In case of ingestion – Do Not Induce Vomiting, get medical help immediately.



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