

Always use correct Personal Protective Equipment

# 626 SPRAYING ENAMEL

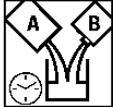
## Description



Spraying Enamel is a premium easy to use air dry, high gloss, high build alkyd enamel with excellent flow and durability.

Highly recommended for Automotive and Industrial finishes.

## Products



**Product Type:** Modified Alkyd  
**Colour:** Full range  
**Finish:** High Gloss  
**Pot Life:**

**Induction Time:** 5 Minutes If used with Enamel Add  
**Density:** 0.92-1.20 kg/L  
**Recommended DFT:** 50 microns  
**Theoretical Coverage:** 10 m<sup>2</sup>/L @ 50 microns DFT

## Properties



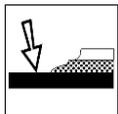
**VOC:** 428.37 g/L  
**Volume Solids:** 50%  
**Recoat-ability:** Following coats should be applied within one and a half hours of the preceding coat or after an interval of at least 24 hours as the partially cured film is subject to recoat fry and lifting between these times. Excessive film builds and cold temperatures may prolong the 24-hour period.

**Dry Time @ 20°C:** Dust free: 1 hour  
Tack free: 4 hours  
Recoat: 24 hours

The through drying properties of Spraying Enamel can be considerably improved by the addition of **Enamel Add** (Urethane Additive - contains isocyanate - refer data sheet).

The addition of 500 ml of Enamel Add per 4 litres of Spraying Enamel markedly increases through dry, gloss retention, mar and chemical resistance (refer data sheet).

## Substrates



Spraying Enamel can be applied over a variety of suitably prepared exterior and interior surfaces:

- O.E.M. finishes
- Refinished fully cured and dry paint systems
- Steel
- Aluminium and non ferrous metals

## Substrates

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- Galvanised steel
- Glass reinforced plastics (Fibreglass)
- Wood and MDF Board Composites

**Surface Preparation**



Strong emphasis that all surfaces to be painted should be clean, dry, free from all traces of contamination and well sanded. Do not apply to existing finishes, which are blistering, peeling, cracking, flaking or otherwise unsound. These must be completely removed and primed with suitable primer.

**Steel**

Where Grit media blasting is totally impractical the substrate should be cleaned with RALI Wax & Grease Remover, mechanically abraded and chemically treated with Rust Kill or Hydrafos to remove all rust and corrosion. Re-clean with Wax & Grease Remover (refer data sheets).

Prime with suitable primer from the RALI Range:

- **Industrial:** Maintenance Primer or Etch Primer (must be thoroughly sanded to ensure mechanical intercoat adhesion).
- **Automotive:** 81A 2K Etch Primer, SprayFilla, FM1 Primer (all must be thoroughly sanded to ensure mechanical intercoat adhesion).

**Aluminium**

Thoroughly clean with Wax & Grease Remover. Mechanically abrade with 320 grit abrasive paper or use 3M Nylon abrasive pads. Chemically treat with Hydrafos. Prime with Etch Primer or 81A-Two Pack Etch Primer (refer data sheets).

**Fibreglass**

Wash with warm detergent solution e.g. C-Power solution. Degrease with Wax & Grease Remover (refer data sheet). Abrade with 150-240 Wet & Dry paper. Prime with Durepox 2-Pack Primer (refer data sheets).

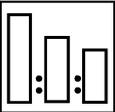
**Existing paintwork**

Wash with water and soap. Degrease with Wax & Grease Remover to remove all traces of oil, grease, silicone, wax and other contaminants. Painted surfaces must be thoroughly sanded with 240-320 W & D paper to remove all gloss. Prime sand through to timber, fibreglass or steel substrates, with Maintenance Primer.

Spot repairs and small sand through in the automotive industry can be spot or fully primed with Lacquer Primers, FM1 Primer, Sprayfilla.

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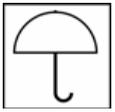
<b>Directions For Use</b> 	<b>Mixing Ratio:</b> If using Enamel Add - 500ml to 4L of Spraying Enamel.
	<b>Thinning:</b> 15 to 25% by volume with Spraying Thinner.
	<b>Application method:</b> Filter Strain all mixed product before application. Spray one light even coat and allow to dry for 15 minutes @ 20 deg followed by one or two medium coats allowing 15 minute flash off between coats. In the case of single layer metallic colours finish off with a light cross coat with the spray gun at a greater distance from the surface to improve metallic distribution and an even finish. Avoid heavy wet coats.
	<b>Clean up:</b> Spraying Thinner

**Note** *It is recommended to keep the job under cover particularly in wet weather until through hardening has taken place. A new film of enamel is easily water marked by rain and will lose gloss if caught by cold winds or frost. Do not attempt to wash with detergents or polish the painted surface unless thoroughly dry. A three to four week drying period is recommended in warm summer conditions.*

<b>Spray Equipment:</b> 	Compliant / Conventional Suction and Gravity feed  Tip size: 1.4 - 1.8 mm Air pressure: 300- 400 kPa (45- 60 psi)
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**Health & Safety**  

 For detailed information refer to Safety Data Sheets (SDS). Avoid breathing vapour. Wear protective mask and gloves. Ensure adequate ventilation. Flammable - keep away from sparks and flames. If eyes become contaminated flush with water for 15 minutes.

<b>Transport &amp; Storage</b> 	<b>Sizes:</b> 1L, 4L, 20L <b>Dangerous Goods:</b> 3Ab <b>UN:</b> 1263 <b>Hazchem:</b> 3[Y] <b>Packing Group:</b> III <b>Shipment name:</b> PAINT Flammable <b>Flash point:</b> 27°C
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