

PRODUCT DATASHEET

Vehicle and Machinery Enamel

PRODUCT INFORMATION

Reference Number:

97-LINE

Coating type:

Modified alkyd

Typical uses:

Finishing coat for vehicles, plant and machinery. This product is ideal for industrial and agricultural equipment.

Colours available:

All British and RAL shades available on DACMIX tinting scheme.

Appearance:

Gloss finish

Features and benefits:

- Excellent exterior durability
- Good resistance to oils, grease, and chemicals
- Non-yellowing
- Dries to a hard film
- Rapid drying
- Mild solvents

TECHNICAL INFORMATION

Theoretical coverage:

10m² per litre at 40 microns dry film thickness.

Film thickness:

	Wet film thickness	Dry film thickness
Typical:	100 microns	40 microns
Range:	75-125 microns	30-50 microns

Recommended primers:

Rapidac Metal Primer (13-LINE)

Dac Metal Primer: 1-6 (40-LINE)

QD AC Primer (98-LINE)

V.O.C.:

492g/m² EPA Method 24

460g/m² calculated from formulation to satisfy EU

Solvent Emissions Directive

May vary with colour.

% Volume solids:

40% calculated from laboratory formulation.

May vary with colour.

Drying time:

Temp.	Touch dry	Firm dry	Overcoat
5°C	150 mins	10 hrs	Overnight
10°C	120 mins	8 hrs	Overnight
15°C	90 mins	6 hrs	Overnight
20°C	60 mins	4 hrs	Overnight

Drying time will vary with temperature, air movement, etc.

Should a second coat of Vehicle and Machinery Enamel be required, this can be applied as soon as the first coat is touch dry, i.e. up to 1 hour – or allow coating to dry overnight.

SURFACE PREPARATION

Paint preparation before use:

Mix paint thoroughly by stirring and continually agitate the product, for homogeneity and consistency.

Mixing ratio by volume:

N/A

Surface preparation:

All surfaces to be coated should be clean, dry, and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000. The surface should also be suitably primed.

APPLICATION

Application conditions:

This material should preferably be applied at temperatures more than 10°C. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C spraying characteristics may be impaired.

Airless spray:

Tip size: 9-11thou (0.23-0.28mm)

Tip pressure: 2000psi (137bar)

Conventional spray:

Tip size: 55 thou (1.4mm)

Tip pressure: 40-60 psi (2.7-4.1bar)

Brush application:

No thinning required ready to use.

Thinning:

15% of Dacrylate Thinner R70 may be required when spraying the product to achieve optimum spray characteristics.

If the product needs to be thinned for brushing/rolling application then Dacrylate Thinner R1 is required.

Clean-up:

Clean all equipment after use with Dacrylate Thinner R1 or R70. Do not allow product to remain in hoses, guns, or spray equipment. All surplus product should be disposed of in accordance with appropriate regional regulations/legislation.

STORAGE AND PACKAGING

Storage:

Under cover within temperature range of 5°C to 32°C. Keep containers dry and tightly sealed to avoid moisture contamination.

Shelf life:

2 years in unopened containers when stored under cover within a temperature range of 5°C to 32°C or 'use by' date on packaging.

Pot life (at 20°C):

N/A

Packaging:

5 litre containers

HEALTH AND SAFETY

Please refer to the following data sheets:

97-LINE 10223 Vehicle and Machinery Paint (Unleaded)

97-LINE 10242 Vehicle and Machinery Paint (Leaded)

All work involving the application and use of this product should be performed in compliance with all relevant national, health, safety & environmental standards, and regulations.

ADDITIONAL NOTES

The application and spray information given above is intended as a guide only. As conditions vary from job-to-job, it is the applicators responsibility to ensure all equipment in use has been set up to give the best results.

Polychromatic colours such as RAL9006 and RAL 9007 may be susceptible to slight variations in colour depending on application methods and the type of paint. To obtain the best colour and appearance, these colours are best spray applied.

IMPORTANT INFORMATION

The information supplied in this product datasheet is not intended to be exhaustive. Any person using the product for any other purpose than that specifically recommended in this product datasheet, without first obtaining written confirmation from Dacrylate Technical Services as to the suitability of the product for the intended purpose does so at their own risk. All advice given about the product is correct to the best of our knowledge, however we have no control over the condition of the substrate, preparation or the many factors affecting the use and application of the product. Therefore, unless specifically agreed in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product.

Dacrylate warrants its products to be free from defects in material and workmanship. Dacrylate's obligations and buyer's exclusive remedy relating to the products shall be limited, at Dacrylate's option, to either replace the products not conforming the warranty or the credit of the buyers account in the invoiced amount of the non-conforming product. Any claim under this warranty must be made by the Buyer to Dacrylate in writing within five (5) days of the Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. The Buyer's failure to notify Dacrylate of such non-conformance as required herein shall bar the Buyer from recovery under this warranty.

The information detailed in this datasheet is liable to modification from time-to-time in the light of experience and our programme of product development. Before use, it is the customers responsibility to check with Dacrylate Customer Services, quoting the product reference number and version reference at the bottom of the data sheet, to ensure that they have in their possession the latest issue.

Technical product datasheets are available from our website at www.dacrylate.co.uk, and should be the same as this datasheet. Should there be any discrepancies between this document and the website version, then please contact Dacrylate Customer Services.

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