



TECHNICAL DATA SHEET

STOKES ACRYLIC TWIN PACK GLOSS TOPCOAT

Reference	Revision No	Revision Date	Printed	Page 1 of 2
ATP300	1	26 July 2007	1 September 2010	

WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
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Properties and Uses	<p>PROPERTIES Stokes Acrylic Isocyanate Free Twin Pack Paint, ready for use when base and activator are thoroughly mixed together. It gives good resistance to salt spray when applied over an epoxy primer, with excellent adhesion and flexibility.</p> <p>USES This paint system can be used for structural steel, industrial machinery, maintenance coatings and any item that requires a rapid drying, good colour retention, excellent long term durability and good chemical resistance.</p>
Technical Data	<p>TYPE Two Pack Acrylic / Epoxy based resin system with carefully selected pigments.</p> <p>DRYING TIME Within 20 minutes to BS3900 part C2, surface dry, under normal conditions of temperature and humidity. Recoatable overnight, or by 'wet on wet' application technique. Can also be force dried at 80°C for 30 minutes.</p> <p>MIXING RATIO 3:1,3.5:1 or 4:1 by volume Base:Hardener. Mixing Ratio is displayed on the Base tin.</p> <p>POTLIFE 8 Hours at 20°C</p> <p>THEORETICAL SPREADING CAPACITY Approximately 9 square metres per litre on smooth non porous surfaces to give a dry film thickness of 35 microns. Typical dry film thickness 30 - 40µ.</p> <p>FLASH POINT In the range of 21 - 55°C. FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT By volume 30% nominal. By weight 35% nominal. These figures will vary slightly depending on particular colours. Pastel shades can be up to 34% Volume Solids when mixed.</p> <p>THINNERS AND CLEANING SOLVENT Stokes Thinners Ref. TH095</p> <p>OIL RESISTANCE Good resistance to most hot and cold lubricating and cutting oils. Tests for suitability with any particular oil should be conducted before large scale application.</p> <p>LEAD CONTENT Some paints within this product range may contain lead based pigments. Please refer to labels on individual paint tins for Risk & Safety aspects of the paints.</p> <p>COLOUR RANGE Colours produced to meet customers specific requirements.</p>
Stock Container Sizes	<p>Composite Packs of 4 ,4.5 or 5 Litres. Bases are 3 ,3.5 or 4 Litres in 5 Litre tins. Activator is 1 Litre in a 1 Litre tin. Other sizes by special arrangement.</p>

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Processes	<p>PREPARATION</p> <p>The surface to be painted must be clean, dry and free from grease, mill scale, dust, dirt, rust, peeling or loose material or any other contamination. New, unpainted or very absorbent surfaces should be primed using Stokes Epoxy Zinc Phosphate Twin Pack Primer from the EP300 range (Refer to Stokes Technical Department). This product can be applied over a Zinc Rich Epoxy primer where extra protection is required.</p> <p>The Acrylic paint is supplied as a Two Pack material. Before use, pre-mix Base and Curing agent in the ratio as stated on the tins.</p> <p>FINISHING - Spray Application.</p> <p>One coat of the mixed material is satisfactory for most purposes, if a higher film thickness is required a second coat may be applied after the first coat is touch dry.</p>
Application	<p>IMPORTANT</p> <p>Clean out all spray equipment after use. If paint is left in equipment beyond its pot life it will become extremely difficult to clean.</p> <p>CONVENTIONAL SPRAY</p> <p>It is recommended that this top coat is applied by a pot gun or pressure pot type of application. It is essential to mix the Base and Curing Agent to the correct ratio as stated on the base tin.. It will be necessary to thin the mixed paint with between 10-20% of Stokes Thinners Ref. TH095.(see below)</p> <p>AIR ASSISTED SPRAY</p> <p>It is essential to thoroughly mix the Base and Curing Agent to the correct ratio as stated on the base tin.We recommend a maximum tip size of 11 thou.(see below). If applying by air assisted spray then the mixed paint must be thinned with at least 20% Stokes Thinners Ref. TH095.</p> <p>It is important to only apply thin coats of this product. Films in excess of 80-100 microns WFT may cause problems with blistering and paint runs.</p>
Storage	<p>Use within 12 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of Stokes Material Safety Data Sheets Ref.ATP300A & ATP300B)</p>
Health and Safety	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEETS REF. ATP300A AND ATP300B FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
Precautions in Handling and Use	<p>Avoid the inhalation of vapours and particulates by the provisions of good natural ventilation sufficient to keep air-borne concentrations below the Occupational Exposure Standards (OES) during the application and drying of paint films.</p> <p>Note: Occupational Exposure Standards are controlled by the Health and Safety Executive (HSE), reviewed annually and published as EH40.</p> <p>In operations where natural ventilation is insufficient to achieve this - e.g. painting work in enclosed areas - exposure should be controlled by the use of local exhaust ventilation. When this is not reasonably practicable, suitable respiratory protective equipment must be worn. For spray application or when OES's are likely to be exceeded, use the respiratory equipment as recommended in BS4275:1974. This specification gives advice on selection, use and maintenance of various types of breathing apparatus. Protect other persons in the area.</p>
Disclaimer	<p>The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.</p> <p>This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes & Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.</p> <p>R.J.Stokes & Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.</p>