



TECHNICAL DATA SHEET

COMPLIANT AIR DRY ONE COAT FINISH

Reference	Revision No	Revision Date	Printed	Page 1 of 2
CF	9	1 November 2011	1 November 2011	

WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
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Properties and Uses	<p>PROPERTIES High quality range of quick drying, anti-corrosive, one coat industrial semi gloss finishes for steel. Suitable for application by most types of spray equipment. (See application section for further details). Wet film thicknesses of up to 400 microns may be applied without sagging occurring. Finishes from this range of products meet the Process Guidance PG6/23(11) requirements for Volatile Organic Compounds (V.O.C.) for metal air drying topcoats.</p> <p>USES Air drying compliant finishes for use on industrial machinery, metal fabrications, castings, and a wide range of engineering articles, etc.</p> <p>CLASSIFICATION OF ENVIROMENTS EN ISO 12944-2 SPECIFICATION, Paints from this range comply to classification C1, C2 & C3 only.</p>
Technical Data	<p>TYPE Modified short oil length alkyd resin system containing zinc phosphate together with selected pigments extenders.</p> <p>DRYING TIME Surface dry within approx. 20 -30 minutes to BS3900 Part C2 under normal conditions of temperature and humidity handleable after 2 hours. These finishes may be re-coated with a second coat after allowing the first coat to dry for a minimum of two hours. Paints from this range may also be force dried for a maximum of 30 minutes at 50øC.</p> <p>THEORETICAL SPREADING CAPACITY Approximately 7.5 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 70 microns.</p> <p>FLASH POINT In the range of 21 - 55øC. FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT These figures will vary slightly depending upon the pigmentation but are nominally within the following ranges. By volume 48 - 52% By weight 63 - 67%</p> <p>VOLATILE ORGANIC CONTENT (V.O.C.) In the range of 400 - 419 gm/litre</p> <p>THINNERS AND CLEANING SOLVENT Stokes Thinner Ref. TH012.</p> <p>OIL RESISTANCE Good resistance to most hot and cold lubricating and cutting oils. Tests for suitability with any particular oil should be made before large scale application.</p> <p>SALT SPRAY & HUMIDITY RESISTANCE Resistance to hot salt spray ASTM B117 : Passes 500 hours. Resistance to humidity BS3900:G5 : Passes 500 hours.</p> <p>LEAD CONTENT Some paints within this range may contain lead based pigments. Please refer to labels of individual paints for Risk & Safety aspects of the paints.</p> <p>COLOUR RANGE Colours made to meet customer requirements.</p>
Stock Container Sizes	<p>20 litre containers. Other sizes by special arrangement.</p>

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Processes	<p>PREPARATION The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, and peeling or other loose / flaking material or any other contamination.</p> <p>FINISHING - Spray Application. One coat of a paint from this range is satisfactory for most purposes or a 'wet-on-wet' application technique may be employed if a higher film thickness is required. A second coat or a banding coat can be spray applied after 2 hours drying.</p> <p>FINISHING - Brush or Roller Application. Not suitable for painting large areas because of the speed of drying but could be used for 'touch-up' for damaged areas or for painting small articles. We do not recommend the application of a second coat of these paints to be applied by either brush or roller, if a second coat is applied by brush or roller allow the first coat to dry overnight to prevent bleed through.</p> <p>MASKING - After overnight drying using a low tack masking tape. SANDING - Best results for sanding are obtained after three days drying.</p> <p>TEST CONDITIONS - All drytimes and overcoat times tested at 70µ dry film thickness under normal conditions of temperature and humidity to BS3900 PART C. Note increasing the film thickness above 70µ will increase drytimes and overcoat times.</p>
Application	<p>CONVENTIONAL SPRAY. (suction or pressure pot feed) Supplied ready for use. Spraying pressure 55 - 65 p.s.i. Fluid tip size 1.8mm.</p> <p>AIRLESS SPRAY AND HOT AIRLESS SPRAY Supplied ready for use. Suggested airless spray pressure approx. 500 - 1000 p.s.i. Recommended spray tip size 15 thou.</p> <p>AIR ASSISTED AIRLESS SPRAY Supplied ready for use. Suggested air assisted spray pressure approx 500 - 1000 p.s.i. Recommended fluid tip size 15 thou.</p> <p>HOT SPRAY APPLICATION Suggested temperature of paint for hot spray 30 - 50°C. Do not heat above 50°C as this will reduce intercoat adhesion of a second coat, if this temperature is exceeded then sand back before applying a second coat.</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 Sheet Ref. CF).</p>
Health and Safety	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. CF FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</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>