



# TECHNICAL DATA SHEET

## STOKES MATT OCF - BRUSH GRADE

<b>Reference</b>	<b>Revision No</b>	<b>Revision Date</b>	<b>Printed</b>	<b>Page 1 of 3</b>
LE	3	2 November 2011	18 January 2012	

**WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899**  
**Little London Road | Sheffield | S8 0UH | Tel: 0114 258 9595 | Fax: 0114 250 9836 | Email: sales@rjstokes.co.uk**

<b>Properties and Uses</b>	<p><b>PROPERTIES</b> High quality range of quick drying, anti-corrosive, one coat industrial matt finishes for steel. Suitable for brush application and by most types of spray equipment. (See application section for further details). Wet film thicknesses of up to 250 microns may be applied without sagging occurring.</p> <p><b>USES</b> Air drying one coat finishes for use on industrial machinery, metal fabrications, castings, and a wide range of engineering articles, etc.</p>
<b>Technical Data</b>	<p><b>TYPE</b> Modified alkyd resin system containing zinc phosphate together with specially selected pigments extenders.</p> <p><b>DRYING TIME</b> Surface dry within approx. 1 hour 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 16 hours. Paints from this range may also be force dried for a maximum of 30 minutes at 50°C.</p> <p><b>THEORETICAL SPREADING CAPACITY</b> Approximately 7.5 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 50 microns.</p> <p><b>FLASH POINT</b> In the range of 21 - 55°C. FLAMMABLE LIQUID.</p> <p><b>NON VOLATILE CONTENT</b> These figures will vary slightly depending upon the pigmentation but are nominally within the following ranges. By volume 35 - 40% By weight 55 - 60%</p> <p><b>VOLATILE ORGANIC CONTENT (V.O.C.)</b> In the range of 450 - 500 gm/litre</p> <p><b>THINNERS AND CLEANING SOLVENT</b> Stokes Thinner Ref. TH010.</p> <p><b>OIL RESISTANCE</b> 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><b>LEAD CONTENT</b> All paints in this range are manufactured to no added lead formulations. <b>COLOUR RANGE</b> Colours made to meet customer requirements.</p>
<b>Stock Container Sizes</b>	<p>20 litre containers. Other sizes by special arrangement.</p>



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<p><b>Processes</b></p>	<p><b>PREPARATION</b>            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><b>FINISHING - Spray Application.</b>            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 16 hours drying.</p> <p><b>FINISHING - Brush or Roller Application.</b>            Suitable for painting large areas and can be used for 'touch-up' for damaged areas or for painting small articles. A second coat or banding coat can be brush or roller applied after 16 hours drying.</p> <p><b>MASKING -</b> After overnight drying using a low tack masking tape.  <b>SANDING -</b> Best results for sanding are obtained after three days drying.</p> <p><b>RECOMMENDED DRY FILM THICKNESSES</b>            RJ Stokes recommend a minimum dry film thickness (DFT) of 90µ is required to achieve the product's optimum anti-corrosive properties on unpainted mild steel.            Due to the application method by Brush/Roller it may be necessary to apply more than one coat to achieve the minimum dried film thickness.</p> <p>A typical DFT for this product is between 90 - 150 Microns.</p> <p>If the coating is used to overpaint units to change the colour which is mostly the case then the DFT is of less importance as the coating underneath already provides the substrate with the necessary protection.</p>
<p><b>Application</b></p>	<p><b>BRUSH OR ROLLER.</b>            Supplied ready for use.</p> <p><b>CONVENTIONAL SPRAY.</b> (suction or pressure pot feed)            Supplied ready for use.            Spraying pressure 55 - 65 p.s.i.            Fluid tip size 1.8mm.</p> <p><b>AIRLESS SPRAY AND HOT AIRLESS SPRAY</b>            Supplied ready for use.            Suggested airless spray pressure approx. 500 - 1000 p.s.i.            Recommended spray tip size 13 - 15 thou.</p> <p><b>AIR ASSISTED AIRLESS SPRAY</b>            Supplied ready for use.            Suggested air assisted spray pressure approx 500 - 1000 p.s.i.            Recommended fluid tip size 13 - 15 thou.</p>
<p><b>Storage</b></p>	<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. LE).</p>
<p><b>Health and Safety</b></p>	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. LE FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>



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### Disclaimer

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.

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.

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.