

STOKES QUICK DRYING SEMI-GLOSS ONE COAT FINISHES

Reference QS/QF	Revision No 2	Revision Date 10 July 1997	Printed 6 March 2008	Page 1 of 2
---------------------------	-------------------------	--------------------------------------	--------------------------------	--------------------

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

Properties and Uses	<p>PROPERTIES High quality, general purpose range of one coat industrial anti-corrosive semi-gloss finishes for steel. Dries within 30 minutes. Suitable for application by most types of spray equipment including electrostatic. (See application section for further details). Wet film thicknesses of up to 275 microns may be applied without sagging occurring.</p> <p>USES High build finishes for use on industrial machinery, metal fabrications, castings, and a wide range of engineering articles, etc.</p>
Technical Data	<p>TYPE. Short oil modified alkyd resin system containing zinc phosphate together with selected pigments and extenders.</p> <p>DRYING TIME. Within 30 minutes to BS3900 Part C2 under normal conditions of temperature and humidity. These finishes may be re-coated with a second coat of the same material by spray application only, 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 60°C.</p> <p>THEORETICAL SPREADING CAPACITY. Approximately 5 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 75 microns.</p> <p>FLASH POINT. In the range of 21 - 55°C. 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 36 - 38% By weight 50 - 55%</p> <p>VOLATILE ORGANIC CONTENT (V.O.C.) In the range of 540 - 560 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>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. White. Other colours by special arrangement.</p>
Stock Container Sizes	<p>20 litre containers. Other sizes by special arrangement.</p>
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.</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. When a further coating is required to be applied by brush or roller we suggest that a coat of either a Stokes Decorative Paint or Stokes Machinery Enamel Paint should be used.</p>



TECHNICAL DATA SHEET

STOKES QUICK DRYING SEMI-GLOSS ONE COAT FINISHES

Reference	Revision No	Revision Date	Printed	Page 2 of 2
QS/QF	2	10 July 1997	6 March 2008	

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

Application	<p>CONVENTIONAL SPRAY. (suction or pressure pot feed) Thin 5 - 10% by volume with Stokes Thinner Ref. TH012 Spraying pressure 55 - 65 p.s.i. Fluid tip size 1.8mm.</p> <p>AIRLESS SPRAY AND HOT AIRLESS SPRAY Supplied ready for use. Could be thinned slightly (maximum 10% by volume) if necessary with Stokes Thinners TH012 depending on the pump ratio and also the temperature of the paint in the hot spray equipment. Suggested airless spray pressure approx. 500 - 1000 p.s.i. Recommended spray tip size at least 13 thou. Suggested temperature of paint for hot spray approx. 60 - 70°C.</p> <p>AIR ASSISTED AIRLESS SPRAY Apply unthinned for hot spray application or if necessary could be thinned to a maximum of 10% by volume with Stokes Thinners Ref. TH012. Thinning will depend on the pump ratio of the spray equipment. Suggested air assisted spray pressure approx 500 - 1000 p.s.i. Recommended fluid tip size minimum 13 thou.</p> <p>ELECTROSTATIC SPRAY Adjust conductivity of the paint if necessary with Stokes Thinner TH009.</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.QS).</p>
Health and Safety	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. QS 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>