

600:333 ST1Kone

Key Features

- Single pack Aqueous Acrylic Matrix AC OCF
- Zinc phosphate anti-corrosive pigmentation
- Good adhesion to a wide range of substrates
- Fast dry and early water spot resistance
- Tough flexible exterior durable coating



Typical Uses

- Accommodation Units
- Steel fabrications
- Plant and machinery
- Waste Containers
- For airless spray application, plus brush roller
- For use where flammable solvents are not permitted

Technical Information

Gloss Level	Sheen
Volume Solids	45 ± 2% (dependent on shade)
Solids by Weight	58 ± 2% (dependent on shade)
Flash Point	Not classified as flammable
V.O.C.	83 g/l (dependent on shade and with water excluded from calculation)
Drying Times @ 20 °C.	Touch dry = 30 minutes Handle dry = 2 hours Full Cure = 7 days (times are quoted at 20 °C and will vary with film thickness, air movement, temperature and humidity)
Colours	Available in a wide range of colours including most British Standard and RAL Shades. Corporate, bespoke and other shades available by arrangement.
Packaging	5 litres and 20 litres.
Shelf Life	6 months in unopened containers when stored under cover within the temperature range 5-35°C.

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Application Guide

	Airless/ Heated Airless/Airmix	Brush/ Roller
Thinning	Ready for use. Thinning not required	5% clean water max if required
Tip Sizes	13-15 thou	N/A
Spray Pressure	120-140 bar 1700-2000 psi	N/A
Pot Life	Unlimited	Unlimited
Spray Viscosity	N/A	N/A
Number of Coats	1 (over a blast profile two coats will be required to achieve recommended dft)	1-2 (over a blast profile not recommended)
WFT per coat	100 microns	N/A
DFT applied at above WFT	45 microns 75 microns over blast profile	45 microns, may require two coats
Theoretical Coverage at above WFT	10 m ² /l	10 m ² /l will vary with WFT applied
Time between coats	30 minutes minimum	Approximately 3 hours

(practical coverage will be affected by surface profile, uneven application, overspray and losses in containers and equipment). Spray equipment details given are intended as a guide only. Fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen.

Application Process

Do not apply or dry when the air or substrate temperature is below 5 °C or in excess of 30 °C otherwise film appearance and coating properties may be adversely affected. Surface temperature must also be a minimum of 3°C above dew point. Outdoors preparation, painting and drying should only be undertaken during good weather conditions and never when rain is imminent or on days when a drop in temperature could result in condensation forming on the paint during the initial drying period or overnight. Maximum recommended relative humidity for application and drying should preferably not exceed 80%. Mix thoroughly before use. Best results will be achieved using a power mixer.

Airless, Heated Airless or Airmix spray systems- When changing over from solvent based paint systems flush all lines with 096:000:9999 Changeover solvent followed by clean water, (see 096:000:9999 data sheet for detailed instructions), before application to avoid 'throw out' and blocking of the filters. Using a brush to provide a 'strike coat' on difficult to reach areas such as internal welds, rough spots, bolts or corners before application of the spray coat is a good method of ensuring adequate build is achieved. One even coat applied in parallel passes, overlapping 50% on each pass to avoid bare areas, pinholes or holidays, at the stated WFT is satisfactory for most purposes. However, should additional coats be required for higher film builds or blast cleaned profiles these should be applied wet on wet after the surface is touch dry.

Brush or Roller- Apply by long haired brush or polyether foam roller with rounded edges. Care must be taken to ensure continuous wet edge to ensure uniform coat and prevent, "dragging", of the coating during application. An addition of maximum 5% clean water may be added to aid application and increase wet edge time.

Overcoating- Any time after initial touch dry, (approximately 30 minutes), if applying by airless spray. A minimum of 3 hours is recommended if applying by brush or roller.

Cleaning- Clean all equipment immediately after use with clean water and if required. 096:000:9999 Changeover solvent Ensure all lines, tips, etc. are thoroughly flushed out. It is not sufficient to leave equipment filled with water without a prior flush out.

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Substrates

Steel Fabrications- Once the surfaces to be coated are clean, dry and free from all contamination, grind down any sharp edges and shot blast to Sa2½ (as defined in ISO 8501-1) with an average surface profile of at least 50 microns. As an alternative to shot blasting, mechanically prepare the surfaces to St3-C or St3-D (as defined in ISO 8501-1). Painting should then be carried out within four hours of shot blasting.

Existing primer or finish- Remove loose flaky paintwork back to a firm edge. Ensure all surfaces are clean, dry and free from all contamination before abrading to give a surface with an adequate key. Particular attention should be applied to glossy substrates Apply the material to a small test area to ensure there are no adverse reactions with the existing coating before painting.

Failure to prepare the substrate adequately may result in poor intercoat adhesion, delamination of the coating and or other defects.

Health and Safety

See packaging label for relevant MSDS reference. Copies can be obtained by telephoning 01246 857777.

Test Results

When applied to a standard mild steel Q Panel @ a DFT of 100 microns and dried for seven days at ambient temperature: -

Flexibility	Pass- 6mm bend (test carried out in accordance with BS EN ISO 1519)
Scratch Resistance	Pass- 1200g (test carried out in accordance with BS EN ISO 1518)
Falling Weight (Impact resistance)	Pass- 1kg weight, height 1 metre, direct and reverse impact indentation 5mm ISO 6272-1-2011

Conformity

Defra Process Guidance Note 6/23(11) suitable for all registered processes

Contact to confirm specification.

The foregoing information is given in good faith on the basis of practical experience and extensive laboratory tests. Quoted figures are either theoretical values or typical of production batches. However, as we have no control over the conditions of application or the quality and standard of preparation of the substrate and the many other factors affecting the use and application of the product, the customer must determine the suitability of the delivered product for the intended application. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of this product or for any loss or damage arising out of the use of the product, or its use in conjunction with other manufacturer's product(s). Stir the paint well before use and always check the shade as no responsibility for a colour complaint is accepted after application. The information in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous improvement. For professional use only. 600:333 February 20.