

# APCOMIN INDUSTRIAL SYNTHETIC ENAMEL / APCOMIN 121

## PRODUCT DESCRIPTION

Single pack, air drying, high gloss alkyd finish paint

## FEATURES & RECOMMENDED USE

- General purpose enamel suitable for industrial atmospheric conditions
- Easy application by brush with good flow
- Can be applied over intact alkyd, epoxy and polyurethane coatings
- Good colour retention

## TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 28%
Recommended DFT / Coat	20 - 25 $\mu$ m
Theoretical Coverage Capacity	14.0 sq.mtr/ltr @ 20 $\mu$ m DFT 11.2 sq.mtr/ltr @ 25 $\mu$ m DFT
Drying time at 30°C	Surface Dry : 4 hours Hard Dry : 12 hours
Over coating interval at 30°C	Min. : 12 hours Max. : Unlimited, provided surface is dry and clean from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour and testing variances  
The volume solids indicated are as per ASTM D 2697 air drying method  
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.  
The information provided above is at 30°C and 65% relative humidity

## DIRECTIONS FOR USE

### Surface Preparation

#### General

- Suitable alkyd / epoxy primer or intermediate coat, dry and free from any contamination
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- In case of aged alkyd or epoxy coating, the surface should be sufficiently roughened if necessary

## Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

## Mixing

- If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Thinner should be added after mixing. Addition of excessive thinner will lead to reduced sag resistance

## Application

<b>Air Spray</b>	
Recommended thinner	T - 284
Volume of thinner	10 - 15% *
Nozzle orifice	1.5 - 3.0 mm
Nozzle Pressure	0.3 – 0.4 MPa (= approx. 3 – 4 atm; 43 – 57 p.s.i.)
Cleaning Thinner	T - 284
<b>Airless Spray</b>	
Recommended thinner	T - 284
Volume of thinner	0 - 5% *
Nozzle orifice	0.28 mm (11 Thou)
Nozzle Pressure	12 MPa (= approx. 120 atm; 1700 p.s.i.)
Cleaning Thinner	T - 284
<b>Brush / Roller</b>	
Recommended thinner	T - 284
Volume of thinner	0 - 5% *

*\*Note: Depending on recommended thickness & application condition*

## Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with thinner T -284. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

## Product Characteristics

- The product is not recommended for continuous immersion in water or continuous splash of water
- For Pastel/Lighter shades, two coats are recommended for better opacity
- The maximum performance is achieved after complete drying
- At higher relative humidity, drying may get retarded
- At higher DFT wrinkling of the surface will be seen

<b>PACK SIZE</b>	20 L
<b>STORAGE</b>	<b>Shelf Life:</b> At least 12 months at 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
<b>REGULATORY INFORMATION</b>	<b>Flash point:</b> Not less than 35°C <b>VOC:</b> 460 ± 50 gm/ltr (depending on shades) as per USA-EPA Method 24 <b>Product Weight:</b> Approx. 0.95 ± 0.06 kg/ltr (depending on shades)

## SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

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