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Date Issued: 10 November, 2009

XTREME ENAMEL

Product Line: 66; 67; 68.

Product Code: 66XX04; 66XX20; 67XX04; 67XX20; 68XX04; 68XX20 where XX represents digits for colour codes.

Description

Xtreme Enamel is a high gloss, lead-free, quick drying enamel having very good flexibility, water and petrol resistance. This line is particularly suitable for use on agricultural implements, general machinery and earthmoving equipment.

Type of Vehicle

Phenolic Rosin Modified Alkyd.

Typical recommended coating systems

Surface	Classification	Preparation	System		Dry Film Thickness	Recoat
Structural Steel	Value system	Abrasive blast clean to AS1627.4 Class 2	First Coat Top Coat	EasiSpray Metal Primer Xtreme Enamel	40 – 50 µm 30 – 35 µm	Min. 4 hrs
Mild Steel	Value system	Remove rust, clean and degrease with Wax & Grease Remover	First Coat Top Coat	EasiSpray Metal Primer Xtreme Enamel	40 – 50 µm 30 – 35 µm	Min. 4 hrs
Galvanised, zinc coated steel and aluminium	Value system	Clean and degrease with Wax & Grease Remover. Lightly abrade aluminium with a nylon scourer.	First Coat Second Coat Top Coat	Etch Primer EasiSpray Metal Primer Xtreme Enamel	5 – 10 µm 30 – 40 µm 30 – 35 µm	Min 2 hrs Min 16 hrs

Thin/ cleanup EasiSpray Metal Primer and Xtreme Enamel with Fast or Medium Thinners.
Thin/cleanup Etch Primer with Etch Primer Thinners.
Refer individual Technical Data Sheets/ MSDS for specific product above.

Surface Preparation

Steel

Excellent performances will be achieved by abrasive blast cleaning to AS1627.47 Class 2. However, good results can be achieved in mild exposure conditions on power or hand tooled cleaned surfaces to AS1627.2 or AS1627.7. Prime with Easi Spray Metal Primer to 40 - 50 microns.

Mild Steel

Remove light surface rust with a rust converter or clean and degrease with Wax and Grease Remover. Prime with Easi Spray Metal Primer to 40 - 50 microns. Wet sand with 320 grade paper if required.

Galvanised, Zinc Coated Steel, Aluminium and most non ferrous metals.

Clean with Wax and Grease Remover. Prime with Etch Primer to 5 -10 microns dry film thickness. Apply an intermediate coat of Easi Spray Metal Primer 30 - 40 microns. Wet sand with 320 grade paper if required.

Refinishing

Xtreme Enamel may be applied directly over sound aged lacquer or enamel finishes, which should first be cleaned with Wax and Grease Remover followed by a wet rub with 320 grade wet and dry paper. After water has been thoroughly dried off, the surface should be again cleaned with Wax and Grease Remover. Spot prime and undercoat bare areas as for new work.

Mixing Instructions

Stir thoroughly until uniform consistency.

Hardener Addition

Lux-Add Enamel Hardener can be added at 250ml per 4L or 1.25L per 20L. Mix until uniform consistency. Refer Product Technical Information Sheet.



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Application

Brush or Roller

Thinning not required, suitable for small areas only.

Airless Spray

Thin approx. 5 - 10%. Tip orifice 0.013" to 0.015". Apply at 14 to 17 Mpa atomising pressure.

Apply two coats allowing the first coat to tack off, to a dry film thickness of no more than 40 microns. First coat must be applied as a mist coat. Second coat applied as a medium coat. Subsequent coats can be applied 24 hours later if required.

Conventional Spray

Thin approx. 15%. Apply at air atomising pressure of 350 to 400kPa.

Apply two coats allowing the first coat to tack off, to a dry film thickness of no more than 40 microns. First coat must be applied as a mist coat. Second coat applied as a medium coat. Subsequent coats can be applied 24 hours later if required.

Do not apply Xtreme Enamel below 10°C or above 85% relative humidity.

Thinner and Cleaner

Superlux Medium or Fast Thinner.

Approximate Coverage

Practical at 40micron dft	Brush or roller	10.9m ² /L
	Airless spray	9.2m ² /L
	Conventional spray	7.8m ² /L

Properties

Colour:	White, Black and a full range of Colours. Note: Colours specified, as containing tint will change drying times depending on tint loading.
Gloss:	High Gloss.
Drying time:	Approximate air drying times at 25°C and 40 microns
Dust free:	10 - 15 minutes
Touch free:	20 - 25 minutes
Tack free:	45 - 60 minutes
Print free:	1.5 - 2.5 hours
Recoating Time:	24 hours
Solids:	By weight approximately 55% By volume approximately 40%
Weight per Litre:	Approximately 1.1kg.
Shelf life:	18 months
Flash Point:	28°C
Durability:	Very good gloss retention, chalking and checking resistance.
VOC:	Approximately 492 grams/ litre.
Resistance Properties:	
Abrasion:	Good
Heat:	Up to 120°C
Solvent:	Moderate.
Oil and Petrol:	Good to spillage.
Chemical:	Limited.

Precautions

Xtreme Enamel contains flammable solvents. Keep away from heat and open flame. When applying in a confined space, use an airline respirator. In common with other organic solutions Xtreme Enamel should not be allowed to remain on the skin and normal hygiene standards should be observed when using this product.