

SELECTION & SPECIFICATION DATA

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| Generic Type | Modified alkyd |
| Description | <p>A premium quality alkyd gloss enamel which is designed to protect and give good appearance to:</p> <ul style="list-style-type: none"> • Suitably primed mild steel and other metal surfaces • Tank exteriors • Bridges and pipes • Marine exterior areas such as freeboards, decks, houses, and superstructures • Marine interior areas such as engine rooms, passageways, and equipment • Farm equipment / restoration projects |
| Features | <ul style="list-style-type: none"> • Durable high gloss finish • Interior or exterior usage • Marine quality • Excellent weathering properties • Excellent flow and levelling • Good corrosion resistance in normal - mildly acidic fume areas • High hiding • Washable and scrubbable • Good abrasion resistance • Easy application by brush, roller, or spray • Safe – All colours lead and chrome free • Available with Ultra-Fresh Antimicrobial Additive where hygienic germ-free coating systems are required |
| Colour | <p>New Zealand: White, Black, Golden Yellow, and tintable to an extensive range of Resene, RAL, British Standards and AS 2700 colours. Custom (fleet) colours are also available on request</p> <p>Australia: White</p> |
| Finish | Gloss |
| Primer | Multi-Bond Primer, High Build Rust Barrier, Altra~Etch® or Pre~Fab |
| Dry Film Thickness | 40 - 50 microns 80 microns wet to obtain 40 microns dry |
| Solids Content | By volume 50% ± 1% |
| Theoretical Coverage Rate | 12.5 m ² /L at 40 microns Allow for loss in mixing and application. |
| VOC Values | As Supplied : 390 g/L |

SUBSTRATES & SURFACE PREPARATION

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|-------------------------|---|
| General | <p>All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application of Isotal Enamel. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.</p> |
| Steel | <p>Prime with specific primers – Refer to “Primers” section above. Isotal Undercoat applied to the primed surface will provide a sandable surface and will enhance adhesion on aged primers.</p> |
| Galvanised Steel | <p>Prime with Altra~Etch® then apply Isotal Undercoat. (refer to relevant data sheet for surface preparation guidelines)</p> |

SUBSTRATES & SURFACE PREPARATION

Wood | Prime with Multi-Bond Primer and/or Isotal Undercoat.
(refer to relevant data sheet for surface preparation guidelines)

MIXING & THINNING

Mixing | Stir thoroughly to ensure a homogeneous condition.

Thinning | The addition of up to 10% v/v Altex Thinning Solvent #45 (brush/roller application), or up to 15-25% v/v Altex Thinning Solvent #53 (spray) will enhance application properties.
Note: Excessive thinning can cause low film thickness, sagging and other film defects.
Use of thinners other than those supplied or recommended by Altex Coatings may adversely affect product performance and void product warranty, whether expressed or implied.

Ratio | N/A – single component coating

Pot Life | N/A

Accelerator | Enamel Quick Dry Additive is available to improve the cure rate in less than optimum conditions. Please refer to the relevant product data sheet.

- Accelerates the cure of enamel coatings.
- Depending on addition rate, will reduce dust free times by up to 50%.
- Increases hardness of the cured film.
- Reduces time to be able to mask out areas.
- May enhance both flow and final gloss levels

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General) | The following spray equipment has been found suitable.

Conventional Spray | 1.0mm to 1.4mm fluid tip with appropriate air cap.

Airless Spray | Pump Ratio 30:1
Material Hose 3/8" I.D min
Tip Size 0.015 – 0.019

(Note: The above is a guide. Other equipment to the above may be used.)

Brush & Roller (General) | Brush and roller application are acceptable if conditions are suitable, however, care must be taken to ensure the correct film build is applied.

APPLICATION CONDITIONS

| Condition | Material | Surface | Ambient | Humidity |
|-----------|----------|---------|---------|----------|
| Minimum | 10°C | 10°C | 10°C | 0% |
| Maximum | 32°C | 37°C | 35°C | 85% |
| Optimum | 16-24°C | 16-24°C | 16-24°C | 30-70% |

CURING SCHEDULE

| Surface Temp. | Dry to Handle | Dry to Recoat | Dry to Touch |
|---------------|---------------|---------------|--------------|
| 10°C | 24 Hours | 24 Hours | 6 Hours |
| 15°C | Overnight | Overnight | 4 Hours |
| 24°C | 12-18 Hours | 12-18 Hours | 2 Hours |

Curing schedule based on 40 microns DFT
Maximum self-recoat time: 14 days (without light sanding)

CLEANUP & SAFETY

Cleanup | Use Altex Thinning Solvent #45 or #53

Safety | For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label, and the Safety Data Sheet (SDS) for health and safety information prior to use.

Ventilation | It is very important for the safety of the applicator and the proper performance of Isotal Enamel that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry fresh air to remove all solvent vapours. Since solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating.

PACKAGING, HANDLING & STORAGE

Shelf Life | 48 months at 24°C

Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.

Shipping Weight (Approximate)
1L – 1.19 kg
4L – 4.76 kg
10L – 11.9 kg

Storage Temperature & Humidity | Optimum: 15-20°C

Flash Point (Setaflash) | 33°C

Storage | Store under cool, dry conditions.
Avoid large fluctuations between high and low temperatures.
Avoid the formation of condensate due to low temperatures.

WARRANTY

DISCLAIMER

The information in this datasheet is provided as a guide only and is provided without warranty, implied or otherwise. It is your responsibility to determine the suitability of any information or product for the use contemplated. Conditions of use, application and the substrate are beyond our control so no liability whatsoever (whether as to coverage, performance, injury or otherwise) is accepted for the information contained herein.

Data sheets may change from time to time and it is your responsibility to ensure you have the latest product datasheet and material safety data sheet from your supplier. Check the data sheet date with the listings at www.altexcoatings.com
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