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PRODUCT INFORMATION SHEET

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AUTO ENAMEL

Description

Motospray Automotive Enamel is a synthetic enamel based on high performance alkyd resins. *Auto Enamel* offers high gloss with outstanding flow properties. In addition specific modifiers resist mottling in auto enamel finishes, resulting in high gloss metallic films with an even metallic appearance.

Uses

Auto Enamel is intended for use as a commercial transport finish for applications to coaches, trucks, prime movers etc. *Auto Enamel* is also used for the respray of passenger automobiles. *Auto Enamel* is not intended for automobile repair or touch up. For this purpose use *Motospray Acrylic Lacquers*.

Properties

Outstanding gloss off the gun
Excellent flow properties
Tough, durable finish

Surface preparation

Feather edge all chips, scratches and repaired areas. Sand all parts that require painting. Rust should be removed by grinding and /or sanding. Bare metal areas and rusted areas that have sanded or ground should then be treated with *Motospray Deoxidiser and Rust Remover*. Apply two coats of *Motospray Enamel Primer Surfacer*, allow to dry overnight. Sand the primed surfaces with 600-800 wet or dry paper. Clean then degrease repaired area with *Motospray Prepwash*. Apply colour coats in accordance with instructions.

Thinning

Thin *Auto Enamel* with 10-15% *Motospray Enamel Thinner E250*. Where the area to painted is large (eg full respray) and where temperature is high (>25⁰), thin with 10-15% *Enamel Thinner E250 Slow* or *Mineral Turps*. The addition of *HiChem Enamel Hardener* may be made at the rate of 500ml per 4litres of unthinned *Auto Enamel*. The addition of *Enamel Hardener* is desirable under poor drying conditions to speed drying, increase gloss and also to increase chemical and mechanical resistance of the final dried film. The blend of *Enamel Hardener* and *Auto Enamel* has a useable life of approx. 6 hours at 20⁰C. Only mix enough for the job at hand.

Do not use acrylic or multipurpose thinners in *Auto Enamel* as this can cause wrinkling and reduce the appearance of the film.

UD01 Driers MUST be added to *Auto Enamel* colours made from the range of *Auto Enamel Tinters*.

Application

After thinning, spray out a small test area to check that colour match is acceptable before commencing full spraying job. For low coverage colours, first apply a coat of an appropriate high coverage colour such as white or black.

Apply one light dust coat and allow to dry for 5 minutes. Then apply 2 to 3 single coats allowing 10 to 20 minutes drying time between coats. In the case of metallic even out the metallic appearance by applying 1-2 light dust coats.

Recommended Dry Film Thickness is 40 microns. Do not exceed 75 microns total Dry Film Thickness.

<u>Gun Setups</u>	<u>FLUID TIP</u>	<u>AIR PRESSURE</u>
Suction Feed	1.4-1.8	310-420 kPa (45-60 psi)
Gravity Feed	1.1-1.4	310-420 kPa (45-60 psi)

Recoat: If additional coats are required, allow a minimum of 48 hours before applying *Auto Enamel* otherwise wrinkling or a delayed curing may occur.

DO NOT FORCE DRY.

In hot weather care should be taken to avoid the application of heavy coats as wrinkling may result.

Finished work should not be allowed to dry in the sun.

Cleanup

Use *Enamel Thinner E250 Slow*, *Enamel Thinner E250* or *Superglow Multipurpose Thinner*.

Drying Time

At 20°C and dry film build 40 microns.

Dust free - 1 1/2 hours.

Tack free - 3-4 hours.

Hard dry - 16 hours. It can be handled with care. Ready for tape.

Full cure - enamels continue to harden up to 4 weeks depending on temperature and film thickness.

A period of 4 weeks should be allowed before using detergent or polishing wax.

Do not allow contact with water for a period of 5 days.

Do not attempt to compound synthetic enamels

Storage

Store in a cool dry place. Always replace the lid securely after use.

Safety

See material safety data sheet

Coverage

Approx. 9 square meters per litre at 40 micron dry film thickness.

Product Codes

	<u>20 litre</u>	<u>4 litre</u>
Super White	SW20	SW4
Black	AEB20	AEB4
Tinters	E(No.)20	E(No.)4

Other colours may be available on request.

The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.