HiChem Industries Pty Ltd.
73 Hallam South Road Hallam, Vic 3803
Phone (03) 9796 3400 Fax (03) 9796 4500
ACN 006-542-767

PRODUCT INFORMATION SHEET

G:\SECURE\Product Information\INDUST\RAPID DRY ENAMEL.doc 22/03/02

RAPID DRY ENAMEL

Description:

A general purpose, very fast air drying spraying enamel based on a copolymer alkyd resin, exhibiting good exterior durability, corrosion resistance and gloss retention.

Uses:

HiChem Rapid Dry Enamel is intended for use where speed of dry is important. It can be applied on a variety of general metal surfaces, after application of a suitable primer or undercoat.
Typical uses are sheet steel, vehicle chassis, agricultural equipment, metal furniture, cabinets and electrical switchboards.
By the addition of *Universal Flatting Base* lower gloss finishes can be achieved.
Rapid Dry Enamel is not intended for automotive respray, repair or touch up. For this purpose use *Motospray Acrylic Lacquer* or *Motospray Automotive Enamel*.

Properties

- Very fast drying
- Outstanding adhesion
- Excellent gloss and colour retention
- Very good exterior durability

Suitable Substrates

After suitable preparation and priming, Rapid Dry Enamel may be applied to steel, galvanised steel, zinc coated steel, aluminium, and fibreglass. May be applied over the following primers-

Structural Primer 3240
Structural Primer 3250
Super Etch Primer
Enamel Primer Surfacer

Surface Preparation:

Remove rust and old flaking paintwork by wire brush, grinding and/or sanding. Treat rusted and bare metal areas with *Motospray Deoxidiser Rust Remover* or *Rust Converter and Primer/Sealer* as appropriate. Remove all the gloss from previously painted areas by sanding with 280-400grit abrasive paper. Clean surface with *HiChem Prepwash* to remove all traces of wax, grease, silicone, oil and dirt prior to applying primer or *Rapid Dry Enamel*.
Bare steel:. Clean and degrease thoroughly with *Prepwash.* Use *HiChem Structural Primer 3240* or *3250* or *Super Etch Primer*. Use *Motospray Enamel Primer Surfacer* if sanding is required.
Non ferrous metals: Substrates such as aluminium, zinc-alum, copper and galvanised steel should first be abraded using a non-metallic pad such as Scotchbrite. Clean with *Prepwash* wax and grease remover. Then apply *HiChem Super Etch Primer* . Use *Motospray Enamel Primer Surfacer* over *Super Etch Primer* if sanding is required.
Pre-painted surfaces : Can be applied directly to pre-painted surfaces in sound condition after flatting and cleaning with *Prepwash*.. If priming is desired use *HiChem Structural Primer 3240* or *3250.* Use *Motospray Enamel Primer Surfacer* if sanding is required.

Thinning:

Thin with 15-25% *HiChem Enamel Thinners E250*.
Use of *Universal Flatting Base* (see Product Information Sheet) may require a reduction in the amount of thinners added.

Application:

After thinning, *HiChem Rapid Dry Enamel* is applied as follows:
Apply one light even coat.
Apply 1-2 full coats with 5 minute air flash between coats depending on temperature.
Recommended wet film thickness is 70 micron, dry film thickness 25 micron.

Spray Gun setup	Fluid tip	Air Pressure
suction	1.8	310-420 kPa (45-60 psi)
gravity feed	1.5	310-420 kPa (45-60 psi)

Application viscosity : 15-17 seconds by Ford No. 4 Cup at 20°C.

Cleanup:

Use Enamel Thinner E250 or Reducer 285.

Drying Time :

At 20°C, dry film build 25 microns.

- dust free - 3-5 minutes.
- touch dry - 15 minutes.
- hard dry - overnight.

Note : Excessively thick films of *Rapid Dry Enamel* must be avoided or a permanently soft paint film may result.

Recoat Time

Can be re-coated up to 4 hours drying and again after 72 hours under normal ambient conditions. Re-coating should not take place in the period after 4 hours drying or before 72 hours drying as the paint film is at a sensitive stage and may react to over coating.

Coverage:

Theoretical 15 m^2 per litre at 25 microns dry film thickness.

Volume Solids: approx. 34 %v/v

Colours :

A range of standard factory made colours are available ex stock. We will do special colour matches but conditions apply. Contact our representative or our sales office for details.

Standard Packages :

Colours: 4 litres

Factory Colours :

Colour	Product Code
White	RDW
Black	RDB
Ford Tractor Blue	RDFTB
Golden Yellow Y14	RDY14
Caterpillar Yellow	RDCY
New Caterpillar Yellow	RDNCY
Mid Blue B15	RDMB
Signal Red R13	RDR13
Crimson (IHC/PO Red) R15	RDR15

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.