



304 EQUIPMENT ENAMEL

PRODUCT DESCRIPTION

Commercial Performance Coatings 304 Equipment Enamel is a single pack, general purpose spraying enamel based on a blend of alkyd resins.

It is a moderately fast drying, high gloss, hard and durable coating, suitable for all industrial applications and can be applied over most sound and properly prepared surfaces including metal and timber.

Commercial Performance Coatings 304 Equipment Enamel is available in a range of colours from the AS2700 and RAL Classic colour ranges.

For a more durable exterior, single pack topcoat finish, the product lines PET or ACE are recommended.

PRODUCTS

Equipment Enamel Mixed Colour		304
Reducers	<i>Normal conditions</i>	AER20 Alkyd Enamel Reducer Normal
	<i>Hot conditions</i>	AER30 Alkyd Enamel Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner
		AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Commercial Performance Coatings 304 Equipment Enamel can be applied over the following primers:

- EPS EtchPro Primer Surfacer, 426 EtchPro, 426 Vinyl Etch
- 411 Structural Primer, 425 Structural ZP Primer, 402 ZP Primer

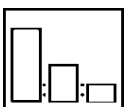


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

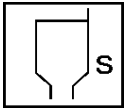
For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



PRODUCT	PARTS
304 Equipment Enamel Mixed Colour	100
Reducer	10 - 20%

SPRAY VISCOSITY



15 - 20 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 2 wet, even coats

Allow 10 - 15 minutes flash off between coats at 25°C

DRYING TIMES



AIR DRY (25°C)

- DUST FREE: 10 minutes
- TOUCH DRY: 30 minutes
- DRY TO HANDLE: 1 hour
- HARD DRY: Overnight

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT



Recoating should not be attempted after 4 hours drying and before 72 hours drying, as the enamel is then in a sensitive dry stage and may react to overcoating.

TOTAL DRY FILM BUILD

50 - 60 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	35 - 40%, depending on colour
COVERAGE	5.8 - 8.0 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Fair
ABRASION	Good
SOLVENT	Fair
CHEMICAL	Fair
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Not recommended

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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