

FAST ENAMEL

INTENDED USE

METAL FINISHING

A 2 to 3 hour dry high gloss enamel for application by spray, or brush on small areas. Particular benefits over other faster drying enamels are that it has a low odour, a longer wet edge, higher flash point, and can easily be re-coated.

Typical uses are for machinery, fixed plant, construction equipment, sheet metal and general fabrication work, and larger items which are painted in open shop conditions.

ARTICLES - that are not part of a building structure (and are therefore outside the scope of the building products VOC Product Directive)

Used as a fast drying refurbishment or maintenance brushing enamel for items such as :
INSIDE BUILDINGS Machinery, fixed plant, movable equipment, fork lift trucks, trolleys, frames, guards etc

OUTSIDE BUILDINGS Tanks, pipework, process plant, towers, bridges, or any structure which is not part of a building

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

SUITABLE SUBSTRATES AND PREPARATION

Surfaces must be dry sound and free from dirt, dust and grease.

For spray application prime with Manor Fast Primer or similar, and for brush application prime / undercoat with Manor Metal Primer or CV Primer Undercoat. Previously painted glossy surfaces should be lightly abraded prior to application to promote adhesion. Any non-ferrous metals must be pre-treated with Manor Wash Primer or Manor 1 Pack Etch Primer CT

AVAILABILITY

Gloss finish available in a limited range of popular colours stocked in 5 litre tins. An extensive range of BS, RAL and other colours are available from the MANORMIX Scheme. Semi-gloss and semi-matt finishes are also available to order.

PRODUCT INFORMATION (TYPICAL FIGURES)

Composition	Based on a medium oil alkyd resin, pigmented with suitably selected pigments.
Volume Solids	37%
Weight Solids	44 - 55%
VOC content	500 - 520 gm/litre.
Typical film thickness	30 microns dry or 80 microns wet.
Theoretical Coverage	12.5 sq. metres/litre at 27 microns dry film thickness.
Dry heat resistance	80°C
Flammable	HIGH FLASH - in the range of 32-55°C

APPLICATION DETAILS**PREFERABLY BRING PAINT TO 15-25°C AND STIR WELL BEFORE USE.**

Airless spray (hot or cold)	Ready for use, up to 5% thinners may be added to suit equipment. 11-13 thou. (0.28-0.33 mm) Typical fluid pressure 140 kg/sq. metre or 2000 p.s.i. Typical hot spray temperature 65-70°C
Conventional spray	Up to 15 % Thinners may be added to suit equipment. Apply two coats wet on wet at a viscosity of 40-50 secs BS B4 Flow Cup. May also be hot sprayed unthinned at 65-70°C.
Brush/Roller	Small areas only
Thinner	Industrial Thinner is recommended for wet on wet spraying and cleaning. Manor Low Odour White Spirit should be used when recoating recently applied or thick films, in order to prevent wrinkling

Film thickness per coat

	Dry	Wet
Minimum	25 microns	65 microns
Maximum	40 microns	110 microns

DRYING AND RECOATING**Approximate drying times**

<u>Substrate temperature</u>	<u>Touch dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10°C	4- 6 hours	24 hours	3 days
20°C	2-3 hours	12 hours	(see note)

Environmental Conditions

The air temperature should be at least 5°C with a surface temperature 3°C above dew point and the relative humidity below 90%. The drying times will be significantly extended in cold, damp conditions.

Overcoating/Repainting

If required, a further coat of Manor Fast Enamel may be applied wet on wet, or after 12 hours using Low Odour White Spirit as the thinner. Recoating between 2 and 12 hours may cause wrinkling. If left for more than 3 days between coats, it is important to lightly abrade the coating to ensure good intercoat adhesion. To repair runs and sags allow the first coat to dry such that the film can be lightly abraded to remove the defect, then leave the flatted surface to "heal up" overnight before re-coating using Low Odour White Spirit as the thinner.

SHELF LIFE

Store in cool, dry conditions, typically 5-25°C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

SAFETY PRECAUTIONS

REFER TO THE MANOR SAFETY DATA SHEET

FAST ENAMEL

Reference No. SPFE-7 ISSUED 03/2010
THIS DATA SHEET SUPERCEDES ALL PREVIOUS ISSUES