



# Implement Enamel

Durable alkyd topcoat for steel

1475 - line

## Description

- Acrylic-modified enamel for steel fabrications

## Properties

- High gloss
- Improved exterior durability compared with conventional quick drying enamels
- Extensive colour library and easy colour matching with Coloryte® Industrial Tint System

## Typical Applications

- Steel fabrications (tools, agricultural machinery, metal furniture, etc.)

## General Data

- Weather resistance Good; chalking may occur with lengthy exterior exposure, but film integrity should not be affected
- Solvent resistance Resists splashes of hydrocarbon solvents; not recommended for continuous immersion
- Chemical resistance Fair
- Abrasion resistance Fair
- Recommended primers Zinc Phosphate Primer, Rhinogrip® Etch Primer

## Specifications (at 25°C and 50% relative humidity)

- Resin type..... Acrylic-modified alkyd
- Typical solids content..... 35 - 40% (by volume)
- Typical film thickness (per coat)..... 25 microns (dry)  
75 microns (wet)
- Theoretical coverage..... 15m<sup>2</sup> / L @ 25 microns dry film thickness (dependant on colour)
- Heat resistance..... up to 120°C (dry heat)
- Touch dry..... 1 - 2 hours
- Hard dry..... 16 hours
- Recoating..... after 16 hours
- Gloss..... Gloss
- Colours..... Extensive colour library and easy colour matching with Coloryte® Industrial Tint System
- Shelf life..... minimum 12 months (in cool, dry conditions)

## Surface Preparation

- Bare steel surfaces should have rust and scale removed with abrasive paper or wire brush
- Wipe with clean solvent and rags to remove grease and any other residues

## Mixing recommendation

- Mix the entire contents of the can before decanting
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even consistency of the product
- Thin up to 15% by volume with Wagon Paints' T4 Enamel Thinner (see Application) and stir as above

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## Application

- May be spray applied using airless or conventional air spray equipment
- Small areas may be coated by brush (using T5 Mineral Turpentine as thinner)
- **Airless Spray** nozzle size.....0.33 – 0.38 mm  
nozzle pressure.....2000 – 2500 psi (14 - 17mPa)  
volume of thinner.....up to 5%
- **Air Spray** nozzle size.....1.6 – 2.0 mm  
nozzle pressure.....45 – 60 psi (300 - 400kPa)  
volume of thinner..... up to 15%
- **Cleaning solvent** .....T4 Enamel Thinner or T12 Gunwash

## Coating Systems

Substrate	Primer	Topcoat	Total film thickness ( $\mu\text{m}$ )
Mild Steel	Zinc Phosphate Primer	Implement Enamel	50 - 60
	Rhinogrip <sup>®</sup> Etch	Implement Enamel	40 - 50
Structural Steel	Shopprime	Implement Enamel	50 - 60
	Rhinoprime	Implement Enamel	50 - 60
Galvanised Steel	Rhinogrip <sup>®</sup> Etch	Implement Enamel	40 - 50
Aluminium	Rhinogrip <sup>®</sup> Etch	Implement Enamel	40 - 50

## Safety precautions

- **Refer to the relevant Material Safety Data Sheet**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

**Packaging Group II**      **UN No. 1263**

**Pack sizes**      4 litre, 20 litre

Authorised:      A. De Mello, Sales Manager

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These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



**Wagon Paints**

**5 Stephenson Road, Bayswater North, Victoria 3153 Australia**  
**Phone: 61 3 97291344 Fax: 61 3 97202179 Email: sales@wagonpaints.com.au**