

MACHINERY ENAMEL

PRODUCT CODE: PA 87

TECHNICAL DATA SHEET

Product Description	Premium quality high gloss air drying enamel.														
Intended Uses	<ul style="list-style-type: none">Specifically formulated for application to large earthmoving equipment.														
Features	<ul style="list-style-type: none">These products are designed to "stay open" to absorb overspray when spraying large areas such as graders, bulldozers, etc.Excellent durability and gloss.Good adhesion and flexibility.1987 Caterpillar Yellow (PA 87) is lead-free.														
Product Information	Appearance	High gloss													
	Colours	1987 Caterpillar Yellow (PA 87)													
	Generic type	Modified alkyd													
	Solvent type	Aromatic and aliphatic hydrocarbons													
	Solids	Approx. 45 – 49 % by mass; 35 % by volume													
	S G	0,97 (typical)													
	Viscosity at 23 °C	66 – 72 KU (typical)													
	Recommended DFT	Min: 25 µm, Max: 50 µm													
	Theoretical spreading rate	10 m²/L @ 35 µm DFT													
	Flash point	37 °C													
	VOC	471 g/L													
Application Details	Mixing	Stir thoroughly with a flat paddle until homogeneous.													
	Method	Spray application.													
	Thinning	For conventional spray thin to 16 - 25 seconds Ford Cup No. 4 with PLASCON FAST DRYING SOLVENT (PYY 1) or ENAMEL THINNER (TH 77) . For airless spray thin to 30 - 35 seconds Ford Cup No. 4													
	Cleaning	PLASCON FAST DRYING SOLVENT (PYY 1) ENAMEL THINNER (TH 77) or NO 40 LACQUER THINNERS (ILS 1)													
	Drying time	Touch dry: 2 h @ 23 °C Recoating: 8 h @ 23 °C Dry to handle: 8 h @ 23 °C													
	Application Environment	<table><tr><td>Surface Temperature</td><td>Ambient Temperature</td><td>Relative Humidity</td></tr><tr><td>Min: 10°C</td><td>Min: 10 °C</td><td>Min: 10 %</td></tr><tr><td colspan="3">or 3 °C min. above dew point</td></tr><tr><td>Max: 40 °C</td><td>Max: 40 °C</td><td>Max.: 85 %</td></tr></table>		Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10°C	Min: 10 °C	Min: 10 %	or 3 °C min. above dew point			Max: 40 °C	Max: 40 °C	Max.: 85 %
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Min: 10°C	Min: 10 °C	Min: 10 %													
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Max: 40 °C	Max: 40 °C	Max.: 85 %													
Storage and Packaging	Store away from direct sun, heat and severe cold. Packaging: 5 L, 25 L														

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Surface Preparation	<p>All mild steel surfaces must be clean, dry and free from dust, dirt, oil, grease or any other contaminants.</p> <ul style="list-style-type: none"> Remove oil, grease and dirt and any other contaminants with AQUASOLV DEGREASER (GR 1). Rinse thoroughly with clean water. Prime with COASTCOTE ETCH PRIMER SNK 2 RED OXIDE (SNK SERIES)
Application	<ul style="list-style-type: none"> Thin as recommended and apply by spraying. Apply a second coat if necessary to the required DFT.
Safety Precautions	<ul style="list-style-type: none"> Always keep paint out of reach of children. Ensure good ventilation during application and drying. If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. Harmful if swallowed. Seek medical attention and do not induce vomiting. Do not smoke while painting. Flammable. Store in a cool dry place away from heat and sparks. Refer to Safety Data Sheet for complete information.

DISCLAIMER:

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

NB: Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging and colour.

KANSAI PLASCON (PTY) LTD

10 Frederick Cooper Drive,
Factoria, Krugersdorp
South Africa
1739.
Tel: +27 11 951 4500
Fax: +27 800 110 932

PLASCON ADVISORY SERVICE: 0860 20 40 60

EMAIL: advice@kansaiplascon.co.za