

AQUADUO DIRECT-TO-METAL

PRODUCT CODE: PWI 500 Series & TWI Tint Bases

TECHNICAL DATA SHEET

Product Description	AQUADUO DIRECT-TO-METAL is a single pack direct to metal water-based coating.													
Intended Uses	For Direct to Metal application as a top coat on mild steel and galvanised iron.													
Features & Benefits	<ul style="list-style-type: none"> • Good anti- corrosive properties. • Single coat application as a top coat and primer when airless sprayed. • No Primer needed • Non-toxic pigmentation. 													
Product Information	<p>Appearance Colours Tint bases</p> <p>Generic type Volume Solids Recommended DFT Recommended WFT Theoretical spreading rate Practical spreading rate</p> <p>TVOC</p>	<p>Matt (gloss level may increase when tinting to bright/dark colours) White (PWI 501) Can also be tinted with INSPIRED COLOUR tints. Pastel Tint Base (TWI 1000), Deep Tint Base (TWI 2000), Transparent Tint Base (TWI 3000). Max 9 % Tinter allowed. Pure acrylic 31 % 50 – 60 µm per coat 161 – 194 µm per coat 5.6 m²/L at 55 µm DFT. This serves as a guide only. The practical spreading rate will vary depending on the porosity and profile of the substrate, as well as the application technique and tools used. 22.66 g/L</p>												
Application Details	<p>Mixing Method</p> <p>Thinning</p> <p>Cleaning Drying time</p> <p>Application Environment</p>	<p>Stir thoroughly with a flat paddle until homogeneous.</p> <p><u>Airless Spray</u>: Tip size 0.015 -0.017" Nozzle pressure 172 Bar (2500 PSI). <u>Conventional Spray</u>: Gun: De Vilbiss MBS or JGA: Fluid tip E (1.8mm). <u>Brush</u>: 30 – 40 µm DFT can be achieved (theoretical). <u>Roller</u>: 30 - 40 µm DFT can be achieved (theoretical).</p> <p>Not normally recommended. For conventional spray application thin to a max of 5 % with water.</p> <p>Water</p> <p>Touch dry: 60 mins @ 23 °C (50% RH) Over coating: 4 h @ 23 °C</p> <p>For optimum adhesion performance and corrosion protection, the product needs to dry @ 15 °C - 23 °C for 7 days or @ 50 °C for 24 h.</p> <table border="1"> <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>@23 °C - Min: 10 % Max: 85 %</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>@ 10 °C - Min: 10 % Max: 50 %</td></tr> </table>	Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10 °C	Min: 10 °C	@23 °C - Min: 10 % Max: 85 %	or 3 °C min. above dew point			Max: 40 °C	Max: 40 °C	@ 10 °C - Min: 10 % Max: 50 %
Surface Temperature	Ambient Temperature	Relative Humidity												
Min: 10 °C	Min: 10 °C	@23 °C - Min: 10 % Max: 85 %												
or 3 °C min. above dew point														
Max: 40 °C	Max: 40 °C	@ 10 °C - Min: 10 % Max: 50 %												
Storage & Packaging	<p>Store away from direct sun, heat and severe cold.</p> <p>Packaging: 5 L and 20 L</p>													
Tint Bases	<ul style="list-style-type: none"> • The tint bases and the colourants are unfinished or intermediate products which are not recommended for use by themselves. A finished product is only produced once the prescribed quantities of colourants have been thoroughly mixed with the tint base. • When mixed to a finished product its technical features, product information, application and surface preparation details comply with that of AQUADUO DIRECT-TO-METAL. • Only colourants from the PLASCON INSPIRED COLOUR system are permitted for use when tinting 													
Tinting Procedure	<ul style="list-style-type: none"> • Formulae for colours will be generated by the customer as per request from his customers. 													

AQUADUO DIRECT-TO-METAL

PRODUCT CODE: PWI 500 Series & TWI Tint Bases

Surface Preparation	<p>MILD STEEL:</p> <ul style="list-style-type: none"> The surfaces to be over coated must be clean, dry and free from contamination. Oil and grease should be removed using PLASCON AQUASOLV DEGREASER (GR 1) or REMOVAL HIGH STRENGTH DEGREASER (RCI 70.) followed by clean water rinses. Soluble chloride content may not exceed 75 mg per m². Dust and debris not to exceed 0, 3% when tested in accordance with SANS test method 769. Areas of breakdown, damage or weld seams should be prepared to the specified standard and patch primed with AQUADUO DIRECT-TO-METAL. The product must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be re-blasted to the standard specified above. Sweep blast on welded areas to remove any contaminants which could be obtained from welding. <p>GALVANISED IRON:</p> <ul style="list-style-type: none"> The surfaces to be over coated must be clean, dry and free from contamination. Preferred surface preparation is Sweep blast using Garnet Mica to achieve a blast profile of 20 – 30 µm. or if sweep blasting is not possible, clean the surface using METALCARE GALVANISED IRON CLEANER (GIC 1) and abrasive scouring pads. Rinse with clean water until a water break free surface is achieved. Soluble chloride content may not exceed 75 mg per m². Dust and debris not to exceed 0, 3 % when tested in accordance with SANS test method 769. Areas of breakdown, damage or weld seams should be prepared to the specified standard and patch primed with AQUADUO DIRECT-TO-METAL.
Application	<ul style="list-style-type: none"> Apply two coats of AQUADUO DIRECT-TO-METAL to achieve the recommended DFT allowing 4 h drying between coats.
Cautions	<ul style="list-style-type: none"> Do not apply at temperatures below 10 °C or if the temperature is liable to fall below 10 °C during the 4 h following or during wet weather conditions. In cool weather conditions allow additional drying time before over coating. Not suitable for use on aluminium surfaces.
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. Refer to Safety Data Sheet for complete information.

DISCLAIMER:

The recommendations contained herein are given in all 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.

N.B. 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, pack size and colour.

KANSAI PLASCON (PTY) LIMITED

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