

APCOMIN 140



PRODUCT DESCRIPTION

Single pack, air drying, general purpose, glossy DTM Enamel

FEATURES & RECOMMENDED USE

- General purpose direct to metal enamel suitable for interior and exterior use under industrial atmospheric conditions
- Ability to achieve higher film build per coat
- Used as self- priming top coat
- Easy application by brush and spray with excellent flow
- Excellent drying characteristics
- Good weather resistance
- Meets performance requirements of IS 2932 specification
- Optimum performance of coating is achieved in two coats at the DFT of 60 - 80 μm

TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 45 %
Recommended DFT / Coat	40-50 μm
Theoretical Coverage Capacity	11.25 sq.mtr/l @ 40 μm DFT 9.0 sq.mtr/l @ 50 μm DFT
Drying time at 30°C	Touch Dry : 1.5 hours hard dry : 5 hours
Over coating interval at 30°C*	Min 6 - 8 hours(dependent on application process/ DFT / System)
Shelf life (cool & dry place)	at least 12 months
Flash point	not less than 30°C

The data given is for guidelines only .The physical values are subject to normal manufacturing Tolerances, colour and testing variances

The volume solids indicated are as per ASTM D 2697 air drying method

The actual drying time/ over-coating interval may be shorter or longer depending on film thickness ventilation, humidity, temperature etc.

The information provided above is at 30 °C. and 65 % relative humidity

*Note : For Brush application, over-coating interval is minimum 16 hours.

DIRECTIONS FOR USE

Surface Preparation

General

- Steel : Blast cleaned to Sa 2.5 of Swedish specification
- If blast cleaning is impractical, remove loose rust / scale using power tools / hand tools to achieve St3/ St2 grade of surface preparation as per Swedish standards. Remove contaminants like grease, oil etc. using cleaning solvent. Ensure the surface is clean and dry before painting

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- If settling is observed in the drum, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Thinner should be added after mixing of paint. Excess addition of thinner will lead to reduced sag resistance

Application

Brush / Roller Recommended thinner Volume of thinner	T – 284 0 – 10% *
Air spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure	T – 284 5 – 20% * 1.50 - 3.0 mm 0.3 - 0.4 MPa (= approx 3-4 atm, 43-57 p.s.i.)
Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure	T – 284 0 - 5% * 0.28 mm (11 Thou) 12-15 MPa (1700-2100 p.s.i.)

**Note: Depending on recommended thickness & application condition*

Cleaning

- Do not allow product to remain in hoses, gun or spray equipment. Clean all equipment immediately using thinner T – 284. It is recommended to flush out spray equipment during the course of the working day. The frequency of cleaning will depend upon amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed off in accordance with appropriate regional legislation

Product Characteristics

- The product is not recommended for continuous immersion in water or continuous splash of water
- The maximum performance is achieved after complete drying of paint film
- At higher relative humidity and at lower temperature drying may get retarded
- At higher DFT, drying may get retarded and wrinkling will be observed

PACK SIZE	20 L
STORAGE	Shelf Life: At least 12 months at 30°C for original unopened pack, subject to inspection thereafter Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point: Liquid : Not less than 30°C ; Powder : Above 65°C VOC: 430 ± 30 g/ltr as per USA-EPA Method 24 Product Weight: 1.02 ± 0.10 kg/ltr (depending on shade)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection is always recommended while spraying paint
- Please refer our Material Safety Data Sheet prior to using the product

Disclaimer: To the best of our knowledge the information provided herein is true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product

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