

TECHNICAL DATA SHEET

ACE 23 – QD ANTI-CORROSIVE HIGH SOLIDS ONE COAT FINISH

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ACE23	1	16th February 2015	16th February 2015	

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Properties and Uses

PROPERTIES

High quality range of quick drying one coat industrial semi-gloss finishes with anti-corrosive properties, anti-sag properties and easy to apply with an attractive finish. Suitable for application by most types of spray equipment. (See application section for further details). Finishes from this range of products meet the Process Guidance PG6/23(04) requirements for Volatile Organic Compounds (V.O.C.) for metal processes.

USES

Air drying high solids finishes for use on industrial machinery, metal fabrications, castings, and a wide range of engineering articles, etc.

CLASSIFICATION OF ENVIROMENTS

EN ISO 12944-2 SPECIFICATION, Paints from this range comply to classification C1,C2 & C3 only .

Technical Data

TYPE

Modified alkyd resin system containing zinc phosphate together with selected pigments extenders.

DRYING TIME

Surface dry within approx. 30 -45 minutes to BS3900 Part C2 under normal conditions of temperature and humidity handleable after 3 hours. Paints from this range may also be force dried for a maximum of 30 minutes at 50°C.

FULL CURE - 7 days

OVERCOATING/REPAINTING

These finishes may be re-coated with a second coat after allowing the first coat to dry for a minimum of 3 hours. If overcoating takes place after several days then it is recommended to lightly abrade to improve inter-coat adhesion

THEORETICAL SPREADING CAPACITY

Approximately 7 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 75 microns.

RECOMMENDED FILM THICKNESS PER COAT

Minimum dry film thickness -60 microns (110 microns wet)
Maximum dry film thickness -120 microns (200 microns wet)

FLASH POINT

In the range of 21 - 55°C. FLAMMABLE LIQUID.

NON VOLATILE CONTENT

These figures will vary slightly depending upon the pigmentation but are normally within the following ranges.

By volume 53 - 56%
By weight 73 - 76%

CLEANING SOLVENT

ACE Thinner Ref. TH012.

OIL RESISTANCE

Good resistance to most hot and cold lubricating and cutting oils. Tests for suitability with any particular oil should be made before large scale application.

SALT SPRAY

Resistance to hot salt spray ASTM B117 : Passes 500 hours plus.

COLOUR RANGE

Colours made to meet customer requirements.

Stock Container Sizes

15 litre containers.
Other sizes by special arrangement.



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<p>Processes</p>	<p>APPLICATION CONDITIONS Do not apply when air or surface temperature is below 10°C. Application should not attempted in high humidity or when condensation is likely to occur (i.e. Surface temperature must always be a minimum of 3°C above dew point). Painting should only be carried out under good atmosphere conditions and clement weather. Painting and drying should <u>never</u> be undertaken when the air temperature falls below the minimum temperature for the coating, or during fog, mist, snow or when rain is imminent. Surfaces wet from condensation or when condensation is likely to occur during the drying process should not have paint applied to it.</p> <p>SURFACE PREPARATION Shot blasting is the preferred method of surface preparation. Painting should then be carried out within four hours. If oxidization has occurred before painting the surface should be re-blasted. If shot blasting is not practical then clean and degrease steel substrate, completely remove rust, burrs and oily residues. Sharp edges at welding seams should be ground down, weld spatter, dust, scale etc. should be removed. The resultant surface should be dry and free from contamination and dust.</p> <p>FINISHING - Brush or Roller Application. Not suitable for painting large areas because of the speed of drying but could be used for `touch-up` for damaged areas or for painting small articles. We do not recommend the application of a second coat of these paints to be applied by either brush or roller, if a second coat is applied by brush or roller allow the first coat to dry overnight to prevent bleed through.</p> <p>TEST CONDITIONS Drying times are quoted at 20°C under normal conditions, as the drying time depends on air temperature, air movement and relative humidity. Do not apply more than the recommended dry film thickness. As full cure of this coating will be dramatically retarded where there is excessive build and/or when application is at low temperatures.</p>
<p>Application</p>	<p>CONVENTIONAL SPRAY. (suction or pressure pot feed) Supplied ready for use. Spraying pressure 55 - 65 p.s.i. Fluid tip size 1.8mm.</p> <p>AIRLESS SPRAY AND HOT AIRLESS SPRAY Supplied ready for use. Suggested airless spray pressure approx. 500 - 1000 p.s.i. Recommended spray tip size 15 thou.</p> <p>AIR ASSISTED AIRLESS SPRAY Supplied ready for use. Suggested air assisted spray pressure approx 500 - 1000 p.s.i. Recommended fluid tip size 15 thou.</p> <p>HOT SPRAY APPLICATION Suggested temperature of paint for hot spray 30 - 40°C.</p>
<p>Storage</p>	<p>Use within 12 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of ACE Material Safety Data Sheet Ref. HS2007).</p>
<p>Health and Safety</p>	<p>THIS MATERIAL IS FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. HS2007 FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>

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Precautions in Handling and Use

Avoid the inhalation of vapors and particulates by the provisions of good natural ventilation sufficient to keep air-borne concentrations below the Occupational Exposure Standards (OES) during the application and drying of paint films.

Note: Occupational Exposure Standards are controlled by the Health and Safety Executive (HSE), reviewed annually and published as EH40.

In operations where natural ventilation is insufficient to achieve this - e.g. painting work in enclosed areas - exposure should be controlled by the use of local exhaust ventilation. When this is not reasonably practicable, suitable respiratory protective equipment must be worn. For spray application or when OES's are likely to be exceeded, use the respiratory equipment as recommended in BS4275:1974. This specification gives advice on selection, use and maintenance of various types of breathing apparatus. Protect other persons in the area.

Disclaimer

The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.

This Data Sheet supersedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of ACE Coatings Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.

ACE Coatings Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.