



TECHNICAL DATA SHEET

ACE 6 COMPLIANT QD HB ANTI-CORROSIVE 1 COAT FINISH

Reference	Revision No	Revision Date	Printed	Page 1 of 3
ACE6	1	23 October 2006	23 October 2006	

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Properties and Uses

PROPERTIES

High quality range of quick drying, anti-corrosive, one coat industrial gloss finishes for steel. Suitable for application by most types of spray equipment. (See application section for further details). Wet film thicknesses of up to 250 microns may be applied without sagging occurring. Finishes from this range of products meet the Process Guidance PG6/23(97) requirements for Volatile Organic Compounds (V.O.C.) for metal air drying topcoats.

USES

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

Technical Data

TYPE

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

DRYING TIME

Surface dry within approx. 20 -30 minutes to BS3900 Part C2 under normal conditions of temperature and humidity handleable after 2 hours. These finishes may be re-coated with a second coat after allowing the first coat to dry for a minimum of two hours. Paints from this range may also be force dried for a maximum of 30 minutes at 50°C.

THEORETICAL SPREADING CAPACITY

Approximately 7 sq. metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 80 microns.

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 nominally within the following ranges.

By volume 50 - 55%

By weight 60 - 65%

VOLATILE ORGANIC CONTENT (V.O.C.)

In the range of 400 - 419 gm/litre

CLEANING SOLVENT

Thinner Ref. ACE 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 & HUMIDITY RESISTANCE

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

Resistance to humidity BS3900:G5 : Passes 500 hours plus.

LEAD CONTENT

Some paints within this range may contain lead based pigments. Please refer to labels of individual paints for Risk & Safety aspects of the paints.

COLOUR RANGE

Colours made to meet customer requirements.

Stock Container Sizes

20 litre containers.

Other sizes by special arrangement.



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Processes

PREPARATION

The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, and peeling or other loose / flaking material or any other contamination.

Do not apply or dry when air or surface temperature is below 10°C or in high humidity or where condensation is likely to occur.

FINISHING - Spray Application.

One coat of a paint from this range is satisfactory for most purposes or a 'wet-on-wet' application technique may be employed if a higher film thickness is required. A second coat or a banding coat can be spray applied after 2 hours drying.

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.

MASKING - After overnight drying using a low tack masking tape.

SANDING - Best results for sanding are obtained after three days drying.

TEST CONDITIONS - All drytimes and overcoat times tested at 50µ dry film thickness under normal conditions of temperature and humidity to BS3900 PART C. Note increasing the film thickness above 50µ will increase drytimes and overcoat times.

Application

CONVENTIONAL SPRAY. (suction or pressure pot feed)

Supplied ready for use.

Spraying pressure 55 - 65 p.s.i.

Fluid tip size 1.8mm.

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.

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.

HOT SPRAY APPLICATION

Suggested temperature of paint for hot spray 30 - 50°C.

Do not heat above 50°C as this will reduce intercoat adhesion of a second coat, if this temperature is exceeded then sand back before applying a second coat.

Storage

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.).

Health and Safety

THIS MATERIAL IS FLAMMABLE. REFER TO ACE MATERIAL SAFETY DATA SHEET REF. CF FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.



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Precautions in Handling and Use

Avoid the inhalation of vapours 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.