

T & R WILLIAMSON LTD

A DIVISION OF THOMAS HOWSE LTD

MASTERCRAFT RANGE

HIGH SOLIDS ENAMEL

CAT NO: 43050

T D NO: 131



By Appointment
to HM The Queen
T&R Williamson Ltd
Manufacturers
of Coatings and Paints Ripon

TECHNICAL DATA SHEET

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PRODUCT FEATURES

Principally intended for application by brush, it can, if required be applied by spray.

THEORETICAL VOLUME SOLIDS:

55%

POT LIFE OF MIXTURE:

N/A

FLASH POINT:

Above 32-61°C

VOCs PER LITRE:



On average
300-400g/litre.
(Depending on colour.)

2004/42/II(d)420 The EU limit for this product category IIB(d) in ready to use form is a maximum of 420g/Litre.



DESCRIPTION

Mastercraft Enamel is a one component product formulated on an air drying long oil alkyd. Specially formulated to combine good flow, high opacity with a high-gloss finish.



SURFACE PREPARATION

Substrates: Recommended for use directly over any of the following products:

Transped FBRS Primer: 104 spray

Transped Fleetprime: 116 spray

Mastercraft ZP 100 ; 308

Transped Undercoat: 103 brush or spray

Previously painted surfaces in sound condition and suitably prepared

Ensure all surfaces are clean, dry and free from contaminants such as oil, grease, silicone etc.

If required primers and undercoats can be lightly denibbed using P600 grade paper or Scotchbrite.

Tac rag to remove dust before overcoating.

Previously painted surfaces must be abraded with P360 - P400 grade wet or dry or machine sanded using P220 - P320 grade grit discs to provide a matt keyed surface. Finally spirit wipe before painting.

Preparation: Ensure all surfaces to be undercoated are clean, dry and free from contaminants such as oil, grease, silicon, etc..



MIXING RATIO*

This is a one pack product. No mixing Required

*All pigmented fluid paints have a tendency to settle and separate over a period of time. In order to ensure that the paint is evenly dispersed before use it is essential that the material in the can is thoroughly hand stirred after opening. In difficult circumstances, the use of a mixing machine or mechanical stirrer will be more effective



SPRAYING VISCOSITY

22 - 25 Seconds *	reduce as necessary *
Conventional	Airless

*In a 4mm Flow Cup. (Spraying viscosity and thinning will depend on ambient conditions, spray equipment used and desired finish.)

SHELF LIFE

12 months from the date of manufacture, stored in original unopened container at a temperature between 10°C and 25°C

SPREAD RATE:

Approx. 20 m²/litre dependant upon application

EWC CODE:

08 01 11



METHODS OF APPLICATION

Method:	Brush	Conventional Spray	HVLP
Thinning:	Not Required	-----up to 5% Thinners -----	
Fluid:	N/A	-----Pressure feed-----	
Spray Gun Fluid Tip:	N/A	1.4 - 1.8 mm	FF 1.4 mm
Spray Gun Needle:	N/A	FF/EX	FF
Spray Gun Air Cap:	N/A	30	13
Air Pressure at the Gun:	N/A	55-60 Psi (3.8 - 4.2 Bar)	25 Psi (1.7 Bar)
Air Cap Pressure:	N/A	N/A	10 Psi (0.7 Bar)
Number of Coats:	1 full coat	Light coat - full coat to required thickness.	



THINNERS

Williamsons SR25 Thinners



DRYING TIMES

Touch Dry 5-6 hours Hard Dry 16 hours at 20C



RECOMMENDED FILM THICKNESS

Wet Film Thickness	50 Microns
Dry Film Thickness	25 Microns



CLEANING

Equipment Cleaning using Williamsons Gunwash
Gunwash Cat No: 3668900X85