

# T & R WILLIAMSON LTD

A DIVISION OF THOMAS HOWSE LTD

## RAIL SPEC TRANSPORT PAINT

## UNDERFRAME BLACK GLOSS FINISH

**CAT NO: 8109181291**

**T D NO: 291**



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

## TECHNICAL DATA SHEET

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Revised: 2021

### PRODUCT FEATURES

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

### THEORETICAL VOLUME SOLIDS:

50%

### POT LIFE OF MIXTURE:

N/A

### FLASH POINT:

Above 32°C

### VOCs PER LITRE:



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

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



### DESCRIPTION

Underframe Black Gloss Finish is a one component high build air drying modified alkyd finish. This product is specifically formulated to give a high build protective finish to rail vehicle underframes.



### SURFACE PREPARATION

Refer to the relevant vehicle maintenance painting schedule regarding vehicles previously coated with single component materials from standard CR/TT1081 or BR SPEC 81.

For further information refer to section on painting procedure.



### 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. 7m<sup>2</sup>/litre dependant upon application

## EWG CODE:

08 01 11



## METHODS OF APPLICATION

Method	Brush	Conventional Spray	Airmix Airless Spray	HVLP
Thinning	Supplied ready for use	Up to 5% SR 48	N/A	Up to 5% SR25
Number Of Coats	1 full coat	1 light coat 1 full coat	1 full coat	1 light coat 1 full coat
Spray Gun Fluid Tip	N/A	1.4mm	11-15 thou	FF 1.4mm
Fluid Feed	N/A	Pressure	1500-2000 psi/ 105-140 bar	Pressure
Air Cap	N/A	30	N/A	153/13
Air Pressure	N/A	55-60 psi / 4 bar	80-100 psi/ 5-7 bar	30 psi/ 2 bar gun-10 psi/0.7 bar
Recoat Time	6 hours at 20°C			
Intercoat Preparation	If required, this product's durability and colour can be enhanced by overcoating with a clear exterior body varnish such as 81/290.			



## THINNERS

N/A



## DRYING TIMES

6 hours Touch Dry, 16 hours Hard Dry



## RECOMMENDED FILM THICKNESS

Wet Film Thickness	200 Microns
Dry Film Thickness	90 Microns



## CLEANING

Equipment Cleaning using Williamsons Gunwash