

# T & R WILLIAMSON LTD

A DIVISION OF THOMAS HOWSE LTD

## MASTERCRAFT

## QD ENAMEL

CAT NO: 1202400E55/1254000E55

T D NO: 320



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

Application by most types of spray equipment.

### THEORETICAL VOLUME SOLIDS:

40%

### POT LIFE OF MIXTURE:

N/A

### FLASH POINT:

Above 32-61°C

### VOCs PER LITRE:



On average 522g/litre. (Depending on colour.)

2004/42/IIIB(c)540 The EU limit for this product category IIB(c) in ready to use form is a maximum of 540g/Litre.



### DESCRIPTION

Fast drying Styrene Modified Alkyd Finish, for application on plant and machinery where its fast drying properties may be an advantage. Obtainable in a standard range of colours plus specials to order.



### SURFACE PREPARATION

Previously Painted Surfaces in Sound Condition: Ensure the existing paint is compatible with the Speed Enamel. If in doubt test a small area. The surface must be thoroughly degreased and clean. Remove any loose paint or rust, etc., by scraping and/or abrading. Areas cleaned off to base metal must be spot primed before applying further coats of paint (see recommended primers).

Old painted and Corroded Steelwork: Refer to Primer Data Sheet.

New Steelwork: Refer to Primer Data Sheet.

Aluminium, Zintec and Galvanized Steel: Refer to Primer Data Sheet.

Recommended Primers:

Mastercraft Industrial ZP 100

Transped 100 Range FBRS Anti-Corrosive Primer: 104

For further information, refer to Technical Service Department.



### 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. 6 m<sup>2</sup>/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 SR10 Thinners



## DRYING TIMES

30 minutes Touch Dry, 4 hours Hard Dry



## RECOMMENDED FILM THICKNESS

Wet Film Thickness	150 Microns
Dry Film Thickness	60 Microns



## CLEANING

Equipment Cleaning using Williamsons Gunwash  
Gunwash Cat No: 3668900X85

To the best of our belief and knowledge the information given is true and accurate, but as conditions of use and any labour involved are beyond our control, the end user must satisfy himself by prior testing that the product is suitable for his specific application. Furthermore, no responsibility can be accepted or any warranty given by our representatives, agents or distributors. Products are sold subject to our standard conditions of sale and the end user should ensure that he has consulted our latest literature.



ISO 9001:2008  
FM 09513