T & R WILLIAMSON LTD

A DIVISION OF THOMAS HOWSE LTD

MASTERCRAFT

AC 100

CAT NO: 36540

T D NO: 308

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

Available in Red Oxide, White, Black and Grey with Satin finish when dry.

THEORETICAL VOLUME SOLIDS:

40%

POT LIFE OF MIXTURE:

N/A

FLASH POINT:

Above 23-32°C

VOCs PER LITRE:

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

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

DESCRIPTION

Mastercraft AC 100 is a single component anti-corrosive primer based on a chain stopped modified short oil alkyd resin combined with zinc phosphate inhibitive pigmentation. Available in Red Oxide, White, Black and Grey with a Satin finish when dry.

SURFACE PREPARATION

New Steelwork:
Ensure the surface is thoroughly degreased and clean before abrading to remove surface rust and 'key' the surface to improve adhesion. Complex structures may be more effectively cleaned and degreased by detergent pressure washing or steam cleaning. Allow to dry before further preparation or priming.

Old Corroded Steelwork:
Best prepared by grit blasting to a controlled surface profile of approximately 50-75 microns. To avoid early spot or flash rusting of exposed primed steel, it is essential that the primer is applied to give a dry film thickness of 2 times the blast profile peaks eg:

Peaks	-	50 microns
DFT even peaks	-	100 microns
Total DFT	-	150 microns

Aluminium, Zintec & Galvanised Steel:
Thoroughly clean and degrease using a suitable degreasing solution. Abrade the surface using 320 grit paper and finally spirit wipe. Apply 1 coat of Transpeed Two Pack Etch Primer 101 as an adhesion promoter.

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. 7 m^2/litre dependant upon application

EWC CODE:

08 01 11

METHODS OF APPLICATION

Methods:	Airless Spray	Conventional Spray	HVLP
Thinning:	N/A	Add up to 5% Thinners SR10	Add up to 5% Thinners SR10
Fluid:	N/A	Pressure Feed	Pressure Feed
Spray Gun Fluid Tip:	11-15 Thou	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
Pressure at the Gun:	N/A	55-60 Psi (4kg/cm^2)	25 Psi (1.7 Bar)
Pump Pressure:	1500-3000 Psi	N/A	N/A
Air Cap Pressure:	N/A	N/A	10 Psi (0.7 Bar)
Number of Coats:	1 full coat	Wet on wet to required Film Thickness	
Overcoating Times:	Air Dry - 1-2 hours dependant on DFT @ 20°C. For optimum finished appearance leave to dry longer Force Dry- 1x1 hour cycle in spraybake booth @ 60°C and allow to cool before proceeding		
Intercoat Preparation:	Lightly abrade with P600 paper or Scotchbrite to denib the surface if required. Finally 'tac rag' to remove residual dust. If this product is to be wet abraded, allow a minimum of 4 hours @ 20°C before overcoating.		
Protection:	Application of this product at a DFT of 100 microns will give optimum protection to new steel. On blast cleaned steel, the DFT should be twice the blast profile peaks, eg: Peaks - 50 microns DFT Overpeaks - 100 microns Total Dft - 150 microns To achieve the required DFT, additional coats may be necessary depending on the equipment used, spraying technique, substrate profile, etc..		

THINNERS

Williamsons SR10 Thinners

DRYING TIMES

30 minutes Touch Dry, 4 hours Hard Dry

RECOMMENDED FILM THICKNESS

Wet Film Thickness	100-200 Microns
Dry Film Thickness	40-80 Microns

CLEANING

Equipment Cleaning using Williamsons Gunwash

ISO 9001:2008
FM 09513