

## Water Based Dipping Enamel

### Production Description

Single pack quick drying water based dipping enamel based on Epoxy Ester and Styrene Acrylic copolymer emulsion use in dip in tank for coating all metal articles. It is fast drying with tough uniform coating.

### Areas of Application

For application of difficult structures like coils, tools, springs, pipe scaffoldings and sway bars Suitable for interior and exterior use.

### Technical Data

Colour	Standard colours
Viscosity	60-70 seconds
Toxicity	Dry film is not toxic
Thinning & Clean Up	Water. Up to 10% thinner can be used depending on weather conditions
Theoretical Coverage	8 sq.mtr / litre at 35 microns*
Drying Time (at 25 C & RH 60%)**	Touch dry: 30 mins ** / Recoat: 16 hours**
Specific Gravity	1.05 Kg/ litre
Gloss Level	Minimum 80% at 60 degrees
Packs available	1000, 200 and 20 litres (other sizes on request)

\*Practical coverage depends on surface profile, method of application and dry film thickness. Higher film thickness leads to lower coverage.

\*\* Cooler temperature, higher film thickness, or higher humidity conditions will lead to longer drying times

### Method of Application

Mechanically agitate dipping tank prior to and periodically during the coating process. Stabilizers may be added depending on the volume, weather conditions and time length of the process. Evaporation of the solvent is common test viscosity and add thinners as required. Test viscosity measured with a flow cup. Dipping viscosity to be at 60-70 seconds

### Surface Preparation

Apply primer after appropriate surface preparation. If required suitable undercoat may be used over primer. On galvanized surfaces, apply a coat of Omega Super Etch primer after proper surface preparation before applying Dipping Enamel.

Previously Painted: In case of previously painted surfaces, remove oil, grease and other contaminants by solvent cleaning. Ensure to remove all loose paint by scraping and thorough sanding.

Touch up bare metal areas with appropriate primer.

### Application

Stir the contents thoroughly before use. Add recommended water as per climatic condition and apply uniform coat. Second coat of Dipping Enamel if required can be applied after 8 hours drying of first coat.

### Mix and Colour Check

Mix the paint before application with a wide flat (25mm) paddle in a circular lifting motion from the bottom of the container for 5 minutes or until the paint and colour are thoroughly mixed. Remix the paint every 2 hours to ensure product consistency.

Check colour to the colour chart/standard prior to application. Inner mix multiple containers together to ensure colour consistency. Replace and secure container lid during painting to prevent the paint drying within the container.

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### Coating Maintenance

Washing the painted surface periodically will maintain the look of a newly painted surface longer. Clean the surface with a diluted sugar soap or a mild detergent and rinse well with clean water.

Do not use scouring pads, abrasive brushes, high pressure washing or solvent to clean the painted surface. These will damage the paint film and cause premature failure of the coating.

### Flammability & Transport Information

- Non-flammable.
- Ensure container is upright with lid secure.
- Ensure the container is secured in the vehicle for transport.

### Environmental

- Do not wash painting equipment and allow waste to enter drains and water ways.
- Do not dispose of unwanted paint and thinners that will enter drains and water ways.
- Refer to state / local EPA and council web sites for environmental and safe disposal details.

### Safety & Precautions

- Do not apply when surface temperature is below 10<sup>0</sup> C or over 35<sup>0</sup> C
- Do not apply in environments of high humidity/moisture, or if pending rain is a possibility.
- Apply in calm fine weather conditions and only during daylight hours.
- Cease painting 2 hours before sunset or if weather changes are forecast.
- Use only the recommended thinner for dilution and cleaning.
- Check paint colour to the colour chart/standard prior to application
- Provide adequate ventilation during use.
- Keep out of reach of children
- Avoid exposure of the new paint film to steam for 48 hours and to washing or scrubbing for 7 days.
- Check cross cut adhesion test of old coating before repainting.
- Apply a test sample for compatibility of this product over a small test area.

The technical information and suggestions for use and application are given in good faith. Since conditions of use are beyond the manufacturer's control, information contained herein is without warranty, implied or otherwise. The manufacturer does not assume any liability for any loss or injury resulting from the use of the product. Cooler temperature, higher film thickness and higher humidity conditions will require longer drying times