



SUBSTRATE: METALS – MILD STEEL

DESCRIPTION: UNIVERSAL HIGH GLOSS ENAMEL A CLASSICAL LONG OIL, ALKYD BASED, LONG-LIFE, HIGH GLOSS FINISH

SYSTEM TABLE

TECHNICAL DATA	1 ST COAT	2 ND COAT	3 RD COAT	4 TH COAT
PRODUCT NAME	UNIVERSAL RED OXIDE QUICK-DRYING PRIMER	UNIVERSAL HIGH GLOSS ENAMEL	UNIVERSAL HIGH GLOSS ENAMEL	
PRODUCT CODE	PRO00	ENM00	ENM00	
LIFE EXPECTANCY	2-3 YEARS	2-3 YEARS	2-3 YEARS	
WB/SB	SOLVENT BASED	SOLVENT BASED	SOLVENT BASED	
SMOOTH/TEXTURE	SMOOTH	SMOOTH	SMOOTH	
COLOUR	RED	WHITE & FANDECK	WHITE & FANDECK	
VOLUME SOLIDS %	68	46	46	
FILM BUILD	WFT 46 - 58µm DFT 35 – 45 µm	WFT 65 - 87 µm DFT 30 - 40 µm	WFT 65- 87µm DFT 30 - 40µm	
SPREADING RATE DFT	TSR 19m ² /lit @40µm PSR 11,2m ² /lit@40µm	TSR 13,1,/lit @35µm PSR 7,5m ² /lit@35µm	TSR 13,1m ² /lit@35µm PSR 7,5/lit@35µm	
DRYING TIMES @23°C	16 HOURS	16 HOURS	16 HOURS	
VOC % GRAMS PER LITRE	43,49 525,05	41,98 433,41	41,98 433,41	
CLEANING	MINERAL TURPS	MINERAL TURPS	MINERAL TURPS	



SURFACE PREPARATION METHOD STATEMENT

Rust Free

Surfaces must be clean, dry and rust free. Remove surface contaminants using a Degreaser, scrubbing with bristle brush or broom, or using Scotch Brite pads. Rinse thoroughly with tap water while brushing or hydroblast to remove all traces of the Degreaser to achieve a water break-free surface. Dry surface rapidly to prevent flash rust formation. Cleaned surface must be painted within 4 hours.

Rusted

After degreasing sand off rust with coarse emery paper or wire brush to ISO 8501 - 01 : 2007 - St3 to attain a bright metal finish. Remove dust.

Millscale & Rust

Alternatively, remove millscale and rust by abrasive blast cleaning to ISO 8501 - 01 : 2007 - Sa2½. Remove dust by vacuum cleaning. Prime within 4 hours.

APPLICATION METHOD STATEMENT

Apply 1x coat of [UNIVERSAL Red Oxide Quick-Drying Primer](#) at a minimum of 46 µm WFT allow 16 hours to dry at 23°C & 50% RH.

Apply 2 x coats of [UNIVERSAL High Gloss Enamel](#) at a minimum of 65 µm WFT per coat, allowing 16 hours drying between coats at 23°C and 50% RH

FOOT NOTES:

TSR	= Theoretical Spread Rate
PSR	= Practical Spread Rate
VOC	= Volatile Organic Compound
WFT	= Wet Film Thickness
DFT	= Dry Film Thickness
ERH	= Equilibrium Relative Humidity
RH	= Relative Humidity