

Stokes Low Odour OCF Matt (LE)

Product Description	A one coat* anticorrosive alkyd primer/finish (matt) for steel, for brush or spray application.				
Features & Use	<ul style="list-style-type: none">Designed for brush/roller or spray applicationContains zinc phosphate anticorrosive pigmentFor use on the refurbishment of modular buildings, for industrial machinery, metal fabrications, castings and a wide range of engineering itemsGood resistance to most hot and cold lubricating and cutting oils when fully cured. Tests for suitability with any particular oil should be made before large scale application				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	53 ± 2% (varies with colour)				
VOC Content	410 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	50 µm	106 µm	9.4 m²/litre	
	Maximum	100 µm	213 µm	4.7 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 70 microns DFT		+10°C	+23°C	+35°C
	Dust Free		2 hr	1 hr	45 min
	Hard Dry		4 hr	2 hr	1½ hr
	Overcoating	Minimum	24 hr	16 hr	12 hr
		Maximum	Indefinite if clean and sound		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	BS, RAL and shades to order				
Product Code	20LOE				
SG	1.30 kg/ltr (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Ideally blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns Where blast cleaning is not practicable, degrease overall and prepare any rusted areas to St2 minimum (ISO 8501-1:2007) without 'polishing' the steel surface 				
Mixing	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
Thinner / Cleaner	Axalta Thinner TH400 (formerly called No.3 Thinner)				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes*	Yes*	Yes	Yes
	<ul style="list-style-type: none"> Designed for application by brush or roller as supplied, for larger areas and smaller areas of touch up * For spray application, please consult Axalta Coating Systems for advice 				
Product Notes	<ul style="list-style-type: none"> Masking should be left until after overnight drying and use a low tack masking tape Best results for sanding are obtained after three days drying All paints in this range are manufactured to no added lead formulations A minimum dry film thickness of 90µm is required to achieve optimum anticorrosive properties on unpainted mild steel. More than one coat by brush or roller is likely to be required to achieve this minimum dft *Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, so that yellows, bright reds and oranges may not be suitable as one coat systems 				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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