Issue Date: Apr 2018
Reference: CE

Stokes Compliant OCF Matt (CE)

Product Description	**A one coat* anticorrosive alkyd primer/finish** (matt) for steel.
Features & Use	• Designed for airless spray application • Excellent build properties and hold-up on edges • Contains zinc phosphate anticorrosive pigment • For use on modular buildings, industrial machinery, metal fabrications, castings, and a wide range of engineering items • The white version can be used as a solar reflecting finish
Approvals/ Certification	Please consult Axalta Coating Systems
Finish	Matt / Eggshell
Volume Solids	46 ± 2% (varies with colour)
VOC Content	464 ± 20 g/litre (varies with colour)

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
Minimum	100 µm	217 µm	4.6 m^2/litre
Maximum	175 µm	380 µm	2.62 m^2/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 100 microns DFT		+10°C	+23°C	+35°C
Dust Free		1 hr	30 min	15 min
Hard Dry		4 hr	2 hr	1 hr
Overcoating	Minimum	4 hr	2 hr	1½ 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	**20COE** and **17COE**
SG	1.25 kg/lt (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

- 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

No.4 Thinner **Equipment Cleaner** No.4 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	No	Yes	Yes

- Airless Spray: output fluid pressure at tip 1500-2000 psi, Tip Size 13-15 thou (0.33-0.43 mm)
- Hot Spray Application: suggested temperature of paint for hot spray is 30-50°C. Do not heat above 50°C as this will reduce intercoat adhesion of a second coat. If this temperature is exceeded, sand back before applying a second coat.
- Conventional spray: airless spray is recommended as considerable thinning would be required for conventional spray and film build would be greatly reduced
- Application by brush/roller will result in a reduced film thickness and poorer cosmetic finish due to fast drying, and is recommended only for small areas of touch up/remedial work. Overnight drying should be left between coats applied by brush or roller to avoid pick-up

Product Notes

- Masking should be left until after overnight drying and use a low tack masking tape
- When fully cured, resists splashes of most hot and cold lubricating and cutting oils. Splashes should be immediately removed to prevent long term film damage
- *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.