

## Stokes Compliant OCF Matt (CE)

<b>Product Description</b>	<b>A one coat* anticorrosive alkyd primer/finish (matt) for steel.</b>				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Designed for airless spray application</li> <li>• Excellent build properties and hold-up on edges</li> <li>• Contains zinc phosphate anticorrosive pigment</li> <li>• For use on modular buildings, industrial machinery, metal fabrications, castings, and a wide range of engineering items</li> <li>• The white version can be used as a solar reflecting finish</li> </ul>				
<b>Approvals/ Certification</b>	Please consult Axalta Coating Systems				
<b>Finish</b>	Matt / Eggshell				
<b>Volume Solids</b>	46 ± 2% (varies with colour)				
<b>VOC Content</b>	464 ± 20 g/litre (varies with colour)				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	100 µm	217 µm	4.6 m <sup>2</sup> /litre	
	<b>Maximum</b>	175 µm	380 µm	2.62 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to 100 microns DFT		<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>
	<b>Dust Free</b>		1 hr	30 min	15 min
	<b>Hard Dry</b>		4 hr	2 hr	1 hr
	<b>Overcoating</b>	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					
<b>Colours</b>	BS, RAL and shades to order				
<b>Product Code</b>	<b>20COE and 17COE</b>				
<b>SG</b>	1.25 kg/lit (varies with colour)				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23-60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>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</li> <li>Ideally blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li>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</li> </ul>										
<p><b>Mixing</b></p>	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>										
<p><b>Thinner</b></p>	<p>No.4 Thinner <span style="float: right;"><b>Equipment Cleaner</b> No.4 Thinner</span></p>										
<p><b>Application Conditions</b></p>	<p>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.</p>										
<p><b>Application Methods</b></p>	<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th style="width: 20%;">Method</th> <th style="width: 20%;">Airless Spray</th> <th style="width: 20%;">Conventional Spray</th> <th style="width: 20%;">Brush</th> <th style="width: 20%;">Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>No</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>Airless Spray: output fluid pressure at tip 1500-2000 psi, Tip Size 13-15 thou (0.33-0.43 mm)</li> <li>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.</li> <li>Conventional spray: airless spray is recommended as considerable thinning would be required for conventional spray and film build would be greatly reduced</li> <li>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</li> </ul>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	No	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	No	Yes	Yes							
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li>Masking should be left until after overnight drying and use a low tack masking tape</li> <li>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</li> <li>*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</li> </ul>										
<p><b>Health &amp; Safety</b></p>	<p>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.</p>										

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