

## Stokes Compliant OCF Semi-Gloss (CF)

Product Description	A one coat* anticorrosive alkyd primer/finish (semi-gloss) for steel.				
Features & Use	<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>Resistance to hot salt spray ASTM B117 : passes 500 hours</li><li>Resistance to humidity BS3900:G5 : passes 500 hours</li><li>Good 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</li></ul>				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Semi-gloss				
Volume Solids	49 ± 2% (varies with colour)				
VOC Content	419 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	100 µm	204 µm	4.9 m²/litre	
	Maximum	175 µm	357 µm	2.8 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 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	20CFG				
SG	1.31 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				

## Stokes Compliant OCF Semi-Gloss (CF)

Issue Date: Apr 2018  
Page 2 of 2

<b>Surface Preparation</b>	<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>				
<b>Mixing</b>	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
<b>Thinner</b>	No.4 Thinner <b>Equipment Cleaner</b> No.4 Thinner				
<b>Application Conditions</b>	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.				
<b>Application Methods</b>	<b>Method</b>	<b>Airless Spray</b>	<b>Conventional Spray</b>	<b>Brush</b>	<b>Roller</b>
		Yes	No	Yes	Yes
<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>					
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>Masking should be left until after overnight drying and use a low tack masking tape</li> <li>Best results for sanding are obtained after three days drying</li> <li>Some paints within this range may contain lead based pigments. Please refer to labels of individual paints for Risk &amp; Safety aspects of the shades</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>				
<b>Health &amp; Safety</b>	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.				

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.