

Stokes Machinery Enamel

Product Description	An alkyd finish for metalwork.				
Features & Use	<ul style="list-style-type: none">Fast surface drying, good through-drying, good flow and levelling characteristicsResistant to splashes of Diesel after 7 days air dryingUse for constructional plant and machinery, tools, etc.Exhibits good weathering and anticorrosive propertiesOil resistant when cured				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	40 ± 2% (varies with colour)				
VOC Content	490 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	25 µm	63 µm	16.0 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 25 microns DFT		+10°C	+23°C	+35°C
	Dust Free		4 hr	2 hr	1 hr
	Hard Dry		24 hr	16 hr	8 hr
	Overcoating	Minimum	24 hr	16 hr	8 hr
		Maximum	Indefinite if surface is clean and sound		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	BS and RAL selected shades				
Product Code	20MAC-				
SG	1.10 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°C – 60°C				

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Surface Preparation	<ul style="list-style-type: none"> This product is a finish coat and should be applied over an appropriate primer and/or intermediate coat Ideally abrade old, sound coatings to provide a key All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination 				
Mixing	Must be mixed thoroughly before use. Agitate periodically to ensure paint remains homogeneous.				
Thinner	No.3 Thinner Equipment Cleaner 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"> Brush application recommended, use as supplied Thinning may required for spray application 				
Product Notes	<ul style="list-style-type: none"> Can be force dried for 20 minutes at 80°C Not recommended for immersion For best opacity use a primer or undercoat of a suitable shade 				
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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