

SERIES 5 FAST DRYING ONE COMPONENT ACRYLIC PAINT

June 2003

SPRAYLAT Series 5 is an automotive quality, one component, acrylic lacquer. It applies easily and dries in 15-20 minutes to a **DURABLE, FADE RESISTANT, SUPERIOR FINISH**. Series 5 may be used as an air dry lacquer or force dried through a low bake oven. **AVAILABLE IN ANY COLOUR OR GLOSS LEVEL**

This **COST EFFECTIVE, VERSATILE** paint may be used on **ALUMINIUM, STEEL, FOAMEX, MDF, VINYL, POWDER COATED SURFACES** and **ACRYLIC**.

When used to decorate aluminium or steel the minimum requirement is that the surface should be free of oil, grease and oxide before priming. Metal abrasion is recommended. Clean surface with Series 5 Cleaner. Series 5 Primer should be mixed 50:50 with Series 5 Activator and allowed to stand for 10 minutes. The Series 5 Primer will give a high build finish. Once the Primer is dry (within 10-20 minutes) the coloured component acrylic top coat may be applied. This high gloss finish may be adjusted with the addition of Gloss Modifier. The primer is not required when coating plastic surfaces.

Series 5 is sprayed using conventional spray equipment with recommended air pressure 60-80 psi and may be reduced with 5T Thinners between 30%-50% by volume. It can be recoated at any time without fear of loss of intercoat adhesion. The top coat will air dry within 10-15 minutes. If masking or immediate packing is required, the Series 5 top coat can be force dried for 30 minutes at 60°C/15 minutes at 80°C. Even though the surface may appear touch dry, do not apply vinyls until the paint has fully cured (ie by force drying or by leaving overnight in warm, ventilated conditions).

GLOSS MODIFIER - For best results pre-mix equal amounts of paint to Gloss Modifier and mix well. Then add balance of paint to achieve desired gloss level.

15-20% Gloss level	=	17% addition of Gloss Modifier
30-35% Gloss Level	=	10% addition of Gloss Modifier
40-45% Gloss Level	=	8% addition of Gloss Modifier
50-60% Gloss Level	=	4% addition of Gloss Modifier

Series 5 RETARDER - Due to the fast drying nature of the paint a 'dry edge' may be apparent under certain circumstances (ie. very warm conditions or when spraying large components). Drying time can be slowed down by adding 5-10% by volume Series 5 Retarder into the Series 5T Thinner before thinning the paint.

TECHNICAL DATA

	<u>Series 5 Primer</u>	<u>SPRAYLAT</u> <u>Series 5</u>
Mixing Instructions	1 part primer 1 part activator	30%-50% reduction with 5T
Pot Life	8 hours	12 Months
Application Method	Standard spray gun	Standard spray gun
Tape Time	N/A	4+ hours or force dry
Pencil Hardness	N/A	H
Gloss	N/A	High 85%
Gloss Retention	N/A	Excellent after 18 months in Florida
Flexibility	N/A	1/4" mandrel bend
Impact Resistance	N/A	40 lbs direct 10 lbs reverse
Graffiti Removal	N/A	Detergents
Water Resistance	Passes	Passes 48 hrs full water immersion with no loss of adhesion
Drying Time	15-20 minutes	Tack free: 10 mins. Dry to handle 20 mins
Force Dry	Air dry only	Force dry up to 60°C for 30 mins
Thinner	None	5T
Recommended Dry Film Thickness	1 mil/25 microns	1.0mil/25 microns
Coverage At Recommended Thickness	10 m ² /L	10m ² /L

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