

## TECHNICAL DATA SHEETS

### PERMOGLAZE 2 K ACRYLIC ENAMEL

<b>DESCRIPTION</b>	<p><b>Permolaze 2K Acrylic Enamel</b> is a two-component solvent-based hydroxyl-functional acrylated polyester cured with an aliphatic isocyanate hardener to produce a very durable, non-yellowing and chalking-resistant urethane polymer. It is designed for cross-linking at both room and low stoving temperatures. The system is primarily intended for use as a high-quality enamel for vehicle and industrial finish. It is also recommended as a marine paint.</p>	
<b>CHARACTERISTICS</b>	<ul style="list-style-type: none"> <li>• Cures to a hard-glossy film with good resistance to scratching and chipping</li> <li>• Good adhesion and abrasion resistance</li> <li>• Good gloss retention</li> <li>• Good resistance to aliphatic and aromatic solvents, ethanol, gasoline, diesel oil, brake fluids and lubricants</li> <li>• Resistance to diluted acids and alkalis</li> <li>• Suitable for all types of properly prepared and primed steel, wood, Profilage Sheets and glass reinforced polyester (GRP)</li> </ul>	
<b>SURFACE PREPARATION</b>	<ul style="list-style-type: none"> <li>• Surfaces must be dry and moisture content of surface should not be more than 10 % when measured with a moisture meter.</li> <li>• Surfaces must be free of dirt, dust, grease, oil and loose paint. <ul style="list-style-type: none"> <li><u>Mild Steel</u></li> <li>• Mild Steel substrates must be primed with <b>Permolaze Epoxy Zinc Chromate Primer</b> and overcoated with <b>Permolaze 2K Acrylic Enamel</b>.</li> <li><u>Galvanised Steel</u></li> <li>• Galvanised Steel substrates must be primed with <b>Permolaze 2 Pack Etch Primer</b> and overcoated with <b>Permolaze 2K Acrylic Enamel</b>.</li> <li><u>Wood Substrates</u></li> <li>• Wooden substrates must be primed with ICA PU Primer White 287.</li> <li><u>Glass-reinforced polyester</u></li> <li>• 1 coat of diluted <b>Permolaze 2K Acrylic Enamel</b> must be used as primer on <b>GRP</b>.</li> <li><u>Profilage Sheets</u></li> <li>• 1 coat of diluted <b>Permolaze 2K Acrylic Enamel</b> must be used as primer on uncoated profilage sheets and on previously painted profilage sheets, use <b>Altex Rust Bond Sealing Primer</b>.</li> </ul> </li> </ul>	
<b>APPLICATION</b>	Method	Air Assisted spray & Brush
	Thinning	<b>Permolaze 2K Acrylic Thinner</b>
	Dilution	Air Spray      Thin to 10-20% by volume
		Brush            5-10%
	Cleaning	<b>Permolaze 2K Acrylic Thinner</b>

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<b>PRODUCT INFORMATION</b>	<p>Finish Shades Mixing Ratio (volume)</p> <p>Pot Life Shelf Life Solid Content of Mix by Volume (undiluted) Spreading Rate/Litre Drying Time</p>	<p>Gloss&amp; Satin. White, Patel, Medium and Dark Base (3) Catalyst (1)</p> <p>± 2 hours at 25°C for 5 litres of mix ± 6 months in original non-opened containers</p> <p>8-10m<sup>2</sup> depending on surface profile, ambient conditions, dilution and application method</p> <p>Touch Dry ± 2 hours at 25°C in dry conditions Hard Dry ± 4 hours at 25°C in dry conditions Recoating Time 4 hours minimum (without sanding) at 25°C</p>
<b>PRECAUTIONS</b>	<ul style="list-style-type: none"> <li>• The air temperature must not be below 10°C and not higher than 35°C. Humidity must not be below 10% and not higher than 85%.</li> <li>• Base must be fully stirred before adding the hardener.</li> <li>• Thorough stirring is necessary after the components are mixed.</li> <li>• Cure is slow at low temperature.</li> <li>• To avoid films defects, wet film thickness should not exceed 75µm.</li> <li>• Heat increases reaction rate while shortening pot life and curing time.</li> <li>• Isocyanate hardener reacts with ambient moisture to form a hard-foaming mass.</li> <li>• Thinner used for dilution must not contain alcohols or water as contaminants. These will cause bubbles in the film and poor paint quality.</li> <li>• It is vital to apply these products in dry conditions and on dry surfaces to avoid poor adhesion and various film defects as Permolaze 2K Acrylic Enamel is moisture and water sensitive.</li> <li>• It is recommended not to over-dilute the product as this can affect the performance, thus causing the product to chalk.</li> </ul>	
<b>PACKAGING</b>	Available in 1, 5 & 20 litres	
<b>STORAGE</b>	Keep away from direct sun, sources of heat, flames or sparks.	

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#### SAFETY, HEALTH & ENVIRONMENT INFORMATION

- Highly inflammable.
- Keep away from heat, sparks and open flames.
- Handle with care
- Ensure good ventilation during application.
- In case of insufficient ventilation during painting, wear suitable respiratory equipment.
- Avoid contact with skin and eyes.
- If contact with skin occurs, wash well with soap and water.
- In case of contact with eyes, rinse immediately with plenty of clean water and seek medical attention.
- Keep out of reach of children.
- Do not use empty paint containers for storing foodstuffs.
- Do not throw paint containers or contents in the waterways or environment.
- Contains no added **Lead/Mercury/Nickel/Cadmium**.

For further information, kindly contact our Technical Information Service.

**Note:** This Technical Data Sheet is subject to change without prior notice.

#### DISCLAIMER

This data sheet is based on extensive lab tests and field use. However, if used under unspecified conditions, the performance of the product may differ. We can only guarantee the quality of the product as supplied in its original closed container.