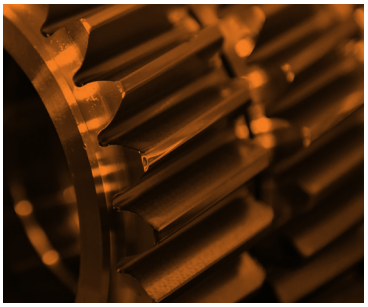
British Paints

Celebrating 100+ Years



Industrial Product Manual

LEAD CONTENT DOES NOT EXCEED 90PPM* For a Healthy Future *90 parts per million

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Industrial Range

TSA / STOVING COATING
Applications


E-Rickshaw


Fan


Cycles


Material Handling

EPOXY COATING
Applications


LPG Cylinders


CNG Cylinders


Pre-Engineered Buildings

POLYURETHANE COATING
Applications


Bumpers


Helmet


Bike

CONVENTIONAL COATING
Applications


LPG Cylinders


Special Purpose Vehicle


Tipper

VACUUM METALIZING COATING
Applications


Plastic Coating


Auto Headlight MS Coating


Vehicle with Headlight

COMPANY PROFILE

CELEBRATING 100+ YEARS OF DECORATIVE & INDUSTRIAL LEGACY

56+
Branch Offices

12K+
Channel Partners

50K+
Colors to choose from

OUR OFFERINGS

Comprehensive range of Environment-Friendly/Low VOC products for all substrates.

Architectural Coatings

Industrial Coatings

PRODUCT DATASHEET INDEX

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3. SUPRA STOVING ALUMINIUM PRIMER	2021-26
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RED OXIDE ZINC CHROMATE PRIMER (IS-2074)

A general purpose anticorrosive primer based on phenolated alkyd medium, Red oxide of Iron and Zinc Chromate pigment. The primer is suitable for steel and light alloys in mild to moderately corrosive atmospheres. It is compatible with a wide range of top coats, e.g.synthetic enamels, aluminum paints etc. It passes all test as per IS 101.

PRODUCT DESCRIPTION

Color :	That of Red Oxide
Finish :	Matt to Eggshell
Flash Point :	Above 30°C
Volume Solids :	45 ± 5 %
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	13-15 sqm per ltr.
Drying Time :	Surface dry - within 2 hours Hard dry - within 12 hours
Interval before overcoating :	Minimum 8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying ROZC primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
LPG Cylinders
Petrochemical Installations
Pipelines
Tank Farms
Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	RED OXIDE ZC PRIMER IS-2074	SYNTHETIC ENML AS PER IS-2932	SYNTHETIC ENML AS PER IS-2932
-do-	-do-	SYNTHETIC ENAMEL HR FINISH	SYNTHETIC ENAMEL HR FINISH
-do-	-do-	GLO/YAK/20-20 SYNTHETIC ENAMEL	GLO/YAK/20-20 SYNTHETIC ENAMEL

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

DISCLAIMER

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19-DDA, Comercial Complex, Kailash Colony Extension, Zamrudpur, New Delhi-110048

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Mail : industrial@britishpaints.in

Website : www.britishpaints.in

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RED OXIDE ZINC CHROMATE HR PRIMER

A general purpose anticorrosive primer based on phenolated alkyd medium, Red oxide of Iron and Zinc Chromate pigment. The primer is suitable for steel and light alloys in mild to moderately corrosive atmospheres. It is compatible with a wide range of top coats, e.g. synthetic enamels, aluminum paints etc.

PRODUCT DESCRIPTION

Color :	That of Red Oxide
Finish :	Matt to Eggshell
Flash Point :	Above 30°C
Volume Solids :	45 ± 2 %
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	16-20 sqm per ltr.
Drying Time :	Surface dry - within 1.5 hours Hard dry - within 12 hours
Interval before overcoating :	Overnight
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
LPG Cylinders

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	ROZC HR PRIMER	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL
-do-	-do-	ALUMINUM FINISH	ALUMINUM FINISH

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ALKYD ZINC PHOSPHATE PRIMER

A general purpose anticorrosive and air drying primer based on synthetic resin and rust inhibitive pigment zinc phosphate for using as an ideal primer coat for ferrous and non-ferrous metal surfaces, which remain, exposed to aggressive corrosive environment.

PRODUCT DESCRIPTION

Color :	Grey and Red.
Finish :	Matt to Eggshell
Flash Point :	Above 30°C
Volume Solids :	40 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	13-16 sqm per ltr.
Drying Time :	Surface dry - within 2 hour Hard dry - within 8 hours
Interval before overcoating :	Overnight.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying QDZP primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
Petrochemical Installations
Pipelines

Bridge

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	ALKYD ZINC PHOSPHATE PRIMER	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL
-do-	-do-	ALUMINUM FINISH	ALUMINUM FINISH

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.

3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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RED OXIDE ZINC CHROMATE- 74 PRIMER

A general purpose anticorrosive primer based on synthetic resins, Red oxide of Iron and Zinc Chromate pigment. The primer is suitable for steel and light alloys in mild to moderately corrosive atmospheres. It is compatible with a wide range of top coats, e.g. synthetic enamels,aluminum paints etc.

PRODUCT DESCRIPTION

Color :	That of Red Oxide
Finish :	Matt to Eggshell
Flash Point :	Above 30°C
Volume Solids :	30 ± 2 %
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	12-15 sqm per ltr.
Drying Time :	Surface dry - within 1 hours Hard dry - within 8 hours
Interval before overcoating :	Minimum overnight.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel

Mining and Machinery Industries

Petrochemical Installations

Pipelines

Tank Farms

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	RED OXIDE ZC-74 PRIMER	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL
-do-	-do-	ALUMINUM PAINT	ALUMINUM PAINT

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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ALKYD ZINC PHOSPHATE QUICK DRYING PRIMER

A general purpose anticorrosive and air drying primer based on specially modified quick drying resin and rust inhibitive pigment zinc phosphate for using as an ideal primer coat for ferrous and non-ferrous metal surfaces, which remain, exposed to aggressive corrosive environment with an advantage of its very fast drying character.

PRODUCT DESCRIPTION

Color :	Grey/Red.
Finish :	Matt to Eggshell.
Flash Point :	Above 26°C
Volume Solids :	45 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	15-18 sqm per ltr.
Drying Time :	Surface dry - within 1 hour Hard dry - within 6 hours
Interval before overcoating :	5 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
Petrochemical Installations
Pipelines

Bridge

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	QUICK DRYING ZINC PHOSPHATE PRIMER	SYNTHETIC ENAMEL / QD ENAMEL	SYNTHETIC ENAMEL / QD ENAMEL
-do-	-do-	ALUMINUM FINISH	ALUMINUM FINISH
-do-	-do-	GLO/YAK/20-20 SYNTHETIC ENAMEL	GLO/YAK/20-20 SYNTHETIC ENAMEL

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.

3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

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British Paints
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RED OXIDE ZINC CHROMATE QUICK DRYING HR PRIMER

A general purpose anticorrosive quick drying primer based on phenolated quick drying alkyd medium, Red oxide of Iron and Zinc Chromate pigment. The primer is suitable for steel and light alloys in mild to moderately corrosive atmospheres. It is compatible with a wide range of top coats, e.g. synthetic enamels, aluminum paints etc.

PRODUCT DESCRIPTION

Color :	That of Red Oxide
Finish :	Matt to Eggshell
Flash Point :	Above 26°C
Volume Solids :	45 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	15-18 sqm per ltr.
Drying Time :	Surface dry - within ½ hour Hard dry - within 4 hours
Interval before overcoating :	Minimum 2 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel

Mining and Machinery Industries

LPG Cylinders

Tank Farms

Cranes, Towers.

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Celebrating 100+ Years

SYNTHETIC ENAMEL PAINTS (IS-2932)

A glossy enamel based on synthetic resin vehicle and pigments, designed for decoration and protection, internally and externally. This is an ideal finishing paint for new and old metal, tobe applied over appropriate priming schemes. It passes all test as per IS 101.

PRODUCT DESCRIPTION

Color :	As per IS-5 shade card.
Finish :	Smooth and glossy
Flash Point :	Above 30°C
Volume Solids :	Minimum 35 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	11.67-14 sqm per ltr.
Drying Time :	Surface dry - within 4 hours Hard dry - within 12 hours Tack Free - within 24 hours
Interval before overcoating :	Minimum 12 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
LPG Cylinders
Petrochemical Installations
Pipelines
Tank Farms

Cranes, Towers.

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Celebrating 100+ Years

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A glossy enamel based on synthetic resin vehicle and pigments, designed for decoration and protection, internally and externally. This is an ideal finishing paint for new and old metal, tobe applied over appropriate priming schemes. It passes all test as per IS 101.

PRODUCT DESCRIPTION

Color :	As per IS-5 shade card.
Finish :	Smooth and glossy
Flash Point :	Above 30°C
Volume Solids :	Minimum 35 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	11.67-14 sqm per ltr.
Drying Time :	Surface dry - within 4 hours Hard dry - within 12 hours Tack Free - within 24 hours
Interval before overcoating :	Minimum 12 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel
Mining and Machinery Industries
LPG Cylinders
Petrochemical Installations
Pipelines
Tank Farms

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
-do-	RED OXIDE ZC PRIMER IS-2074	SYNTHETIC ENML AS PER IS-2932	SYNTHETIC ENML AS PER IS-2932
-do-	OTHER AIR DRYING PRIMER	SYNTHETIC ENML AS PER IS-2932	SYNTHETIC ENML AS PER IS-2932

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SYNTHETIC ENAMEL HR FINISH

A glossy enamel based on synthetic resin vehicle and pigments, designed for decoration and protection, internally and externally. This is an ideal finishing paint for new and old metal, to be applied over appropriate priming schemes.

PRODUCT DESCRIPTION

Color :	As per IS-5 shade & other shade card.
Finish :	Smooth and glossy
Flash Point :	Above 30°C
Volume Solids :	36 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	12-14 sqm per ltr.
Drying Time :	Surface dry - within 2 hours Hard dry - within 8 hours
Interval before overcoating :	6 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel

Mining and Machinery Industries

LPG Cylinders

Tank Farms

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	ROZC HR PRIMER	SYNTHETIC HR ENAMEL / GLO/YAK/20-20 ENAMEL	SYNTHETIC HR ENAMEL / GLO/YAK/20-20 ENAMEL
-do-	-do-	ALUMINUM PAINT	ALUMINUM PAINT

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SYNTHETIC ENAMEL QUICK DRYING HR FINISH

A glossy enamel based on quick drying synthetic resin vehicle and pigments, designed for decoration and protection, internally and externally. This is an ideal finishing paint for new and old metal, to be applied over appropriate priming schemes.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth and glossy
Flash Point :	Above 25°C
Volume Solids :	38 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	12.7-15.2 sqm per ltr.
Drying Time :	Surface dry – within 90 minutes. Hard dry - within 8 hours
Interval before overcoating :	Minimum 4 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner : BRITISH Thinner.

USES

General Structural Steel
Mining and Machinery Industries
LPG Cylinders
Petrochemical Installations
Pipelines
Tank Farms

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	ROZC QD HR PRIMER	SYNTHETIC ENAMEL QD HR FINISH	-
-do-	-do-	SYNTHETIC ENAMEL QD HR FINISH	SYNTHETIC ENAMEL QD HR FINISH

NOTES

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2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

DISCLAIMER

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Phone : +91-11-29240394

Mail : industrial@britishpaints.in

Website : www.britishpaints.in

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QUICK DRYING SYNTHETIC ENAMEL FINISH

This is a one component oxidatively quick drying alkyd coating, based on quick drying synthetic resin vehicle and pigments, designed for decoration and protection, internally and externally. This is an ideal finishing paint for new and old metal, to be applied over appropriate primer.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth and glossy
Flash Point :	Above 25°C
Volume Solids :	41 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	13.7-16.4 sqm per ltr.
Drying Time :	Surface dry - within 30 minutes. Tack Free – within 90 minutes. Hard Dry – 8 hours
Interval before overcoating :	Minimum 4 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Roller / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

General Structural Steel

Mining

Machinery Industries

Petrochemical Installations

Pipelines

Tower

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	QD PRIMER	QD SYNTHETIC ENAMEL FINISH	QD SYNTHETIC ENAMEL FINISH
-do-	EPOXY PRIMER	QD SYNTHETIC ENAMEL FINISH	QD SYNTHETIC ENAMEL FINISH

NOTES

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SYNTHETIC MONOCOAT FINISH

A general purpose air drying finish based on specially modified **quick drying** resin for using as an ideal **primer cum finish** for metal surfaces, which remain semi glossy to glossy with an advantage of its very fast drying character. It's a one coat system primer and finish.

PRODUCT DESCRIPTION

Color :	Standard shade.
Finish :	Semi Glossy to Glossy.
Flash Point :	Above 25°C
Volume Solids :	53 ± 2 %
Indicated dry film thickness :	70 ± 5 µm /Coat
Theoretical Covering Capacity :	7-8 sqm/ltr @ 65-75µm dft/coat.
Drying Time :	Touch dry - within half an hour. Tack Free - within 4 hours. Full Cure - within 7 days.
Interval before overcoating :	None or as per desired specifications.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying coating.

APPLICATION DETAILS

Method of application : Airless Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.
(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH thinner.

USES

Genset structure
Pre engineering building
Crane
Tower
Other specified area

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	QUICK DRYING MONOCOAT FINISH	NA	NA

NOTES

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G.P. ALUMINIUM PAINT

Good aluminium lustre, good durability and corrosion resistance are the main properties of aluminium paint. It is supplied in a dual pack system where the paste and medium are packed separately in the same container. G.P. Aluminium paint is fast drying and has good adhesion, hardness and flexibility and also good water resistance.

PRODUCT DESCRIPTION

Color :	Aluminium
Finish :	Smooth & Al. Lustre
Flash Point :	Above 30°C
Volume Solids :	18 ± 2 %
Mixing :	Aluminium paste and medium supplied in proportionate quantities. Mix the contents throughly and stirr well before and during application. Mixed paint to be used off within 24 hours to maintain uniformity in lustre.
Recommended dry film thickness :	10-12 µm per coat
Theoretical Covering Capacity :	15-18 sqm per ltr.
Drying Time :	Surface dry - within 2 hours Hard dry - within 12 hours
Interval before overcoating :	Minimum 8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before painting.

APPLICATION DETAILS

Method of application:	Brush / Spray.
Recommended Thinner:	BRITISH thinner.

USES

General Structural Steel

Railway Wagons

Electrical Transmission Towers
Pipelines, Oil Tanks, Fences.

MS Gates and Fences

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	ROZC PRIMER	G.P. AUMINIUM PAINTS	-
-do-	-do-	G.P. AUMINIUM PAINTS	G.P. AUMINIUM PAINTS

NOTES

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SUPRA ALUMINIUM 250°C PAINT

Good aluminium lustre, good durability and corrosion resistance are the main properties of aluminium paint. It is supplied in a dual pack system where the paste and medium are packed separately in the same container. It is fast drying and has good adhesion, hardness and flexibility, good water resistance and heat tolerate upto 250°C.

PRODUCT DESCRIPTION

Color :	Aluminium
Finish :	Smooth & Al. Lustre
Flash Point :	Above 30°C
Volume Solids :	34±2 %
Mixing :	Aluminium paste and medium supplied in proportionate quantities. Mix the contents throughly and stirr well before and during application. Mixed paint to be used off within 24 hours to maintain uniformity in lustre.
Recommended dry film thickness :	15-20 µm per coat
Theoretical Covering Capacity :	17-22 sqm per ltr.
Drying Time :	Surface dry - within 2 hours Hard dry - within 12 hours
Interval before overcoating :	Minimum 8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 250°C (Continuous).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before painting.

APPLICATION DETAILS

Method of application :	Brush / Spray.
Recommended Thinner:	BRITISH thinner.

USES

General Structural Steel

Railway Wagons

Electrical Transmission Towers

MS Gates and Fences

Pipelines, Oil Tanks, Fences.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	SUPRA ALUMINIUM 250°C PAINT	SUPRA ALUMINIUM 250°C PAINT	-

NOTES

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SUPRA EPOXY PRIMER

It is two pack high performance polyamide/polyamine cured epoxy primer containing special anticorrosive pigment. It has excellent adhesion to steel and suitably treated light alloys. It cures to a tough and high rust preventive coat. It has excellent chemical & water resistance.

PRODUCT DESCRIPTION

Color :	Grey/Red.
Finish :	Matt
Flash Point :	Above 25°C
Volume Solids :	45 ± 2 %
Type :	Two pack cold cure
Recommended dry film thickness :	30-35 µm per coat
Theoretical Covering Capacity :	13-15 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within ½ hour Hard dry - within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner:BRITISH Epoxy thinner

USES

General Structural Steel
Mining and Machinery Industries
Cylinders
Petrochemical Installations
Pipelines / Corrosive Environment

Pre-Engineering Building

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	PU FINISH	PU FINISH
-do-	-do-	EPOXY FINISH	EPOXY FINISH
-do-	-do-	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL

NOTES

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SUPRA EPOXY HIGH BUILD PRIMER

It is two pack high performance polyamide/polyamine cured epoxy high build primer containing special high level of anticorrosive pigment. It has excellent adhesion to steel or suitably treated light alloys. It cures to a tough and high rust preventive coat. It has excellent chemical & water resistance.

PRODUCT DESCRIPTION

Color :	Grey/Red.
Finish :	Matt
Flash Point :	Above 25°C
Volume Solids :	55 ± 2 %
Type :	Two pack cold cure
Recommended dry film thickness :	50-75 µm per coat
Theoretical Covering Capacity :	7.3- 11.0 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within ½ hour Hard dry – within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRTISH Epoxy thinner

USES

General Structural Steel
Mining and Machinery Industries
CNG Cylinders
Petrochemical Installations
Pipelines

Pre-Engineering Building

Power Plants / Corrosive Environment

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY HB PRIMER	PU ENAMEL	PU ENAMEL
-do-	-do-	EPOXY ENAMEL	PU ENAMEL
-do-	-do-	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL

NOTES

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SUPRA EPOXY FINISH

It is two pack high performance polyamide cured top coat, based on epoxy resin and special pigment. It can also be used over an anticorrosive primer on ferrous surface in mild to medium environment. It has excellent chemical & water resistance.

PRODUCT DESCRIPTION

Color :	Standard shades
Finish :	Smooth & Glossy
Flash Point :	Above 25°C
Volume Solids :	42±2 %
Recommended dry film thickness :	30-35 µm per coat
Theoretical Covering Capacity :	12-14 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within 2 hours Hard dry - within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Spray/Brush.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH Epoxy thinner.

USES

General Structural Steel
Mining and Machinery Industries
Power Plants
Petrochemical Installations
Pipelines, Corrosive Environment
Pre-Engineering Building

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	EPOXY FINISH	EPOXY FINISH
-do-	-do-	EPOXY FINISH	PU FINISH

NOTES

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SUPRA EPOXY HIGH BUILD FINISH

It is two pack high performance polyamide cured epoxy high build top coat, based on epoxy resin and special pigment. It can also be used over an anticorrosive primer on ferrous surface in mild to medium environment. It has excellent chemical & water resistance.

PRODUCT DESCRIPTION

Color :	Standard shades
Finish :	Semi-glossy to Glossy
Flash Point :	Above 25°C
Volume Solids :	58 ± 2 approximately
Recommended dry film thickness :	50-75 µm per coat
Theoretical Covering Capacity :	7.7-11.6 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within 2 hour Hard dry - within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Spray/ Brush.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH Epoxy thinner

USES

General Structural Steel
Mining and Machinery Industries
Power Plants
Petrochemical Installations
Pipelines/ Corrosive Environment
Pre-Engineering Building
Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	EPOXY HB FINISH	EPOXY HB FINISH
-do-	-do-	EPOXY HB FINISH	PU FINISH

NOTES

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SUPRA EPOXY MONOCOAT FINISH

It is two pack, cold curing high performance primer cum finish coat, based on epoxy resin and anticorrosive pigment. It can also be used as an anticorrosive primer on ferrous surface in mild to medium environment. It has excellent chemical & water resistance. It's a one coat system primer and finish.

PRODUCT DESCRIPTION

Color :	Standard shade.
Finish :	High Lustre to Semi Glossy.
Flash Point :	Above 26°C
Volume Solids :	62 ± 2 %
Recommended dry film thickness :	75-100 µm per coat
Theoretical Covering Capacity :	6.2-8.3 Sqm/ltr
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within 2 hour Hard dry - within 12 hours Full curing - within 7 days
Interval before Overcoating :	None or as per desired specifications.
Pot Life :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying ROZC primer.

APPLICATION DETAILS

Method of application : Airless spray / Brush / Roller / Air spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH Epoxy thinner.

USES

General Structural Steel

Mining and Machinery Industries
Fertilizers, Corrosive Environment
Petrochemical Installations
Petrochemical Refineries

Pre-Engineering Building, Power Plants

Chemical Manufacturing Units.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY MONOCOAT FINISH	-do-	-do-

NOTES

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SUPRA EPOXY HB MIO COATING BROWN

A two pack polyamide cured high build epoxy coating based on lamellar micaceous iron oxide pigment renders optimum performance for steel protection, providing high film thickness in a minimum coat. Its outstanding chemical, water and abrasion resistance makes this anideal coating for use in industrial environments. This product acts as a tough barrier coat with excellent impermeability to moisture.

PRODUCT DESCRIPTION

Color :	Brown/Grey.
Finish :	Matt to Eggshell
Flash Point :	Above 20°C
Volume Solids :	52 ± 2 %
Recommended dry film thickness :	75-100 µm per coat
Theoretical Covering Capacity :	5.2-6.9 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 4 : 1 (by volume)
Drying Time :	Surface dry - within 2-4 hour Handleable - within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum- overnight. Maximum- indefinite.
Pot Life @30°C :	6-8 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying ROZC primer.

Painting over weathered Zinc primer:

On weathering a white deposit of zinc salt may appear in the surface. These are to be removed by water scrubbing, sand/grit sweeping etc. before over coating.

APPLICATION DETAILS

Method of application : Brush / Airless Spray.

Airless spray recommended for uniform and high film build.

Brush for small areas only.

Notes on Airless Spray : Tip Range 18-23 thou.

Total output fluid pressure: 2500 - 3500 psi. (176-246 kg/sq. cm.)

Recommended Thinner: BRITISH Epoxy thinner

USES

Fertiliser Plants,
Power & Gas Plants,
Marine Installations,
Offshore Structures,
Bridges and Cranes,
Mining & Machinery Units

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	EPOXY HB MIO COATING	EPOXY / PU FINISH

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rinse above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Use off mixed paint within stipulated pot life period.
4. Use of thinners other than supplied or approved by British may adversely affect product performance and void product warranty whether express or implied.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

PRECAUTION

Provide adequate ventilation during application and drying. For proper curing of film, ambient temperature should not be lower than 10°C.

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SUPRA COAL TAR EPOXY COATING

It is two pack high performance polyamide/polyamine cured **High Build** coal tar epoxy paint giving very good toughness and water resistance. It stands corrosion conditions in soil immersion and also certain acidic and alkaline environments. Recommended for use under water structures like penstocks, damgates, cooling tower etc. Also recommended for concreate surfaces of chemical industry such as beams, columns.

PRODUCT DESCRIPTION

Color :	Brown/Black.
Finish :	Eggshell
Flash Point :	Above 20°C
Volume Solids :	65 ± 2 %
Type :	Two pack cold cure
Recommended dry film thickness :	75-125 µm per coat
Theoretical Covering Capacity :	8.67 sqm per ltr @75 µm DFT
	5.20 sqm per ltr @125 µm DFT
Mixing Ratio :	Base : Hardner :: 3 : 1 (by volume)
Drying Time :	Surface dry - 5 to 8 hours
	Hard dry - within 20 hours
	Full curing - within 7 days
Interval before Overcoating :	Minimum 24 hours.
	Maximum 7 days.
Pot Life @30°C :	4-6 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 90-100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

CONCRETE SURFACES:

New Concrete Surface: The new concrete surfaces are very absorbent in nature, hence before painting proper curing of the surface should be done. In case of smooth concrete surface light sand blasting would be ideal to provide key to paint. Alternatively, acid etching with 10% hydrochloric acid can also be carried out. After acid etching surface should be washed thoroughly with fresh water and surface should be allowed to dry thoroughly, before application of paint. ***Old Concrete Surface:*** Various surface contaminants like grease, oil, scales, etc. should be removed by using 10% caustic solution. Thereafter, surface preparation procedure can be same as in case of new concrete surface.

APPLICATION DETAILS

Method of application : Brush / Airless Spray.
Notes on Airless Spray : Tip Range 21-26 thou.
Total output fluid pressure: 2700 - 3500 psi. (190-246 kg/sq. cm.)
Recommended Thinner: BRITISH Epoxy thinner

LIMITATIONS

The finish tends to chalk when exposed to sunlight although protective properties of the film remain practically unaffected.

USES

Penstocks, Damgates, Spiral casing, Cooling towers, Chemical storage tank, Petrochemical Installations, Pipelines, Corrosive Environment, Harbor or Sea shore installation.

SURFACE SELECTION GUIDE

SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	SUPRA COAL TAR EPOXY COATING	SUPRA COAL TAR EPOXY COATING	SUPRA COAL TAR EPOXY COATING
Concrete	SUPRA COAL TAR EPOXY COATING	SUPRA COAL TAR EPOXY COATING	SUPRA COAL TAR EPOXY COATING

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

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POLYURETHANE SURFACER PRIMER

It is two pack, cured with aliphatic isocyanate primer based on acrylic resin and special type of pigment. It is a high performance polyurethane coating on ferrous surface in mild to medium environment. It has excellent chemical, water & UV resistance. This coating is compatible with wide range of top coat.

PRODUCT DESCRIPTION

Color :	Standard.
Finish :	Lustre.
Flash Point :	Above 22°C
Volume Solids :	45 ± 2 %
Recommended dry film thickness :	30-35 µm per coat
Theoretical Covering Capacity :	13-15 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 3.45 : 0.55 (by volume)
Drying Time :	Surface dry - within 1 hour Hard dry - within 8 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life :	3 - 5 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Spray.

Notes on Airless Spray : Tip Range 15-21 thou.

Total output fluid pressure : 2500 - 3000 psi.

(176-211 kg/sq. cm.)

Recommended Thinner: BRITISH PU thinner.

USES

General Structural Steel

Mining and Machinery Industries
CNG Cylinders
Petrochemical Installations
Pipelines

Pre-Engineering Building

Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	PU SURFACER PRIMER	PU FINISH	PU FINISH
-do-	-do-	SYNTHETIC ENAMEL	SYNTHETIC ENAMEL

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

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ALKYD POLYURETHANE FINISH

It is two pack, cured with aliphatic isocyanate high performance top coat based on PU modified resin and special type of pigment. It can also be used over an anticorrosive primer on ferrous surface in mild to medium environment. It has excellent chemical & water resistance.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth and glossy
Flash Point :	Above 22°C
Volume Solids :	30 ± 2 %
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	12-15 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 3.65 : 0.35 (by volume)
Drying Time :	Surface dry - within 1 hour Hard dry – 8-12 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	3 - 5 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Brush / Spray.

Notes on Airless Spray : Tip Range 15-21 thou.
Total output fluid pressure : 2500 - 3000 psi.
(176-211 kg/sq. cm.)

Recommended Thinner:BRITISH PU thinner

USES

General Structural Steel
Mining and Machinery Industries
CNG Cylinders
Petrochemical Installations
Pipelines
Pre-Engineering Building
Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	ALKYD PU FINISH	ALKYD PU FINISH
Steel	PU PRIMER	ALKYD PU FINISH	ALKYD PU FINISH

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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ACRYLIC POLYURETHANE FINISH

It is two pack, cured with aliphatic isocyanate high performance top coat based on acrylic resin and special type of pigment. It can also be used over an anticorrosive primer on ferrous surface in mild to medium environment. It has excellent gloss, chemical, water, UV resistance & color retention properties.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth and glossy
Flash Point :	Above 22°C
Volume Solids :	40 ± 2 %
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	13-16 sqm per ltr.
Mixing Ratio :	Base : Hardner :: 3.45 : 0.55 (by volume)
Drying Time :	Surface dry - within ½ hour Hard dry – 8-12 hours Full curing - within 7 days
Interval before Overcoating :	Minimum overnight. Maximum 7 days.
Pot Life @30°C :	3 - 5 hours.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 100°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Degrease and blast clean Sa 2½ grade minimum of Swedish specification SIS-05-5900-1967. If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to Sa2 or Sa3 grade of Swedish specification. Surface should be perfectly clean and dry before applying appropriate primer.

APPLICATION DETAILS

Method of application : Spray.

Notes on Airless Spray : Tip Range 15-21 thou.
Total output fluid pressure : 2500 - 3000 psi.
(176-211 kg/sq. cm.)

Recommended Thinner:BRITISH PU thinner

USES

General Structural Steel
Mining and Machinery Industries
Cylinders
Petrochemical Installations
Pipelines
Pre-Engineering Building
Cranes, Towers.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	EPOXY PRIMER	ACRYLIC PU FINISH	ACRYLIC PU FINISH
-do-	PU PRIMER	ACRYLIC PU FINISH	ACRYLIC PU FINISH

NOTES

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SUPRA STOVING HLPS PRIMER

It is a stoving undercoat primer made of special alkyd/amino resin along with special pigments and solvents suitable for steel, metal surfaces when cured through stoving. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior uses for excellent durability.

PRODUCT DESCRIPTION

Color :	Black/Grey/White.
Finish :	Smooth & HI-Lustre
Flash Point :	Above 25°C
Volume Solids :	45 ± 2 %
Supply viscosity @30°C :	65 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	18-23 sqm per ltr.
Baking Schedule :	120°C for 30 minutes. 140°C for 20 minutes.
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Conventional spray or Electrostatic spray

Recommended Thinner: BRITISH Stoving thinner.

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING HLPS PRIMER	STOVING ENAMEL FINISH	STOVING CLEAR
-do-	-do-	STOVING METALLIC/FB FINISH	STOVING CLEAR

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

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SUPRA STOVING HLPS PRIMER (WET ON WET)

It is high quality alkyd melamine formaldehyde systems, offering exceptional rust inhibiting qualities, hiding power and adhesion. It can be used as a wet-on-wet system (primer to finish coat in single bake coat) or can be stoved. It provides excellent adhesion on metalsubstrates.

PRODUCT DESCRIPTION

Color :	Black /White.
Finish :	Smooth & Hi-Lustre
Flash Point :	Above 25°C
Volume Solids :	45±2 %
Supply viscosity @30°C :	65 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	18-23 sqm per ltr.
Baking Schedule :	Not required.
Primer + Top coat :	140°C for 30 minutes
Flash off :	3-7 minutes.
Interval before Overcoating :	15-30 minutes
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application : Conventional spray or Electrostatic spray
Recommended Thinner: BRITISH Stoving thinner

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,

Electrical fittings, Fan,

Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING HLPS WHITE PRIMER (W/W)	STOVING ENAMEL FINISH	STOVING CLEAR
-do-	-do-	STOVING METALLIC FINISH	STOVING CLEAR

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SUPRA STOVING ALUMINIUM PRIMER

It is a stoving undercoat aluminium primer made of special alkyd/amino resin along with special aluminium paste and solvents suitable for steel, metal surfaces. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior usesfor excellent durability.

PRODUCT DESCRIPTION

Color :	Aluminium.
Finish :	Smooth & Al. lustre
Flash Point :	Above 25°C
Volume Solids :	40±2 %
Supply viscosity @30°C :	65 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25µm per coat
Theoretical Covering Capacity :	16-20 sqm per ltr.
Baking Schedule :	120°C for 30 minutes 140°C for 20 minutes
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Conventional spray or Electrostatic spray

Recommended Thinner: BRITISH Stoving thinner

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING ALUMINIUM PRIMER	STOVING FLAMEBOYANT FINISH	STOVING CLEAR
-do-	-do-	STOVING ENAMEL FINISH	STOVING CLEAR

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

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SUPRA STOVING ALUMINIUM PRIMER (WET ON WET)

It is a stoving aluminium primer made of high quality alkyd melamine formaldehyde systems, offering exceptional rust inhibiting qualities, hiding power and adhesion. It can beused wet-on-wet primer to finish coat with single bake process or can be stoved. It provides excellent adhesion on metal substrates.

PRODUCT DESCRIPTION

Color :	Aluminium.
Finish :	Smooth & Al. Lustre
Flash Point :	Above 26°C
Volume Solids :	40 ± 2 %
Supply viscosity @30°C :	65 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	25-30 sqm per coat
Theoretical Covering Capacity :	13-16 sqm per ltr.
Baking Schedule :	Not required
Al Primer + Top coat :	140°C for 30 minutes.
Flash off :	3-7 minutes.
Interval before Overcoating :	10 – 15 minutes
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application : Conventional sprayor Electrostatic spray
Recommended Thinner: BRITISH Stoving thinner

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings, Machines, Fan,

Cycles/auto parts etc

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING ALUMINIUM PRIMER (W/W)	STOVING FLAMEBOYANT FINISH	STOVING CLEAR
-do-	-do-	STOVING ENAMEL FINISH	STOVING CLEAR

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SUPRA STOVING LOW BAKE DIPPING PRIMER

It is a stoving undercoat low bake dipping primer made of special alkyd/amino resin along with special pigments and solvents suitable for steel, metal surfaces. The lower stoving schedule of the product can help in reducing overall heating costs. It provides excellent adhesion on metal substrates.

PRODUCT DESCRIPTION

Color :	Black.
Finish :	Smooth & Semi glossy
Flash Point :	Above 26°C
Volume Solids :	39±2 %
Supply viscosity @30°C :	75 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	16-20 sqm per ltr.
Baking Schedule :	120-150°C for 30 minutes
Flash off :	10-15 minutes
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Dipping/Spray.

Recommended Thinner: BRITISH Stoving Thinner.

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING LOW BAKE DIPPING PRIMER	STOVING LOW BAKE GLOSSY FINISH	STOVING LOW BAKE GLOSSY FINISH

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

DISCLAIMER

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THERMOSETTING ACRYLIC (TSA) PRIMER

It is a high luster primer made of special acrylic-amino resin along with special anticorrosive additives, pigments and solvents for desirable smooth/tough finish on metal surfaces when cured through stoving. It can be applied wet on wet primer to top coat with single bake process. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior uses for excellent durability. It has good SST resistance.

PRODUCT DESCRIPTION

Color :	White/Grey.
Finish :	Smooth & Hi-Lustre
Flash Point :	Above 24°C
Volume Solids :	45 ± 2 %
Supply viscosity @30°C :	70 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	25-30 sqm per coat
Baking Schedule :	140°C for 15-20 minutes.
Flash off :	10-15 minutes.
Interval before Overcoating :	As per flash off time.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application : Conventional or Electrostatic Spray

Recommended Thinner: BRITISH TSA thinner

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines, Fan

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	TSA PRIMER	TSA FINISH	-
-do-	-do-	TSA FINISH	TSA CLEAR

NOTES

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SUPRA STOVING HIGH GLOSS ENAMEL FINISH

It is a stoving enamel top coat paint made of special alkyd/amino resin along with special pigments, additives and solvents for desirable smooth/glossy/tough finish on metal surfaces when cured through stoving. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior uses for excellent durability.

PRODUCT DESCRIPTION

Color :	Standards shades.
Finish :	Smooth & Glossy
Flash Point :	Above 25°C
Volume Solids :	40 ± 2 %
Supply viscosity @30°C :	60 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	25-30 µm per coat
Theoretical Covering Capacity :	13-16 sqm per ltr.
Baking Schedule :	120°C for 30 minutes 140°C for 20 minutes.
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Conventional spray or Electrostatic spray

Recommended Thinner: BRITISH Stoving thinner.

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING HLPS PRIMER	STOVING HIGH GLOSS ENAMEL FINISH	STOVING CLEAR
-do-	STOVING HLPS PRIMER W/W	STOVING HIGH GLOSS ENAMEL FINISH	STOVING CLEAR

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

HEALTH AND SAFETY

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SUPRA STOVING METALLIC FINISH

It is a balanced formulation blended with top quality resins, based on alkyd-amino system,selective additives and highly durable pigments which impart its exceptional color retention, high gloss and smooth finish coupled with film flexibility, hardness and solvent resistance. It's suitable for both exterior as well as interior uses for excellent durability.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth & Glossy
Flash Point :	Above 25°C
Volume Solids :	42 ± 2 %
Supply viscosity @30°C :	60 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	16-21 sqm per ltr.
Baking Schedule :	120°C for 30 minutes 140°C for 20 minutes.
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Conventional spray or Electrostatic spray

Recommended Thinner: BRITISH Stoving thinner.

USES

Interior and exterior such as domestic appliances,

Furniture / Fans,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING HLPS PRIMER	STOVING METALLIC FINISH	STOVING CLEAR
-do-	STOVING HLPS W/W PRIMER	STOVING METALLIC FINISH	STOVING CLEAR

NOTES

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3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SUPRA STOVING FLAMBOYANT FINISH

It is an Industrial stoving flamboyant finish paint made of special alkyd/amino resin along with special dyes, additives and solvents for desirable smooth/glossy/tough finish on metal surfaces when cured through stoving. It provides excellent adhesion on metal substrateslike MS. It is suitable for both exterior as well as interior uses for excellent durability.

PRODUCT DESCRIPTION

Color :	Standard shades.
Finish :	Smooth & Glossy
Flash Point :	Above 25°C
Volume Solids :	40 ± 2 %
Supply viscosity @30°C :	60 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	16-20 sqm per ltr.
Baking Schedule :	120°C for 30 minutes. 140°C for 20 minutes.
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	After cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :
Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application: Conventional spray or Electrostatic spray

Recommended Thinner: BRITISH Stoving thinner.

USES

Interior and exterior such as domestic appliances,

Furniture fans,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING HLPS PRIMER	STOVING FLAMEBOYANT FINISH	STOVING CLEAR
-do-	STOVING ALUMINIUM PRIMER	STOVING FLAMEBOYANT FINISH	STOVING CLEAR

NOTES

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3. Primed steel work should not be exposed for a long period and preferably should be coated with suitable top coat at the earliest.

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SUPRA STOVING LOW BAKE DIPPING FINISH

It is a low bake stoving dipping topcoat that contains melamine to give it a tough durable finish. The lower stoving schedule of the product can help in reducing overall heating costs. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior uses for excellent durability.

PRODUCT DESCRIPTION

Color :	Black.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
Volume Solids :	39 ± 2 %
Supply viscosity @30°C :	60 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	20-25 µm per coat
Theoretical Covering Capacity :	16-20 sqm per ltr.
Baking Schedule :	120-150°C for 30 minutes.
Flash off:	10-15 minutes.
Drying Time :	After baking schedule.
Interval before Overcoating :	Cool down till room temp.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application : Dipping/Spray.

Recommended Thinner: BRITISH Stoving thinner.

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines,

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	STOVING LOW BAKE DIPPING PRIMER	STOVING LOW BAKE GLOSSY FINISH	STOVING LOW BAKE GLOSSY FINISH

NOTES

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THERMOSETTING ACRYLIC (TSA) FINISH

It is a high gloss finish top coat made of special acrylic-amino resin along with special pigments, additives and solvents for desirable smooth/tough finish on metal surfaces when cured through stoving. It provides excellent adhesion on metal substrates. It is suitable for both exterior as well as interior uses for excellent durability. it has excellent UV resistance.

PRODUCT DESCRIPTION

Color :	Standard solid, Metallic, Pearl finish.
Finish :	Smooth & Hi-Glossy
Flash Point :	Above 26°C
Volume Solids :	47 ± 2 %
Supply viscosity @30°C :	60 ± 5 sec in B4 Ford cup
Recommended dry film thickness :	25-30 sqm per coat
Baking Schedule :	140°C for 15-20 minutes.
Flash off :	10-15 minutes.
Interval before Overcoating :	As per flash off time.
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.
Dry Heat Resistance :	Up to 150°C (Intermittent).

SURFACE PREPARATION

STEEL SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. Any area of rust should be removed by abrading with a wire brush. Conventional degreasing methods may be employed by using solvent degreaser.

APPLICATION DETAILS

Method of application : Conventional or Electrostatic Spray

Recommended Thinner: BRITISH TSA thinner

USES

Interior and exterior such as domestic appliances,

Steel furniture,

General industrial products,
Electrical fittings,
Machines, Fan

Cycles/auto parts etc.

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
Steel	TSA PRIMER	TSA FINISH	-
-do-	TSA PRIMER	TSA FINISH	TSA CLEAR
-do-	STOVING PRIMER W/W	TSA FINISH	-
-do-	STOVING PRIMER W/W	TSA FINISH	TSA CLEAR

NOTES

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SUPRA STOVING VACCUM METALLIZING LACQUER (VCML) BROWN

It is the one-component base coat lacquer made by special alkyd-amino resin, special additives & solvents for desirable smooth, glossy and tough coat on sheet metals when cured through stove. It provides excellent adhesion on metallizing coated sheet metals(M.S.).

PRODUCT DESCRIPTION

Color :	Brown.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
NVM (% by weight) :	53 ± 2
Recommended dry film thickness :	20-22 µm per coat
Baking Schedule:	200-220°C/30 minutes (Thermal curing in conveyor)
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

STEEL SURFACES :
Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Spray/Dipping.

Recommended Thinner: British thinner.

USES

Four wheeler MS Auto head lights

Two wheeler MS Auto head lights

Cosmetics / Ornamental MS surface
Decorative MS surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
MS	VCML BROWN	Metallizing	Top Coat Lacquer

NOTES

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British Paints
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SUPRA STOVING VACCUM METALLIZING LACQUER (VCML) CLEAR

It is the one-component base coat lacquer made by special alkyd-amino resin, special additives & solvents for desirable smooth, glossy and tough coat on sheet metals when cured through stove. It provides excellent adhesion on Aluminum metallizing coated sheet metals (M.S.).

PRODUCT INFORMATION

Color :	Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
Volume Solids :	45 ± 2 %
NVM (% by weight) :	53 ± 2 %
Recommended dry film thickness :	15-20 µm per coat
Theoretical Covering Capacity :	22-30 sqm per ltr.
Baking Schedule:	200-220°C/30 minutes (Thermal curing in conveyor)
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

STEEL SURFACES :
Surface should be perfectly clean with either hand clothe wiping or chemical cleaning with IPA & other cleaning chemicals. And surface should be dry before applying Base coat lacquer.

APPLICATION DETAILS

Method of application : Spray/Dipping.

Recommended Thinner : BRITISH Plastic Lacquer thinner.

USES

Four wheeler MS head lights

Two wheeler MS head lights

Cosmetics MS surface

Decorative MS surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
MS	STOVING VCML BROWN	Metallizing	STOVING VCML CLEAR

NOTES

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SUPRA STOVING BASE COAT LACQUER FOR ABS

It is one-component thermoplastic lacquer coating for the auto head lights & cosmetics plastic, based on Acrylonitrile Butadiene Styrene (ABS). This lacquer is used as primer coatby conventional spray gun with thermal curing. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coatingtechnology.

PRODUCT DESCRIPTION

Color :	Slight Yellowish to Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
NVM (by wt) :	38 ± 2
Recommended dry film thickness :	8-12 µm per coat
Baking Schedule (Thermal curing in conveyor) :	80-85°C/ 60-75minutes
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor

APPLICATION DETAILS

Method of application : Spray.

Recommended Thinner: BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights
Two wheeler Auto head/tail lights
Cosmetics/ornamental plastic surface
Decorative plastic surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
ABS	Base Coat Lacquer ABS	Metallizing	Top Coat Lacquer for plastics
-do-	-do-	-do-	Hi-Performance Top Coat Lacquer for plastics

NOTES

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SUPRA STOVING 2K BASE COAT LACQUER FOR ABS

It is two-component thermoplastic lacquer coating for the auto head lights & cosmetics plastic, based on Acrylonitrile Butadiene Styrene (ABS), especially developed for Acrylonitrile Styrene Acrylate (ASA). This lacquer is used as primer coat by conventional spray gun with thermal curing. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Slight Yellowish to Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
NVM (by wt) :	38 ± 2 %
Mixing Ratio :	Base : Hardener :: 19:1 (by volume)
Recommended dry film thickness :	8-12 µm per coat
Baking Schedule:	80°C/60minutes (Thermal curing in conveyor)
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor

APPLICATION DETAILS

Method of application : Spray.

Recommended Thinner: BRITISH Plastic Lacquer thinner.
Pot Life: Excellent 24-48 hours.

USES

Four wheeler Auto head/tail lights
Two wheeler Auto head/tail lights
Cosmetics/ornamental plastic surface
Decorative plastic surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
ABS/ASA	2k Base Coat Lacquer for ABS	Metallizing	Top Coat Lacquer for plastics
-do-	2k Base Coat Lacquer for ABS	Metallizing	Hi-Performance Top Coat Lacquer for plastics

NOTES

1. This cancels all previous literature on this product and is subject to revision without notice.
2. Do not apply when temperature fall below 10°C or rises above 50°C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.

HEALTH AND SAFETY

Please refer to the separate safety data sheet available with detailed information.

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SUPRA STOVING BASE COAT LACQUER FOR PC

It is one-component thermoplastic lacquer coating for the auto head lights & cosmeticsplastic, based on Polycarbonate (PC). This lacquer is used as primer coat by conventional spray gun with thermal curing. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Slight Yellowish to Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
NVM (by wt) :	38 ± 2
Recommended dry film thickness :	8-12 µm per coat
Baking Schedule (Thermal curing in conveyor) :	115-120°C/75minutes.
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Spray.

Recommended Thinner: BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights
Two wheeler Auto head/tail lights
Cosmetics/ornamental plastic surface
Decorative plastic surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
PC	Base Coat Lacquer PC	Metallizing	Top Coat Lacquer for plastics
-do-	-do-	-do-	Hi-Performance Top Coat Lacquer for plastics

NOTES

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SUPRA STOVING BASE COAT LACQUER FOR PP (ROBOTIC)

It is one-component thermoplastic lacquer coating for the auto tail lights & cosmetics plastic, based on Polypropylene (PP). This lacquer is used as primer coat by conventional / robotic spray gun with thermal curing. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Slight Yellowish to Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
Volume Solids :	39 ± 2
Recommended dry film thickness :	8-12 µm per coat
Baking Schedule (Thermal curing in conveyor) :	110°C/75minutes For IR curing- 80°C/25minutes
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Conventional Spray/ Robotic Spray.

Recommended Thinner : BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights

Two wheeler Auto head/tail lights

Cosmetics/ornamental plastic surface

Decorative plastic surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
PP	Base Coat Lacquer for PP (Robotic)	Metallizing	Top Coat Lacquer for plastics
-do-	Base Coat Lacquer for PP (Robotic)	Metallizing	Hi-Performance Top Coat Lacquer for plastics

NOTES

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SUPRA STOVING BASE COAT LACQUER FOR PP

It is one-component thermoplastic lacquer coating for the auto tail lights & cosmetics plastic, based on Polypropylene (PP) and especially designed for Talc filled PP. This lacquer is used as primer coat by conventional spray gun with thermal curing. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Slight Yellowish to Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
Volume Solids :	33 ± 2
Recommended dry film thickness :	8-12 µm per coat
Baking Schedule (Thermal curing in conveyor) :	105-115°C for 70-90 minutes
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Spray.

Recommended Thinner: BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights

Two wheeler Auto head/tail lights

Cosmetics/ornamental plastic surface

Decorative plastic surface

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
PP/ Talc filled PP	Base Coat Lacquer for PP	Metallizing	Top Coat Lacquer for plastics
-do-	Base Coat Lacquer for PP	Metallizing	Hi-Performance Top Coat Lacquer for plastics

NOTES

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SUPRA STOVING TOP COAT LACQUER FOR ABS, PC & PP

This top coat is one-component thermoplastic lacquer coating for the auto head, tail lights plastic, based on ABS, PC & PP and can be used on other plastics like BMC & PBT. This lacquer is used as top coat by conventional spray gun with thermal curing. It has excellent chemical & water resistance. It is developed in India for Indian Automotive Industries conditions, and based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
Volume Solids :	19 ± 1
Recommended dry film thickness :	8-10 µm per coat
Baking Schedule (Thermal curing in conveyor) :	60°C/30minutes 70°C/25minutes
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
1%KOH,1%H2SO4, 3%NaCl Test	More than & equal to 10minutes.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Spray/Dipping

Recommended Thinner: BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights

Two wheeler Auto head/tail lights

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
ABS, PC,PP, PBT	Base Coat Lacquer	Metallizing	Top Coat Lacquer for ABS, PC & PP
OTHER PLASTICS	Base Coat Lacquer	Metallizing	Top Coat Lacquer for ABS, PC & PP

NOTES

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SUPRA STOVING HI-PERFORMANCE TOP COAT LACQUER FOR PLASTICS

This hi-performance top coat lacquer is the one-component special top coat lacquer forthe auto head, tail lights, based on ABS, PC, PP, PBT etc. This lacquer is used as top coat byconventional spray gun or dipping on metallizing parts with thermal curing. It is especially designed for its highly alkali resistant characteristic. It is developed in India for Indian Automotive Industries conditions, based on the latest and most innovative coating technology.

PRODUCT DESCRIPTION

Color :	Clear.
Finish :	Smooth & Glossy
Flash Point :	Above 26°C
NVM (by wt) :	19 ± 1 %
Recommended dry film thickness :	8-10 µm per coat
Baking Schedule (Thermal curing in conveyor) :	80°C/30minutes 85°C/25minutes
Drying Time :	Hard dry - after baking.
Interval before Metallizing :	Cool down till room temp.
3%KOH,1%H2SO4, 3%NaCl Test	Above 10 minutes.
Tape test (cross adhesion test) :	0/100 square
Storage life :	Up to 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions.

SURFACE PREPARATION

PLASTIC SURFACES :

Make sure that the surface / substrate to be painted should be free of oil, dust, grease or any other foreign particles to get optimum adhesion & finish. It Is necessary that the surface should be perfectly cleaned either by cleaning chemical or solvent. Before application please insured that the required temperature is obtained at oven & there is no any contamination of water through the compressor.

APPLICATION DETAILS

Method of application : Spray/Dipping.

Recommended Thinner: BRITISH Plastic Lacquer thinner.

USES

Four wheeler Auto head/tail lights

Two wheeler Auto head/tail lights

SURFACE SELECTION GUIDE			
SURFACE	1st COAT	2nd COAT	3rd COAT
ABS/PC/PP/PBT & others	Base Coat Lacquer	Metallizing	Hi-Performance Top Coat Lacquer for Plastics

NOTES

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SURFACE PREPARATION

The objective of applying a paint coating is to provide a film that will protect and decorate the surface being painted. The success of any paint application is generally governed by the following factors:

- Factors affecting the surface
- Surface Preparation
- Film Thickness
- Methods of Application

FACTORS AFFECTING THE SURFACE

Effect of Mill Scale

Generally, the steel plates for structural steel work or industrial use is manufactured by hot rolling, during which, the surface is oxidised rapidly and forms a layer of iron oxide which is called "mill scale". The thickness of mill scale varies from 0.2 to 2.5 mills. Mill scale has a laminated structure and consists of three layers of iron oxide in different forms. The first layer `next to the substrate is Ferrous oxide (FeO). The middle layer is Ferrous Ferric Oxide (Fe_2O_4) and the final expose player is Ferric oxide (Fe_2O_3). A uniform and perfectly intact mill scale would provide an effective defensive barrier against corrosion. From the commercial point of view, it is not a practical proposition, because to achieve the desired result of painting over undamaged mill scale, it should be done at the rolling mill, before the steel has left the rolls.

Effect of Rust

Besides mill scale, a steel substrate also gets rusted due to 'natural' corrosion by electrochemical cell formation. Rusting is highly disruptive because iron gives rise to four time its volume of rust. Rust is essentially the conversion of metal iron into a hydrated form of its oxide, $Fe_2O_3.6H_2O$.

If a substrate is not free from mill scale for rust, accelerated rusting of base metal can occur through electrolytic action between the mill scale or rust and steel. The mill scale or rust is cathodic to steel.

The potential difference between mill scale or rust and steel is about 0.3 V. This electrochemical action would corrode the steel further. It is also liable to spill and carry away the paint film. Hence before application, the substrate should be free from mill scale or rust.

The potential difference between mill scale or rust and steel is about 0.3 V. This electrochemical action would corrode the steel further. It is also liable to spill and carry away the paint film. Hence before application, the substrate should be free from mill scale or rust.

Effect of Effect of Grease, Oil, Dust, etc.

Before application of paints, the surface should be free from any grease, oil, dust or loose particles. Poor adhesion results when paint is applied to a substrate containing the above. If the coating has poor adhesion to the surface, it will permit oxygen and moisture penetrating through the film and will initiate corrosion. Oil or grease present on the surface can also retard drying of paints. Immediately before painting, all loose materials should be cleaned from the surface by dusting, browsing for washing down. Surface containing oil or grease should be cleaned with solvent for by means of steam jet.

Effect of Moisture

Whatever may be the protective value of the paint when it is applied on a surface containing condensed moisture, serious corrosion may occur under the print film. The corrosion in this case is by simple electrochemical process which is represented below by a simplified overall reaction:

$4Fe + 6H_2O + 6O_2 = 2Fe_2O_3.6H_2O$ (Rust)

Therefore, before painting, the surface should be dry.

Effect of Acid or Alkali

Acids or alkali remaining on the surface will accelerate corrosion reaction underneath. This generally happens when a surface is improperly treated with acid pickling or alkali cleaning or when the atmosphere is acidic or alkaline.

SURFACE PREPARATION:

How any paint coating performs, depends on the correct and through preparation of its surface? Given below are some of the recommended surface preparation techniques commonly followed:

Surface: Steel

Degreasing

It is essential to remove all traces of oil, grease, drilling / cutting compounds and any other surface contaminants. The most

common method is by solvent washing, followed by wiping dry with clean rags. Recommended procedures are described in SSPC - SP1.

Hand Tool Cleaning

It is a method of preparing steel surfaces by the use of non-power hand tools. Loosely adhering mill scale, rust and old paint coatings may be removed from steel by chipping, scraping, hand wire brushing and emery paper cleaning. However, these methods are incomplete and always leave a layer of tightly adhering rust on the steel surface. Procedures for hand tool cleaning are described in SSPC - SP2 and should be to ST2 grade of Swedish Standard or ISO 8501-1 : 1988.

Power Tool Cleaning

For the removal of loosely adhering millscale, paint and rust, this is more effective and less laborious method than hand tool cleaning. It will not however remove tightly adhering millscale. Power wire brushes, needle guns, grinders and disc sanders are generally used. Care should be taken, particularly when using power wire brushes, not to polish the metal surface, as this will reduce the key for subsequent painting. Methods are described in SSPC - SP3 and should be to ST3 grade Swedish Standard or ISO 8501-1 : 1988.

Flame Cleaning

Generally more effective than power tool cleaning, but has the inherent risks of fire and explosion, and of possible distortion of light gauge steel.

Blast Cleaning

By far the most effective method for removal of millscale, rust and old coating by using abrasives such as sand, grit or shots directed at high velocity against the surface.

Prior to blasting, steelwork should be degreased and all weld spatters removed. Weld seams and sharp edges should be ground down. This is because paint coatings tend to run away from sharp edges, resulting in thin coatings and reduced protection. The grade of blasting suitable for a particular coating specification depends on a number of factors, the most important of which is the type of coating system selected. There are four commonly used grades for blast cleaning, and the approximate equivalents between the various International Standards are as follows:

	Steel Structure Painting Council (USA)	National Association of Corrosion Engineers (USA)	British Std. BS 4232	Swedish Standard SIS 05 5900 - 1967 / ISO 8501-1 : 1988
White Metal	SSPC - SP 5	NACE # 1	1st Quality	SA 3
Near White Metal	SSPC - SP 10	NACE # 2	2nd Quality	SA 2½
Commercial Blast	SSPC - SP 6	NACE # 3	3rd Quality	SA 2
Brush Off Blast	SSPC - SP 7	NACE # 4	--	SA 1

The profile of roughness obtained during blasting is important, and will depend on the abrasive used, the air pressure and the technique of blasting. Too low a profile may not provide a sufficient key for a coating, while too high a profile may result in uneven coverage of sharp peaks leading to premature coating failure, particularly for thin coatings such as blast primers.

Surface: Non Ferrous Metal / Aluminium / Galvanised Steel

All surface should be clean, dry and grease free. If any corrosive salts are present they should be removed by light abrading. Before painting, one thin coat of etch primer should be applied so as to provide a key for further coats.

In case of galvanised steel, any white zinc corrosion products should be removed by high pressure fresh water washing or fresh water washing with scrubbing. The galvanised surface should then be etch primed to passivate the surface and provide a key for further paint coatings.

Surface: Concrete / Masonry
New Concrete Surface

The new concrete / masonry surfaces are very absorbent in nature, hence before painting proper curing of the surface should be done. In case of smooth concrete surface light sand blasting would be ideal to provide key to paint. Alternatively, acid etching with 10% hydrochloric acid can also be carried out. After acid etching surface should be washed thoroughly with fresh water and surface should be allowed to dry thoroughly, before application of paint. No anti-corrosive primer is generally necessary for concrete / masonry surface but a tack/tie coat of clear lacquer or thinned finish coat should be applied before the final painting.**ew Old**

Concrete/Masonry Surface

Various surface contaminants like grease, oil, scales, etc. should be removed by using 10% caustic solution. Thereafter, surface preparation procedure can be same as in case of new concrete / masonry surface.

FACTORS AFFECTING THE SURFACE

The accepted method of applying the coatings described in this manual are by brush, roller, conventional spray and airless spray. The advantages and disadvantages of each method are briefly described below.

Brush Application

Brush application is a relatively slow procedure, but is generally used for decorative paints and for coating small areas. It is particularly suitable for coating complex small areas where the use of spray method would lead to considerable losses due to overspray. However, most high build coatings are designed for application by airless spray, and high film build will generally not be achieved by brush application.

Roller Application

This is a faster method than brush application on large, even surfaces and can be used for application of thixotropic protective coatings but control of film thickness and high film build is not easily achieved.

Conventional Spray

This is a widely accepted and rapid method of paint application in which the paint is atomised by a low-pressure air stream. Conventional spray equipment is relatively simple and inexpensive, but it is essential to use the correct combination of air volume, air pressure and fluid flow to give good atomisation and a paint film free from defects.

If conventional spray application is not controlled correctly, large losses of paint can result from overspray and rebound from the surface. The major disadvantage of convention spray is that high build coatings can generally not be applied by this method, as most paints have to be thinned to a solution viscosity for satisfactory atomisation and so lose their high build properties.

Pressure Pot

These are generally used in association with conventional spray guns to provide a means of delivering paint from a tank to a spray gun through a hose.

The compressed air, which has entered the tank, forces paint from it to the gun through a hose and atomises the paint. Paint in the tank is prevented from settling by means of a stirrer driven by a compressed air motor or by hand.
Pressure pots are used in cases where large quantities of paint are to be applied and their use, instead of a gravity feed cup attached to spray gun, significantly reduces waste time in constant refilling and also enables the gun to be turned to any angle without spilling of paints.

Airless Spray

Unlike conventional spray, air is not mixed with the paint to form a spray, hence the name airless spray. Atomisation is achieved by forcing the paint through specially designed nozzles or tips, by hydraulic pressure. The required hydraulic pressure is usually generated by an air-powered pump having a high ratio of fluid pressure to air input pressure. Pumps with ratio 20:1 and 60:1 are available, the most common being around 45:1.

The chief advantages of airless spray are:
High build coatings can be applied without thinning.
Very rapid application possible, giving an economic advantage.
Compared to convention spray, over-spray and bounce-back are cut back, leading to reduced losses of material and lessening dust and fume hazards.

The tips through which the paint is forced to achieve atomisation are precisely constructed from tungsten carbide. The atomised “fan” of paint is produced by a slot ground on the face of the orifice. Various orifice sizes together with different slot angles are available. The choice of tip is governed by the fluid pressure required to give atomisation coupled with the orifice size needed to give the correct fluid delivery rate. The fluid delivery rate controls the film thickness applied.

Different slot angles produce spray fans of different widths and the selection of a particular fan width depends on the shape and size of the structure to be painted. Choice of fan width is also related to orifice size - for the same orifice size, the paint applied per unit area will be less, the wider the spray fan.

Generally, tips with an orifice size of 0.009” are suitable for coatings to be applied at approximately 50 microns (2mils) wet film thickness. Tip sizes from 0.013” - 0.019” for wet film thickness of 100-200 microns (4-8 mils) and 0.019” - 0.031” for above 200 microns (8mils) are generally used. Heavy duty mastics which are applied at very high film thickness may need tips with orifices as large as 0.040” - 0.060”.

There are several designs of tips available, the choice of which depends upon the finish required, the ease of application and ease of cleaning blockages from tips.

With some products, the decorative effect achieved with airless spray is not as good as can be achieved by conventional spray. However, airless spray application is now widely accepted as a convenient method of applying high build coatings.

COMMON PAINT DEFECTS

Poor Adhesion:

Poor adhesion of a paint on the substrate or between different course of the paint itself can originate from any of the following causes:

- Applying paint on oily, greasy or very smooth surface.
- Applying over loose particles, rust, dust etc.
- By not using proper pre-treatment or improper surface preparation.
- Applying over an improperly dried previous coat.
- By not standing the previous coat of glossy paint.

To rectify poorly adhering paint, the surface should be repented taking into account the above factors.

Bleeding

Bleeding is one of the several paint defects on a painted surface, it can be defined as the diffusion of coloured material into upper coat from the undercoat. This is due to the discoloration of colourising matter present in the previous coat into the liquid portion of the upper coat and staining the upper coat. It can also happen if powerful solvents are used over a normal dried film or due to the finish coat application over a wet under coat.

As the solvents of the finish coat are able to pick up deleterious matter, a barrier or insulating coat must be applied. The insulating coat must be able to withstand the solvents of the finish coat.

Blistering:

It is the eruption of a paint film and can be defined as localised loss of adhesion between the layers of coating on substrate which is caused by entrapped moisture or gases which expand under varying environmental conditions. This defect is more likely in non-porous coatings like oil paints and enamels. To rectify, smooth, sand the surface and then repaint it.

Blooming (Blushing):

A whitish appearance on the surface of varnish or enamel, accompanied by loss of gloss. The causes of blooming are:

- Application of paint under high humidity.
- Condensation of water on a paint film that has not dried.
- By the use of improper thinner.
- By applying paint in a poorly ventilated room.

To rectify the paint film, clean the affected area, repaint avoiding bloom-activating conditions and particularly a moist or fume laden atmosphere.

Chalking:

Chalking is a state of paint film when a powdery material appears on the surface which comes off easily on the hand when rubbed. Chalking is caused due to the effects of sunlight and oxygen in the atmosphere and also in marine areas due to salt in the air. The binding agent is attacked and deteriorates in varying degrees to allow the pigment within the paint film to be partly or wholly freed. It can also happen when the paint applied to too thin or applied to painted surfaces which are still porous and highly absorbent making the film under bound.

Checking and Cracking

A condition of dried film when its surface is rough and cracked and there is non-uniform breaking of the film due to poor tensile strength. Checking is a mild form of cracking and is restricted to the finished paint only, whereas cracking extent throughout the paint system. The causes of cracking are:

- Due to plaster cracking.
- When a quick hard drying coating is spread over is soft and plastic one.
- Applying at a higher film thickness.
- By the application of matt finish over the glossy finish.
- Application of the finished coat before the undercoat has not completely dried out.

To rectify paint or varnish film which has cracked the defective coat or coats must be completely removed. The exposed base should then be rubbed down to a smooth and clear face and primed before repainting with under coats and finishing coat which have compatible physical and chemical properties.

Chissing and Pinholing:

A defect in which a wet paint films the recedes from small areas on the surface leaving them apparently uncoated. It's an aggravated form of pinholing. Pinholing and Cissing are caused by following factors:

- Painting over surface contaminated with grease or oil.
- Poor wetting of the substrate by paint.

Since cissing occurs immediately on application, the wet paint can be removed completely in case where the paint has dried hard it can be sanded thoroughly and removed. Any grease or wax should be removed completely and glossy substrate must be made rough by sanding. Then repaint the substrate with finish paint.

Low Covering Capacity:

Low covering capacity may be due to any of the following factors:

- Improper thinning and application.
- Rightly absorbent substrate.
- Rough texture of plaster.
- Direct application over putty.

It is advisable to stick to instruction of thinning of paint and application of the suitable primer. The texture of the substrate is one thing which the printer cannot do much.

Drying (slow):

The reason of slow drawing can be due to unfavourable atmosphere condition or use of wrong thinner or intermixing of wrong paints. Existence of grease and wax is also responsible for non-drying. Good light, proper ventilation, warm atmosphere accelerates the drying process of paint. On the contrary, application of paint at high temperature will lead to faster drying and affect easy of application.

To rectify the tacky surface, it should be sanded thoroughly to remove the existing paint as much as possible. When dry, it should be repainted in/moderate temperature conditions following recommended application procedures.

Flaking:
It is lifting of the paint from the under lying surface in the form of flakes or scales. Moisture is one of the causes for flaking. If the previous coat usually held to the substrate, the application to finish coat will lead to failure. Addition of a matt finish coat over a glossy undercoat or application of finish coat containing powerful solvent over a under coat will loosen the adhesive forces leading to paint flaking. Similarly, a smooth surface will also lead to poor adhesion leading to paint flaking.

To rectify flaked paint, remove the affect paint completely and repaint ensuring suitable surface preparation.

Loss of Gloss:
Loss of gloss in synthetic enamel or clear varnish can occur due to any of the following reasons:
- Using thinner which are not recommended.
- Application of enamels over highly absorbent substrates.
- By not allowing the previous coat to dry.
- By proper exhaust.
- By the presence of moisture in the surroundings.

To rectify, sand the surfaces and apply a finish coat with the necessary precautions.

Sagging and running:
A downward movement of the paint film between the time of application and setting resulting in uneven coating having a thick lower edge. Sagging is caused:
- By the application of excessive thick coat.
- By applying at a lower consistency.
- By using a wrong thinner.
- By spring at a high pressure.

To rectify sagged paint, sand the surface to smoothen the sagged areas. Apply finishing coat with uniform distribution of paint thinned to recommended application viscosity following recommended application procedure.

Wrinkling:
This defect is the development of wrinkles on a paint film during drying process. The main reasons for wrinkling is the application of thick coats of paint film and improper drying of the previous coat. It can also be due to the exposure of the wet film to rapid drying conditions.

To rectify the affected paint, remove the paint completely and apply finish paint in thin coats with recommended thinning.

Yellowing and Fading
Yellowing of paint film is due to the yellowing of the natural or synthetic oils and resins which they contain. Alternatively, the change may occur if the film is excluded from natural daylight or subjected to too much sunlight. Application of certain shades which are recommended only for interior use on exteriors will lead to fading of the shade.

To rectify yellowing paint film, the surface should be cleaned and repainted using paint without pronounced tendencies to show yellowing, such as in the yellow to brown colour range. Where possible on inside work, daylight and ventilation should be improved.

Misses or Holidays
Holidays represent the patches where the paint has not been applied. Holidays are due to careless application of paint. Working under artificial or inadequate lighting or colour of undercoat too close to colour of finish coat.

To rectify, apply paint at places missed avoiding patchy appearance.

Orange Peel:
The surface of paint film by spraying has an appearance similar to that of the outer surface of orange peel. It is caused:
- Using a paint of low flow properties.
- Applying paint which is too viscous.
- To holding the gun too far away from the surface being painted.
- Using air pressure too high or too low.

Settling:
Settling is the condition due to which than pigments in the paint separate and settle at the bottom of the container.

Pigment settlement is caused mainly by the difference in specific gravity of the pigment and medium.

To rectify the settled mass, stir the contents thoroughly to a homogeneous paste before use. Periodic inversion of the containers of paint prior to settling will also avoid access settling.

Colour off or Won't match:
A condition at which the dried film shade does not match with the required shade. The causes are:
- Paint not thoroughly stirred.
- Paint not properly applied.
- By applying a very thin coat.
- Wrong coloured undercoat.
- By over stoving of pain film.

To rectify applied paint after taking into account the above causes.

Skinning
The top surface of paint or varnish in a container dries in the form of a skin. Skin formation is due to high uilage in the container filled with paint or container kept open for air entry.

Paint that has skinned can be made fit for use by removal of the skin. It is advisable to use the skinned paint after straining through muslin or nylon cloth.

Dry Spray:
Sprayed paint film dries to a rough gritty finish. This is caused by:
- High air pressure.
- The gun is moved too fast across the surface.
- The paint may be too thin to form a continuous film.
- The gun is too far away from the surface.

To rectify, sand the surface thoroughly and apply paint and the recommended application procedure.

VOLUME SOLIDS, FILM THICKNESS & COVERAGE

Volume solids

Volume solids of a paint is a very important factor for assessment of the spreading rate at a specified thickness. It expresses in percentage the ratio between dry and wet film thickness of a coating applied under laboratory conditions, where no paint loss has been encountered.

$$\%\text{Volume Solid} = \frac{\text{Measured DFTX 100}}{\text{Measured WFT}}$$

The method of determination follows the rules of **ASTM D 2697**.

Film thickness

An adequate film thickness is essential for the success of any coating system. An under-applied coating will generally result in premature failure. Gross over application of paint coatings can lead either to solvent entrapment and subsequent loss of adhesion, or to splitting of primer coats. With the majority of coatings, the limits of acceptable dry film thickness allow for reasonable practical variation, but the correct film thickness should always be the target during application.

Recommended dry film thickness for individual products are given on the Product Data Sheets. Measuring DFT of primers and coatings applied over blast cleaned surfaces in thickness upto 30 microns gives in accurate readings.

Dry Film Thickness can be calculated from the applied Wet Film Thickness as below:

$$\text{DFT} = \frac{\text{WFTX\% Volume Solids}}{100}$$

$$\text{WFT} = \frac{\text{Desired DFT X 100}}{\text{\% Volume Solids}}$$

Coverage

Theoretical Covering Capacity (TCC) :

Theoretical Covering Capacity of the Paint in a given dry film thickness on a smooth non-absorbent substrate is calculated as follows :

$$\frac{\%\text{Volume Solids X 10}}{\text{DFT (microns)}} = \text{Theoretical Coverage (Sq.Metre/Litre)}$$

Practical Covering Capacity (PCC) :

Practical Covering Capacity of the Paint depends on the losses which occurs during the paint application. Hence, theoretical covering capacity cannot be achieved during the field application. These losses are due to the surface conditions, surface profile, shape of substrate, application procedures, poor skill of painters and weather conditions. Though there is no formula for calculating these losses but on the basis of actual observation a guideline is available.

HEALTH AND SAFETY PRECAUTIONS

These notes concern health and safety requirements, industrial hygiene and potential hazards involved in handling paint and thinners. They are not intended to be exhaustive and do not cover all eventualities during the application and storage of paint.

Fire and Explosion:

The maturity of paints contains flammab0le organic solvents. As soon as a paint container is opened, solvent vapours are released. The flash point is the lowest temperature at which a liquid gives off sufficient vapour to form an inflammable mixture in contact with air:

- If the flash point of the paint is lower than or close to the temperature of the air, there is a very considerable risk of explosion and fire.
- If the flash point exceeds the air temperature, then there is no risk of explosion but there is still a risk of fire.

As such, therefore, no naked flames, cigarettes or matches should be allowed near an area where paint is being applied or stored. Precautions should also be taken to avoid spark from electrical appliances or caused by metal-to-metal contact. If a fire involving paint does occur:

- Do not extinguish with water, as paint solvents float on water, and this helps to spread fire.
- Use a dry chemical, foam or CO2 extinguisher.
- Protect yourself from the fumes with breathing apparatus.

Skin and Eye Contact

If paint is spilled the following precautions should be taken:

- Ventilate the area to remove the fumes.
- Mop up all spilled paint with absorbent material, ensuring that all materials used to mop up the paint are disposed off in closed metal containers.

It is recommended that the following precautions should be taken to prevent paint coming into contact with the skin and eyes.

- Select sensible working clothes, that cover as much of the body as possible.
- Always wear gloves and eye protection.
- Do not touch your mouth or eyes with your gloves.
- Read and observe precautionary notices on paint containers / product data sheets.
- Eyes are particularly sensitive, so if you are splashed in the eyes by paint or thinners, flood them immediately with fresh water for at least 10 minutes and seek medical advice immediately.
- If paint should splash on your skin, remove it with soap and water or an individual cleaner, NEVER USE SOLVENT.
- Remember to wash hands and rinse mouth after working with paint.

- Despite these precautions paint can still come into contact with the skin or eyes (e.g. spray mist, excessive splashing), so a non-greasy barrier cream is recommended for all exposed skin.
- Remember the objective is to avoid skin contact. If your clothes become soaked in paint, change them immediately and thoroughly wash the affected garments with soap and water.

Inhalation:

The inhalation of solvent fumes, dust, paint vapours must be avoided. Please follow the applications listed.

- Ensure the ventilation is available to remove solvent fumes.
- If spaces are difficult to ventilate efficiently wear an airfed hood/mask.
- Think about where the fumes are being vented. They could affect other people in adjacent spaces. Remember solvent fumes are heavier than air, they push breathable air upwards. They can flow down drains and ventilation ducts.
- If dizziness, drunkenness or headaches are experienced this could indicate you are being affected by solvent fumes. Move into fresh air and do not return until the ventilation has improved.
- If breathing fumes result in the collapse of a painter, he should be carefully moved into fresh air and allowed to recover gradually. Forced exercise is inadvisable.
- Never enter a space where fumes have or could have accumulated without breathing apparatus.

Inhalation of spray mist:

- The mist of paint particles created when spraying should not be inhaled.
- In well ventilated spaces a dust cartridge respirator can filter out these particles of paint effectively. (Replace the cartridge regularly).
- If ventilation is poor an airfed hood/mask is essential, if any doubt whatsoever exists wear an airfed hood/mask.
- Never filter spray mists through rags wrapped over the mouth. As the rags can get soaked and allow paint to come into direct contact with the mouth. The rags are also rather inefficient filters.

Ingestion:

Food and drink should not be consumed, stored or prepared in areas where paint is stored or being applied. In the case of accidental paint ingestion, medical attention should be obtained at once.

Safety norms should be followed by all concerned in storage, handling and application of the paint. For any further clarification please contact BRITISH PAINTS.

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