VITRETHANE 406

TECHNICAL DATA SHEET

Single Pack Equipment Enamel

A & I Coatings VITRETHANE 406 is a general-purpose spraying enamel. It is a durable, fast drying, high gloss enamel suited for all industrial applications.

USES & BENEFITS	As a topcoat on primed steel for: • Agricultural machinery & Attachments • Earthmoving equipment • Construction machinery • Buckets and dumper bodies • Vehicle chassis • Truck & trailer trays • Tractor implements				
	Benefits 1. Fast Drying 2. High Gloss 3. Can be tinted to customer requirements 4. Very good exterior durability		Limitations 1. Not to be stocked in high temperature (>30°C) and high humidity areas for a prolonged period 2. One coat to achieve high build is not recommended		
PHYSICAL PROPERTIES	Vehicle Type	Single pack enamel based on alkyd resin blends			
	Pot Life	NA			
	Finish	Full Gloss			
	Theoretical Coverage	9m² / Litre @ 40µm DFT			
	Volume Solids	35%			
	Recommended DFT	25 - 50µm DFT			
	Usual No. of Coats	2			
	Colour	Unlimited colour range			
	Pigmentation	Titanium Dioxide and other organic and inorganic pigments			
	Primer Required	Yes, dependant on substrate. Contact A & I Coatings for specific applications			
ENGINEERING DATA	Abrasion Resistance	Good			
	Chemical Resistance	Good			
	Solvent Resistance	Fair			
	Oil Resistance	Fair			
	Dry Heat Resistance	Satisfactory up to 120°C Dry Heat			
	Flexibility	Good			
	Durability	Good Exterior Durability			
CURING DATA	Substrate Temp.(ºC)	Touch Dry	Dust Free	Full Cure	Recoat Min
	20°C	30 Min	10 Min	24hrs	Overnight Dry
APPLICATION DATA	General	The temperature of the substrate should be min.3° C above the dew point of the air. Relative humidity should be at least 50%. It is recommended to measure temperature and humidity in the vicinity of the substrate.			
	Mixing	Stir thoroughly with a power stirrer for 2 – 3 minutes before use.			

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APPLICATION DATA	Application	Apply 2 medium wet coats. Allow 5 minutes between each coat. Tip size: 1.8mm Fluid Tip Air Pressure: 300 – 400 kPa pressure
	Cleaning	V102 Cleaning Thinners
	Thinning	V104 Enamel Thinners
SURFACE PREPARATION	Steel	All surfaces to be structurally sound and free of contamination, particularly salt deposits. Loose or flaking paint must be removed by abrasive blast cleaning, power tool cleaning or sanding. Oil, grease, dirt etc. must be removed with detergent and water blasting in accordance with AS 1627.1.
WORK STOPPAGES	General	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with A & I Coatings recommended cleaner. Once units of paint have been mixed, they should not be resealed, and it is advised that after prolonged stoppages work commences with freshly mixed units.
	Clean Up	Clean all equipment after use with A & I Coatings 104 Enamel Thinner. It is good work practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, (including delays).
PACKING & STORAGE	Packing	Available in 4L, 20L kits. For availability of other sizes, contact A & I Coatings.
	Storage	12 months for binder, 24 months for pigment if stored in sealed containers away from heat and moisture. Subject to re- inspection thereafter.
HEALTH & SAFETY	All applicable statutory regulations must be observed in the application of this product. Users must first read the Material Safety Data Sheet for Vitrethane 406. Users should familiarize themselves with all the safety aspects of the product prior to usage. Please ensure the current Technical Data Sheet is consulted prior to specification or application of A & I Coatings products. If the surface intended to be painted differs from the specification, please consult the A & I Coatings Technical team on 1800 819 585.	

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. Note: The figures quoted for pot life and drying/curing times are not definitive. They are dependent on-site conditions, such as volume of material mixed, ambient and substrate temperatures, weather and ventilation.

DISCLAIMER: Since the use and application of this product is beyond our control we cannot be held responsible for product field performance. The information presented above is the result of our considerable experience with this product but is not to be construed as a performance warranty