

TECHNICAL INFORMATION

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07.12.2021



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Modular Industrial Line Product name: alkyd, single-component gloss enamel, APP Lack Alkyd 30-300 Gloss. APP No.: 0270142.

One-component fast-drying alkyd enamel smooth gloss. Designed for economical industrial work, when coating tractor frames and trailers, agricultural machinery, tanks, machine parts and steel structures. Resistant to mechanical influences, impacts and scratches, as well as chemical agents: acids and alkalis in low concentrations, grease and petrol.

Product and accessories. APP Lack Alkyd 30-300 Gloss,
APP Thinner Alkyd 30-820.

Basic ingredients. APP Lack Alkyd 30-300 Gloss – alkyd binder, pigment paste and additives,
APP Thinner Alkyd 30-820 – thinner for single-component products.

Colour. Solid colours made according to formulas included in APP Modular Industrial Line.
APP 0270142:

- for opaque colours (5-10) + (95-90)
(pigment paste) + (binder),
- for low-opacity colours (15-20) + (85-80)
(pigment paste) + (binder).

Surface texture. Smooth.

Gloss. >92 for 60°, 90% for 20° – gloss.

Adjustment of gloss by mixing APP Lack Alkyd 30-300 Gloss with APP Lack Alkyd 30-300 Matt.

Lack Alkyd 30-300 Gloss	Lack Alkyd 30-300 Matt	Gloss 60°	Category
100	0	> 90	Gloss
60	40	65-90	Semi-Gloss
50	50	50-65	Satin
40	60	40-50	Satin
30	70	20-40	Semi Matt
20	80	10-20	Semi Matt
0	100	< 10	Matt

The degree of gloss/matt depends on the colour, amount of thinner, dry layer thickness, substrate and drying temperature.

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Specific weight. 1.0 kg/L at 20°C

Binder solids content. 36-42% (by weight)
30-34% (by volume)

Solids content of ready-to-use lacquer with 5% thinner. 40-48% (by weight)
37-41% (by volume)

Theoretical efficiency. For binder:

- 300-340 m²/L for 1 µm dry layer.

For ready-to-use lacquer with 5% thinner:

- 370-410 m²/L for 1 µm dry layer.

Note!

In practice, efficiency depends on factors, such as the shape of the object, the roughness of the substrate, the application method and the working conditions.

Application. Designed for painting tractor frames and trailers, agricultural machinery, tanks, machine parts and steel constructions as a one-coat system giving an economical, good topcoat enamel finish.

Advantages

- Designed for cost-effective industrial work.
- Easy preparation and application.
- Gloss, good mechanical resistance, hardness and elasticity.
- For the desired gloss level, it is miscible with APP Lack Alkyd 30-300 Matt.

Substrate

Pre-sanded factory coatings.
Surfaces coated with:

- epoxy primers, e.g. APP Primer EP 30-620, APP Grund EP, APP Grund EP Spray,
- polyurethane primers, e.g. APP Primer PUR 30-630,
- insulating and adhesive primers, e.g. APP Sealer PUR 30-640,

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Substrate cont.

- acrylic primers, e.g. APP Acrylfiller 401, APP Acrylfiller 501, APP Acrylfiller Rapid, APP Acrylfiller Compact,
- single-component fillers, e.g. APP Primer Filler, APP Primer Filler Spray
- insulating and filling primer APP Smart Primer Spray,
- Adhesion primers, e.g. APP Kunststoff Primer.

Substrate preparation.



Existing finishes.

- Dry sand with P320-P360 abrasive paper. Hand sanding finish with sandpaper on a P500-P600 sponge.
- Sand by hand with P600-P800 waterproof sandpaper.

Before spraying APP Lack Alkyd 30-300 Gloss, clean the lacquered surface of dust and degrease it with APP WB910, APP W911 or APP W900 remover using APP Premium cleaner.

For final dust removal, use APP SAS or APP SAS Aqua dust-absorbing cloths. Optionally, dry sand the APP Primer EP 30-620 or APP Primer PUR 30-630 primers with P320 machine.

Application

Mixing ratios.



Volume mixing ratios for temperatures of 18-25°C:

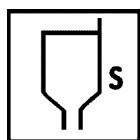
1 volume APP Lack Alkyd 30-300 Gloss

0-10% APP Thinner Alkyd 30-820

Volume mixing ratios for temperatures >25°C:

1 volume APP Lack Alkyd 30-300 Gloss

0-10% APP Thinner Alkyd 30-820



Spray viscosity at +20°C: 20-23 s F/4.

Note!

Use only APP Thinner Alkyd 30-820.

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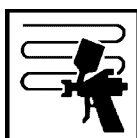
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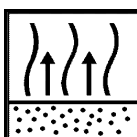
Application.



Apply with a spray gun equipped with a $\varnothing 1.3\text{-}\varnothing 1.5$ mm nozzle at an air pressure of 2.0 to 3.0 bar.

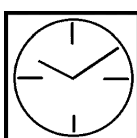


Number of layers: 2 x 1.
Dry coating thickness: 40-50 μm .



Evaporation time between coats at +20°C:
• 10 minutes.

Drying.



At +20°C:
Manipulability: 6-8 h.
Cross-slip hardening: 24 h.

At +60°C:
Cross-slip hardening: 30 min.



IR radiator: 15-25 min.

The coating achieves its full performance properties after a seasoning period, i.e. after 10 to 15 days at 18-22°C.

Sanding.



After 24 hours at +20°C it is possible to polish and remove defects and inclusions with abrasives:

- by hand, wet with P1500-5000 abrasive,
- by machine using P1500-5000 abrasive.

Equipment cleaning. Nitrocellulose, Alkyd, PUR or acrylic solvent.

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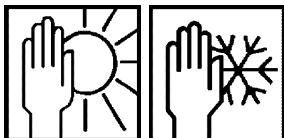
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Storage



Store in closed original packaging in a dry and well-ventilated room,
at +5°C to + 30°C.
Protect from frost and direct sunlight.

OHS regulations



For professional use only.
See text on product labels or SDS.
The user must comply with the OHS regulations in force in the country
concerned.

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