

## TECHNICAL INFORMATION

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07.12.2021



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### Modular Industrial Line

#### **Product name: Alkyd single-component enamel matt primer, APP Lack Alkyd 30-300 Matt. APP No.: 0270146.**

One-component fast-drying alkyd smooth matt enamel primer. Intended for cost-efficient industrial use in the coating of tractor frames and trailers, agricultural machinery, tanks, machine parts and steel constructions as a single-coat system giving a topcoat enamel finish and corrosion protection. 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 Matt,  
APP Thinner Alkyd 30-820.

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

Colour. Solid matt colours made according to formulas included in APP Modular Industrial Line.  
APP 0270146 – (5-10) + (95-90) – (pigment paste) + (binder)

Surface texture. Smooth.

Gloss. 5-10 for 60° – matt.

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.

The above information is in line with the current state of knowledge of our products and their possible applications. This does not guarantee specific properties or suitability for use under specific conditions. Follow the notes and warnings on the product labels and on the safety data sheet. We assume no liability if the final result of the work was influenced by factors beyond our control.

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Specific weight. 1.5 kg/L at 20°C

Binder solids content. 65-70% (by weight)  
40-45% (by volume)

Solids content of ready-to-use lacquer with 20% thinner. 61-67% (by weight)  
41-45% (by volume)

Theoretical efficiency. For binder:

- 400-450 m<sup>2</sup>/L for 1 µm dry layer.

For ready-to-use lacquer with 20% thinner:

- 410-450 m<sup>2</sup>/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. Intended for the coating of tractor frames and semi-trailers, agricultural machinery, tanks, machine parts and steel constructions as a one-coat system giving a topcoat finish and corrosion protection.

#### Advantages

- Direct adhesion to steel, galvanised steel, aluminium.
- Matt, good mechanical resistance, hardness and elasticity.
- For the desired matt level, it is miscible with APP Lack Alkyd 30-300 Gloss.

#### Advantages

- Coat with corrosion protection.
- Easy preparation and application.
- As an alternative to classic primer + lacquer coatings, recommended for a wide range of industrial applications.

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#### 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,
- 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.



Steel.

- Blasting treatment to a cleanliness grade of Sa 2½.
- P320-P360 mechanical grinding.

The treated surface should be free of rust, scale, oil, grease, loose old coating, dust and other contaminants. It should have a uniform metallic sheen.

Galvanised steel and aluminium.

- Dry sand with P240-P320 abrasive paper.
- Very gentle blasting treatment.

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 Matt, clean the coated 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.

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#### Application

Mixing ratios.



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

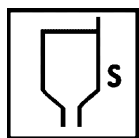
1 volume      APP Lack Alkyd 30-300 Matt

20-30%      APP Thinner Alkyd 30-820

Volume mixing ratios for temperatures >25°C:

1 volume      APP Lack Alkyd 30-300 Matt

20-30%      APP Thinner Alkyd 30-820



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

Note!

Use only APP Thinner Alkyd 30-820.

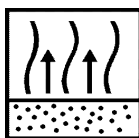
Application.



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



Number of layers: 2 x 1.  
Dry coating thickness: 40-50  $\mu\text{m}$ .



Evaporation time between coats at +20°C:

- 10 minutes.

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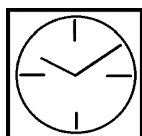


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Drying.



At +20°C:

Manipulability: 6-8 h.

Cross-slip hardening: 24 h.

At +60°C:

Cross-slip hardening: 30 min.



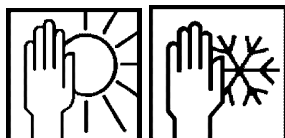
IR radiator: 15-25 min.

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

Equipment cleaning.

Nitrocellulose, Alkyd, PUR or acrylic solvent.

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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