

MANOR

PRODUCT DATA SHEET



Q.D. ENAMEL

INTENDED USE

METAL FINISHING

A half hour dry high gloss spray enamel for components or articles made from sheet or structural metals such as shelving, partitions, pumps or a host of OEM components. It is used wherever there is a need for general purpose finish to dry rapidly.

It may also be used 'direct to metal' without a primer for items that have no need for corrosion protection nor require a primer to fill surface imperfections and will only be used internally. Typical uses without a primer are small cast items and metal shelving.

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

SUITABLE SUBSTRATES AND PREPARATION

Surfaces must be dry sound and free from dirt, dust and grease.

For spray application prime with Manor Fast Primer or similar and for brush application prime/undercoat with Manor Metal Primer or CV Primer Undercoat. Previously painted glossy surfaces should be lightly abraded prior to application to promote adhesion. Any non-ferrous metals must be pre-treated with Manor Wash Primer, Manor Chromate Free Wash Primer or Manor 1 Pack Etch Primer CT.

AVAILABILITY

Gloss finish available in a limited range of popular colours stocked in 5 litre tins. An extensive range of BS, RAL and other colours are available from the MANORMIX Scheme. Semi-gloss and Semi-matt finishes are also available to order.

PRODUCT INFORMATION

(TYPICAL FIGURES)

Composition	Based on a short oil alkyd resin, pigmented with suitably selected pigments.
Volume Solids	40-43%
Weight Solids	46-60%
VOC content	495-530 g/litre
Typical film thickness	30 microns dry or 75 microns wet film thickness
Theoretical coverage	13 sq metres/litre at 75 microns wet film thickness
Dry heat resistance	80 C
Flash Point	Within the range 21-31 C

APPLICATION DETAILS

PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE

Airless spray: **cold** Ready for use but up to 5% thinners may be added to suit equipment. Typical tip size 11-13 thou or 0.28-0.33mm. Typical fluid pressure 140 kg/sq metre or 2000 p.s.i.
As cold but maximum temperature 70 C

heated

Conventional spray Up to 15% thinners may be added to suit equipment. May be hot sprayed at a maximum temperature of 70 C.

Brush Roller Not recommended, use Fast Enamel

Thinner Industrial Thinner

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	20 microns	50 microns
Maximum	40 microns	100 microns

DRYING AND RECOATING

Approximate drying times at 30 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10C	60-90 mins	1 hour	See note
20C	30-40 mins	30 minutes	See note

Environmental conditions

The air temperature should be at least 5C with a surface temperature 3C above the dew point and the relative humidity below 80% thus ensuring that the surface is dry and that condensation will not occur during application or drying.

Drying will slow significantly at temperatures below 10C.

Do not apply in conditions below 5C

Do not apply to external surfaces if the forecast is for rain to fall within the next 4 hours.

In exposed windy conditions a minimum air temperature of 8 C is recommended.

Overcoating / repainting

If required a further coat of QD Enamel may be applied wet on wet.

QD Enamel is sensitive to recoating after 6 hours. If recoating after more than 6 hours but less than 21 days lightly abrade and recoat with Fast Enamel.

If recoating after more than 21 days lightly abrade and overcoat with QD Enamel.

SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

**SAFETY
PRECAUTIONS**

Refer to Manor Safety Data Sheet

LIMITATIONS

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

REFERENCES

Amended date: November 27, 2012

Reference and number:QD- 7