



610 FAST DRY ENAMEL

JULY 2002

Air Dry Enamel

Product Data

610 is a fast drying, modified alkyd enamel, with the following properties:

- Good gloss
- Good gloss retention
- Fair abrasion resistance
- Fair solvent resistance
- Durable finish

Uses

For trucks, buses, earth moving equipment etc. May also be used on timber. Not suitable for aggressive chemical environment.

Colour Availability

Black, white and tinted colours available at Point Of Sale.

Packaging

Available 1L, 4L, 20L

Substrates

Steel and ferrous metals.

Aluminium / galvanised steel – MUST be etch primed before applying rest of system.

Wood / MDF

Total Solids Content

64.9% (wt), 48.2% (vol) – for white

Theoretical Coverage

Approximately 9.7 m²/litre @ 50µm DFT – for white. Practical coverage ranges will be lower than theoretical and this must be taken into consideration when calculating costs.

Thinning and Clean Up

Brush – No thinning necessary, but Mineral Turps may be used sparingly.

Spray – Normal to hot conditions (above 15C), use up to 15% 475 Enamel Reducer MI.

Cold conditions (10-15C), use up to 10% 254 Enamel Reducer MF.

Very cold conditions (below 10C sustained temp), use up to 10% 254 Enamel Reducer MF or 602 Ultraglos Winter Thinner.

Clean gun and equipment with 254 or 475 Reducer.

Application

Spray – conventional

Brush

Drying

Dust free: <1 hour

Print free: 2 hours

Hard dry : 6 hours

Recoat time: We on wet, under 2 hours, OR overnight, with sanding

Surface Preparation

Steel – Remove rust by blasting to SA2.5, or by using power tools or sanding. Degrease, prime.

Aluminium – Degrease, then scour with Scotchbrite. Degrease, prime.

Galv – Clean and degrease. Use a proprietary acid wash if surface has been chromate treated. Prime.

Wood – Sand and dust down. Prime.

MDF – Sand faces with 150 grit, edges with 120 grit followed by 180 grit in the opposite direction, then prime.

Safety Precautions

Read each component's material safety data sheet before use. Mixed material has hazards of each component. Safety precautions must be strictly followed during storage, handling and use.

CAUTION:

Improper use and handling of this product can be hazardous to health.

Do not use this product without first taking all appropriate safety measures to prevent property damage and injuries. These measures may include, without limitation: implementation of proper ventilation, use of proper lamps, wearing of proper protective clothing and masks, tenting and proper separation of application areas. Consult your supervisor. Proper ventilation and protective measures must be provided during application and drying to keep spray mists and vapour concentrations within safe limits and to protect against toxic hazards. Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interiors and buildings.

This product is to be used by those knowledgeable about proper application methods. PPG Industries makes no recommendation about the types of safety measure that may need to be adopted because these depend on application environment and space, of which PPG Industries is unaware and over which it has no control.

If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product.

Health and Safety

Avoid breathing vapour. Use with adequate ventilation. High concentrations of vapour may cause headache or nausea, affect the nervous system and respiration. When catalysed this product contains isocyanates, which are harmful by inhalation. Refer to Code of Practice for the Safe Handling of Isocyanates 1989 (or updates) for details on handling isocyanate material.

Do not use in the presence of naked flame or other sources of ignition. Store away from heat.

Wear safety glasses / goggles, an air supplied respirator or hood and PVC or nitrile chemical handling gloves. Persons with a history of respiratory problems are advised not to use this product or any other two pack polyurethane.

Store / dispose of residues in accordance with local body regulations.

First Aid

If poisoning occurs, contact a doctor. The Poisons Information Centre may be of assistance – telephone 0800 POISON (0800 764 766).

If swallowed, do NOT induce vomiting. Give a glass of water to drink and get medical attention urgently.

If affected by vapour, get into fresh air immediately.

If splashed into the eyes, flush them with copious quantities of clean water for 15 minutes and get urgent medical attention.

If splashed onto skin, wash with soap and water.

For further information, refer to the Material Safety Data Sheet for this product.



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Substrate Systems

Preparation

Steel – Remove rust, clean and degrease

Aluminium – Scour with Scotchbrite and degrease

Galv – Clean and degrease

Wood – Sand and dust down

MDF – Sand and dust down

Substrate / Recommended System	WFT / DFT (Microns)	Overcoat Time @ 20 Degrees C	Overcoat Preparation
MILD STEEL (Interior / Exterior)			
1 st coat 238 Primacote	70-110 / 25-40	1-8 hrs Overnight	N/A Sand 360
OR 1850 Zinchro Primer	65-125 / 25-50	1-8 hrs Overnight	N/A Sand 360
2 nd coat 610 Fast Dry Enamel	85-125 / 40-60		
ALUMINIUM / GALV / STEEL			
(Interior / Exterior Use)			
1 st coat 719 Polyetch	70-100 / 7-10	20' – 8 hrs	N/A
2 nd coat 238 Primacote	70-110 / 25-40	1-8 hrs Overnight	N/A Sand 360
OR 1850 Zinchro Primer	65-125 / 25-40	1-8 hrs Overnight	N/A Sand 360
3 rd coat 610 Fast Dry Enamel	85-125 / 40-60		
WOOD (Interior Use Only)			
1 st coat 100 Primer Surfacer	55-85 / 25-40	1-8 hrs Overnight	N/A Sand 360
2 nd coat 610 Fast Dry Enamel	85-125 / 40-60		
MDF (Interior Use Only)			
1 st coat 708 Primaboard	100-250 / 30-75	Overnight	Sand 360
2 nd coat 100 Primer Surfacer	55-85 / 25-40	1-8 hrs Overnight	N/A Sand 360
3 rd coat 610 Fast Dry Enamel	85-125 / 40-60		

WFT = Wet Film Thickness

DFT = Dry Film Thickness

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