



STYRALUX 220

Rapid Drying Copolymer Enamel

Data Sheet: 220

Supersedes: 09/07

Revised: 05/08

Composition	STYRALUX 220 is a very fast air dry enamel based on modified co-polymer resins.			
	Uses and Properties	As a finishing coat over a wide range of anti-corrosive primers or and primer surfacers. Features include:		
Typical Applications		<ul style="list-style-type: none"> ◆ Exceptionally fast drying ◆ Excellent spraying characteristics ◆ Good wrinkling resistance in thick films ◆ One coat finish for economical work 		
	Typical Systems	As a finishing coat over a range of primers or undercoats. Typical areas of use are on sheet metal, agricultural implements, cabinets, engines, chassis, furniture and switchboards.		
Substrate		Surface Preparation	Typical Systems	dft μm
Structural steel	Abrasive blast clean to AS 1627.4 Class 2½.	1 st Coat: AMERCOAT 185K 2 nd Coat: STYRALUX 220	60-75 60-75	
Mild steel (General Industrial use)	Remove rust, clean and degrease.	1 st Coat: RUSTFIGHTER 215 ❶ 2 nd Coat: STYRALUX 220	40-50 40-50	
Galvanised steel	Solvent degrease and abrade and clean. Sweep blasting recommended for larger sections.	1 st Coat: MULTI ETCH 302 ❷ 2 nd Coat: AMERCOAT 185K 3 rd Coat: STYRALUX 220	6-12 40-50 40-50	
❶ Other primers such as EASIPRIME 101 may be suitable. ❷ Other etch primers such as AMERETCH 783 may be suitable.				

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General Data	
Weathering	Moderate exterior durability
Finish	High gloss, reduced gloss levels available on request.
Chemical Resistance	Not recommended.
Abrasion Resistance	Moderate
Immersion	Not normally recommended
Temperature Range	Up to 120°C dry heat.
Colour	Most Standard Colours available.
Topcoating	Not normally topcoated
Shelf Life	12 months from date of shipment if stored indoors at 4°C to 38°C.
Application Data	
Theoretical Coverage	9.1 Sq Metres per litre at 40 µm dry film thickness. (Wet film thickness 100 µm).
Volume Solids	39%
Drying Time (@ 25°C, 50% R.H.)	Dust free: 3 Minutes; Touch Dry: 15 Minutes; Print free: 45 Minutes; Hard dry: 12-16 Hours. Recoating time: Up to 4 Hrs. Not recommended outside this period. NOTE: The figures quoted for drying and recoating times are not definitive. They are dependent on site conditions, ambient and surface temperatures, weather and ventilation.
Mixing	Stir thoroughly until uniform.
Thinning	Conventional spray application: Use up to 25% THINNER 445. THINNER 54 may be used for hot windy conditions.
Equipment	Conventional spray: Use 70-100 kPa pot pressure and 340-420 kPa atomising pressure. Airless spray: Thinning not required. Use tip orifice 0.325-0.375 mm, (0.013"-0.015"). Apply at 14-17 MPa atomising pressure.
Safety Precautions	Contents are flammable. Keep away from fire or naked flame or sparks. Keep away from children. Read Material Safety Data Sheet. When mixing or applying wear goggles and gloves and ensure good ventilation. When spraying, wear appropriate protective clothing and air supply. If splashed on skin, wash with soap and water. Adequate forced ventilation must be provided in confined spaces.

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