
342 SPRAYING ENAMEL

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Issued: Feb 2004

- DESCRIPTION** 342 SPRAYING ENAMEL is a premium alkyd based topcoat for all general industrial applications.
- It is ideally suited for the finishing of trailers, horse-floats, truck bodies and buses.
- FEATURES**
- High gloss
 - Excellent flow and levelling
 - Good resistance to tape marking
 - Good durability
 - Large colour range available, including metallic colours.
- SUITABLE SUBSTRATES**
- Can be applied over most properly prepared substrates including metal, fibreglass, timber and existing paintwork in sound condition.
- SURFACE PREPARATION**
- All surfaces to be painted should be clean, dry, free from all traces of contamination and be well sanded.
 - **BARE STEEL:** Treat with 971 METAL CONDITIONER AND DEGREASER. Prime with 411, 402 or 425 ZINC PHOSPHATE PRIMERS. For best results use 404 AUTOMOTIVE ENAMEL UNDERCOAT.
 - **BARE ALUMINIUM:** Thoroughly wash with R123 H.D. WAX AND GREASE REMOVER and abrade with nylon abrasive pad. Apply 426 VINYL ETCH PRIMER, 429 PARAPHOS PRIMER SURFACER or 406/413 TWO PACK ETCH PRIMER.
 - **ZINC COATED STEEL:** Degrease with R123 H.D. WAX AND GREASE REMOVER, abrade with nylon abrasive pad, and prime with 411, 402 or 425 ZINC PHOSPHATE METAL PRIMERS. For best results use 404 AUTOMOTIVE ENAMEL UNDERCOAT.
 - **FIBREGLASS:** Wash surface with detergent solution, followed by washing with R123 H.D. WAX AND GREASE REMOVER. Sand thoroughly with 280 grit wet rub paper. Prime with 404 AUTOMOTIVE ENAMEL UNDERCOAT.
 - **EXISTING PAINTWORK:** Wash thoroughly with R123 H.D. WAX AND GREASE REMOVER and sand with 280 grit wet rub paper. Treat all bare metal areas with 971 METAL CONDITIONER AND DEGREASER. Prime with 404 AUTOMOTIVE ENAMEL UNDERCOAT.
- THINNING**
- Thin 342 SPRAYING ENAMEL 25% by volume with R303 ENAMEL REDUCER for spray application. Recommended application viscosity is 18-20 seconds BS4 @ 25°C.

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APPLICATION

- Spray out light even coat and allow to dry for 5 minutes before applying another one or two medium coats allowing 5 minutes flash off between coats.
- AVOID HEAVY COATS.
- For metallic colours, finish off with a light coat to produce an even metallic finish.
- Spray gun setup for normal suction feed application is:
 - 1.8 mm Fluid tip
 - 300 - 400 kPa Air pressure

DRYING TIME

At normal ambient conditions 342 SPRAYING ENAMEL is:

- Dust Free: 1 hour
- Tack Free: 3 - 4 hours
- Ready to Tape: 16 hours
- Recoat: 16 hours

- Allow at least 4 weeks drying before applying detergents or polishing wax.
- The drying properties of 342 SPRAYING ENAMEL can be further improved by the addition of 369 UAE (Urethane Additive).
- Addition of 500 mls of 369 UAE per 4 Litres of 342 SPRAYING ENAMEL markedly increases through dry, mechanical and chemical resistance properties, and gloss.

CLEAN UP

- Use R303 ENAMEL REDUCER

PACK SIZES

- 1 Litre
- 4 Litres
- 20 Litres

PRECAUTIONS

Do NOT attempt to wash or polish the painted surface unless thoroughly dry. A 3 to 4 week drying period is recommended. Do NOT use R103 ALL PURPOSE THINNER in 342 SPRAYING ENAMEL as this could lead to wrinkling and recoat problems. Do NOT attempt to apply excessive film thickness of 342 SPRAYING ENAMEL as this may lead to wrinkling. For the same reason, do not leave painted surfaces in hot sun to dry. Use of 369 UAE converts 342 SPRAYING ENAMEL into a 2 Pack urethane enamel and all precautions and safeguards associated with the use of isocyanate containing materials must be adhered to. This includes handling, mixing and spraying.

HEALTH AND SAFETY

Contains flammable volatile solvents. Keep away from all sources of heat and open flames. Do not smoke whilst handling. Wear suitable protective clothing to avoid contact with skin and eyes and avoid breathing vapour. Do not spray in confined or poorly ventilated areas without the use of approved air supplied breathing apparatus.

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FIRST AID

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| Eyes | If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists. |
| Skin | If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use. |
| Inhalation | If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist. |
| Ingestion | If swallowed, give glass of water to drink and seek medical assistance. DO NOT induce vomiting. |

Consult separate Material Safety Data Sheet for more detailed Health and Safety information.