



# STYRALUX 220

## Rapid Drying Copolymer Enamel

**Data Sheet: 220**

Supersedes: 09/07

Revised: 05/08

<b>Composition</b>	STYRALUX 220 is a very fast air dry enamel based on modified co-polymer resins.			
	<b>Uses and Properties</b>	As a finishing coat over a wide range of anti-corrosive primers or and primer surfacers. Features include:		
<b>Typical Applications</b>		<ul style="list-style-type: none"> <li>◆ Exceptionally fast drying</li> <li>◆ Excellent spraying characteristics</li> <li>◆ Good wrinkling resistance in thick films</li> <li>◆ One coat finish for economical work</li> </ul>		
	<b>Typical Systems</b>	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.		
<b>Substrate</b>		<b>Surface Preparation</b>	<b>Typical Systems</b>	<b>dft <math>\mu</math>m</b>
Structural steel	Abrasive blast clean to AS 1627.4 Class 2½.	1 <sup>st</sup> Coat: AMERCOAT 185K 2 <sup>nd</sup> Coat: STYRALUX 220	60-75 60-75	
Mild steel (General Industrial use)	Remove rust, clean and degrease.	1 <sup>st</sup> Coat: RUSTFIGHTER 215 ❶ 2 <sup>nd</sup> Coat: STYRALUX 220	40-50 40-50	
Galvanised steel	Solvent degrease and abrade and clean. Sweep blasting recommended for larger sections.	1 <sup>st</sup> Coat: MULTI ETCH 302 ❷ 2 <sup>nd</sup> Coat: AMERCOAT 185K 3 <sup>rd</sup> 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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<b>General Data</b>	
<b>Weathering</b>	Moderate exterior durability
<b>Finish</b>	High gloss, reduced gloss levels available on request.
<b>Chemical Resistance</b>	Not recommended.
<b>Abrasion Resistance</b>	Moderate
<b>Immersion</b>	Not normally recommended
<b>Temperature Range</b>	Up to 120°C dry heat.
<b>Colour</b>	Most Standard Colours available.
<b>Topcoating</b>	Not normally topcoated
<b>Shelf Life</b>	12 months from date of shipment if stored indoors at 4°C to 38°C.
<b>Application Data</b>	
<b>Theoretical Coverage</b>	9.1 Sq Metres per litre at 40 µm dry film thickness. (Wet film thickness 100 µm).
<b>Volume Solids</b>	39%
<b>Drying Time (@ 25°C, 50% R.H.)</b>	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.
<b>Mixing</b>	Stir thoroughly until uniform.
<b>Thinning</b>	Conventional spray application: Use up to 25% THINNER 445. THINNER 54 may be used for hot windy conditions.
<b>Equipment</b>	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.
<b>Safety Precautions</b>	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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