

TECHNICAL PRODUCT DATASHEET

Implamel

Dacrylate Implamel one-coat sheen finish, is a general purpose, high-build primer/finish for structural steelwork, waste skips and similar steel fabrications.

PRODUCT INFORMATION

Coating type:

Modified alkyd/zinc phosphate

Reference number:

24-LINE/524-LINE

Features and benefits:

- Suitable for application direct to metal, no primer required
- Quick drying, touch dry in 20 minutes
- Sheen finish
- Dries quickly but paint film remains thermoplastic
- Exterior durability of 2-5 years

Appearance:

Sheen

Colours available:

All British Standard and RAL colours , including colour matching – *contact Dacrylate Customer Services for further details*

TECHNICAL INFORMATION

Theoretical coverage:

5.33m² per litre at 75 microns dry film thickness

% Volume solids:

40% calculated from laboratory formulation
May vary with colour

Film thickness:

	Wet film thickness	Dry film thickness
Typical:	190 microns	75 microns
Range:	150-210 microns	60-85 microns

Drying time:

Temp.	Touch dry	Firm dry	Overcoat
5°C	50mins	2hrs 30mins	See notes
10°C	40mins	2hrs	See notes
15°C	30mins	1hr 30mins	See notes
20°C	20mins	1hr	See notes

Recommended primers:

No primer required.

Drying time will vary with temperature, air movement, etc. Should a second coat be required, allow a minimum of 4 hours drying or preferably leave overnight between coats. The maximum over coating time is indefinite and is subject to normal good housekeeping practices for preparation and cleanliness between coats.

V.O.C.:

550gm/ltr EPA Method 24
398gm/kg calculated from formulation to satisfy EU Solvent Emissions Directive
May vary with colour

SURFACE PREPARATION

Paint preparation before use:

Mix paint thoroughly by stirring and continually agitate the product for homogeneity and consistency.

Surface preparation:

All surfaces to be coated should be clean, dry, and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Manual Clean:

Chip, scrape and wire brush to remove all loose millscale, rust, etc. Degrease with Dacrylate Thinner R5.

Mixing ratio by volume:

N/A.

APPLICATION

Application conditions:

This material should preferably be applied at temperatures in excess of 10°C. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired..

Airless spray:

Tip size: 11-13thou (0.27-0.33mm)
Tip pressure: Minimum 2800psi (193bar)

Conventional spray:

Tip size: 55 thou (1.4mm)
Tip pressure: 40-60psi (2.7-4.1bar)

Brush application:

Due to the fast-drying nature of this product only small areas and narrow sections can be brush applied. Apply with a full wet brush, do not attempt to 'brush-out' or 'layoff'.

Roller application:

This product is not suitable to be rolled.

Thinning:

5-10% of Dacrylate Thinner R5 may be required when spraying the product to achieve optimum spray characteristics.

Clean-up:

Clean all equipment after use with Dacrylate Thinner R5. Do not allow product to remain in hoses, guns, or spray equipment. All surplus product should be disposed of in accordance with appropriate regional regulations/legislation.

STORAGE AND PACKAGING

Storage:

Under cover within temperature range of 5°C to 32°C. Keep containers dry and tightly sealed to avoid moisture contamination.

Shelf life:

2 years or longer in unopened containers when stored under cover within a temperature range of 5°C to 32°C.

Pot life (at 20°C):

N/A

Packaging:

5 litre containers

HEALTH AND SAFETY

Please refer to the following data sheets (*please quote 6-digit number when requesting copies*):

Dacrylate Implamel (24-LINE) SDS 10961

All work involving the application and use of this product should be performed in compliance with all relevant national, health, safety & environmental standards, and regulations

ADDITIONAL NOTES

The application and spray information given above is intended as a guide only. As conditions vary from job-to-job, it is the applicators responsibility to ensure all equipment in use has been set up to give the best results.

This product is designed to be used on large industrial items and is not suitable for use on smaller components. Due to the nature of the material, bag wrapping, stacking etc. should not be carried out as damage to the coating may occur.

Due to their nature, polychromatic colours such as RAL 9006 and RAL 9007 may be susceptible to variations in colour depending on application methods and the type of paint. To obtain the best colour and appearance, these colours are best spray applied.

IMPORTANT INFORMATION

The information supplied in this product datasheet is not intended to be exhaustive. Any person using the product for any other purpose than that specifically recommended in this product datasheet, without first obtaining written confirmation from Dacrylate Technical Services as to the suitability of the product for the intended purpose does so at their own risk. All advice given about the product is correct to the best of our knowledge, however we have no control over the condition of the substrate, preparation or the many factors affecting the use and application of the product. Therefore, unless specifically agreed in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product.

Dacrylate warrants its products to be free from defects in material and workmanship. Dacrylate's obligations and buyer's exclusive remedy relating to the products shall be limited, at Dacrylate's option, to either replace the products not conforming the warranty or the credit of the buyers account in the invoiced amount of the non-conforming product. Any claim under this warranty must be made by the Buyer to Dacrylate in writing within five (5) days of the Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. The Buyer's failure to notify Dacrylate of such non-conformance as required herein shall bar the Buyer from recovery under this warranty.

The information detailed in this datasheet is liable to modification from time-to-time in the light of experience and our programme of product development. Before use, it is the customers responsibility to check with Dacrylate Customer Services, quoting the product reference number and version reference at the bottom of the data sheet, to ensure that they have in their possession the latest issue.

Technical product datasheets are available from our website at www.dacrylate.co.uk and should be the same as this datasheet. Should there be any discrepancies between this document and the website version, then please contact Dacrylate Customer Services.

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