

**DESCRIPTION**

- a two pack isocyanate-free catalysed acrylic metallic coating
- approved to APAS-2919
- conforms to AS/NZS 3750.5

**PRINCIPAL CHARACTERISTICS**

- excellent exterior durability
- unlimited recoatability
- good gloss off the gun
- fast drying
- good resistance to solvent splash
- will cure down to 5 °C
- for best protection overcoat with Paracryl IF540 Antigrffiti Clear
- isocyanate-free

**COLOURS AND GLOSS**

- Metallic - gloss

**RECOMMENDED FILM THICKNESS (PER COAT)**

	Minimum	Maximum	Typical
Dry film thickness microns	50	50	50
Wet film thickness microns	110	110	110
Theoretical spreading rate m <sup>2</sup> /l	9.0	9.0	9.0

**BASIC DATA AT 25 °C**

- solids content approx..... 45% by volume
- mix ratio ..... 4A:1B by volume
- touch dry after ..... 30 minutes
- full cure ..... 7 days

**SURFACE PREPARATION**

**PREVIOUS SUITABLE COAT**

- must be dry and free from chalking and contamination and sufficiently roughened if necessary
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 85%

**APPLICATION INSTRUCTIONS**

- mixing ratio by volume 4A:1B
- mix Paracryl IF540 Metallic Part A with Paracryl IF540 Part B only
- induction time - none
- pot life at 25 °C 8 hours. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- this product must be thinned with the recommended thinner before application
- thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- Valspar recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- for recommendations outside those contained in this data sheet, refer to Valspar

**APPLICATION METHODS**

- **AIRLESS SPRAY**
  - not recommended
- **AIR SPRAY**
  - recommended thinner ..... Thinner L747
  - volume of thinner ..... 15-25%
  - nozzle orifice approx. .... 1.4-1.8mm
  - nozzle pressure ..... 0.3-0.4 MPa (50-60 psi)
  - At temperatures greater than 30°C, or in windy conditions, or where slower drying is required, part, or all, of Thinner L747 may be replaced with Thinner L748. However, film thicknesses must be closely monitored as excessive film builds may result in sagging
- **BRUSH/ROLLER**
  - not recommended
- **CLEANING SOLVENT** ..... Thinner L747

**SAFETY PRECAUTIONS**

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes. Use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Safety Data Sheet (SDS)

**ADDITIONAL DATA**

**Overcoating Table**

Overcoating interval for Paracryl IF540 Metallic when top coating with itself or other compatible coatings

Interval	5 °C	15 °C	25 °C	35 °C
Min	2 hrs	1 hr	30 mins	15 mins
Max	Unlimited when dry and free from chalking and contamination			

**Curing and Potlife Table**

Paint temperature	5 °C	15 °C	25 °C	35 °C
Touch Dry	2 hrs	1 hr	30 mins	15 mins
Dry to Handle	72 hrs	32 hrs	16 hrs	12 hrs
Full Cure	28 days	14 days	7 days	5 days
Potlife (at application viscosity)		12 hrs	8 hrs	4 hrs

- adequate ventilation must be continuously maintained during application and curing

**PRECAUTIONS**

- for recommendations outside those contained in this data sheet, refer to Valspar

**PRODUCT COMPATIBILITY**

**Primers**

- Duranamel PR7 Etch
- Epinamel UC230
- Epinamel PR250
- Epinamel PR360ZPS
- Epinamel CP502
- Epinamel EB600
- Epinamel DTS680
- Epinamel NS808
- Epinamel DTM985

**Topcoats**

- Paracryl IF540 Metallic
- Paracryl IF540 (colours)
- Paracryl IF540 Antigrffiti Clear

**STORAGE AND PACKAGING**

- shelf life at least 12 months
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging 5 Litre Kit (4 Litre Part A, 1 Litre Part B)
- product line: 2017

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