

DESCRIPTION

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

PRINCIPAL CHARACTERISTICS

- unlimited recoatability
- good gloss off the gun
- fast drying
- excellent exterior durability
- good chemical and solvent splash resistance
- will cure down to 5 °C
- isocyanate-free
- also available in metallic (P52.02) and antigrffiti clear (P52.03) finishes
- matting base available to create lower gloss levels (refer to P52.04)

COLOURS AND GLOSS

- AS 2700 Colour Card – full 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 ² /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
- temperature resistance 95 °C (dry), 35 °C (wet)

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 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**
 - recommended thinner Thinner L747
 - volume of thinner 10-20%
 - nozzle orifice approx. 0.38mm (0.015 inch)
 - nozzle pressure 15 MPa (2100 psi)
- **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**
 - recommended thinner Thinner L754
 - volume of thinner 5-10%
 - The maximum dry film thickness that can be achieved when brushing/rolling is 30 microns
 - Multiple coats may be required to achieve the recommended dry film thickness
- **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 Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

Overcoating Table

Overcoating interval for Paracryl IF540 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
- Super Etch Primer
- Epinamel UC230
- Epinamel PR250
- Epinamel PR360ZPS
- Epinamel CP502
- Epinamel EB600
- Epinamel DTS680
- Epinamel NS808

- Epinamel DTM985

Topcoats

- Paracryl IF540
- Paracryl IF540 Metallic
- Paracryl IF540 Antigraffiti 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 20 Litre kit (16 Litre Part A, 4 Litre Part B), 5 Litre Kit (4 Litre Part A, 1 Litre Part B)
- product line: 2017



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ISO 9001

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For the most up to date information contact Valspar Customer Service Hotline or visit the Wattyl Website.

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