

# Technical Data Sheet

Product Name	
Full Product Name	<b>403 Auto Enamel</b>
Type of Product	1K Enamel Topcoat
Description	Concept 403 Auto Enamel is an automotive high gloss alkyd enamel topcoat, characterized by exceptional metal protection due to its excellent adhesion to most surfaces.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
403 Auto Enamel Black	36.5	44.6	0.921	7.68	510.0	4.26
403 Auto Enamel White	41.1	55.9	1.080	9.02	476.2	3.97
302 Enamel Hardener	46.4	53.1	1.020	8.52	475.8	3.97
804 Enamel Thinner	0.0	0.0	0.802	6.69	802.0	6.69

Properties
<ul style="list-style-type: none"> <li>• Good appearance and High gloss</li> </ul>
<ul style="list-style-type: none"> <li>• Good flow</li> </ul>
<ul style="list-style-type: none"> <li>• Good Adhesion</li> </ul>

Substrates
<ul style="list-style-type: none"> <li>• 109 Enamel Primer - Grey</li> </ul>
<ul style="list-style-type: none"> <li>• 113 ZP Primer</li> </ul>
<ul style="list-style-type: none"> <li>• 103 Etch Primer</li> </ul>
<ul style="list-style-type: none"> <li>• 111 Universal Primer</li> </ul>
<ul style="list-style-type: none"> <li>• Sound enamel surfaces</li> </ul>

## Substrate Preparation



**All Substrates**



All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application.

## Product Preparation

 <b>Mixing Ratio</b> <b>8:1 (by volume)</b> <b>Note: This step is optional</b>	<b>403 Auto Enamel</b>		<b>302 Enamel Hardener</b>	
	8 parts		1 part	
 <b>Reducer</b>	Up to 20% reduction with Concept Enamel Thinner, if required			
 <b>Pot life</b> <b>@ 25°C (77°F)</b>	N/A (3-4 hours if 302 Enamel Hardener is added)			
 <b>Spray viscosity</b> <b>@ 25°C (77°F)</b>	<b>BSB 4 Cup</b>	17-19 s		
	<b>Ford 4 Cup</b>	15-17 s		
<b>Spray equipment</b>   	<b>Gun type</b>	<b>Fluid tip</b>	<b>Spray pressure</b>	<b>Spray Distance</b>
	<b>Gravity feed</b>	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	<b>Suction feed</b>	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	<b>HVLP</b>	1.2-1.3 mm 0.047-0.051"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch
 <b>Number of coats</b>	2-3	Apply one coat followed by one or two even full coats. Avoid heavy wet coats.		
 <b>DFT Recommended</b>	40-50 µm 1.6-2.0 mils			
 <b>Flash off time</b> <b>@ 25°C (77°F)</b>	5 min between coats			
 <b>Drying</b>	<b>Air Dry</b> <b>@ 25°C (77°F)</b>	16-24 hours		

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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Remarks	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Equipment Cleaning	
Use recommended Concept Paints Gunwash	

Dry Film Properties	
	After 7 days drying, <b><u>when compared to similar technology products.</u></b>
Gloss	Excellent
Adhesion	Excellent
Metal Protection	Excellent

Product Data	
Colour	White, Black, Mixed colours
Theoretical Coverage	Approx. 6.0 m <sup>2</sup> /L (245 ft <sup>2</sup> /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature, away from sunlight.

Product Packaging		
Product Code	Product Name	Package Size
4036000000X	403 Auto Enamel White	1L, 4L
4037000000X	403 Auto Enamel Black	1L, 4L
403XXXXXXXX	403 Auto Enamel (Mixed colours)	>100L
3029200000X	302 Enamel Hardener	250mL, 500mL
8049200000X	804 Enamel Thinner	1L, 4L, 20L

## Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

Concept Paints  
26-30 Charles Street  
St Marys NSW 2760  
Sydney, Australia

ph. +61 (2) 9673 2555  
fax. +61 (2) 9623 1918  
office@conceptpaints.com.au  
www.conceptpaints.com.au