

# Technical Data Sheet

Product Name	
Full Product Name	<b>Unicote 322 QD Economy Enamel</b>
Type of Product	1K fast drying alkyd enamel
Description	Fast drying, economical industrial alkyd enamel, ideally suited for quick and easy, low build protection of steel, aluminium and glass reinforced plastics

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
341 White	70.0	84.7	1.909	15.93	291.2	2.43
342 Yellow Ochre	63.5	79.0	1.689	14.10	354.6	2.96
343 Black	60.2	64.5	1.083	9.04	384.1	3.21
344 Bright Blue	52.6	53.8	1.163	9.71	537.5	4.49
345 Green Blue	56.7	61.4	1.088	9.08	419.8	3.50
346 Violet	53.9	54.4	1.122	9.36	512.0	4.27
347 Bright Red	58.1	64.4	1.141	9.52	406.8	3.40
348 Magenta	58.6	62.6	1.072	8.94	401.4	3.35
349 Bright Yellow	56.2	62.2	1.125	9.39	425.4	3.55
350 Mid Yellow	44.2	50.1	1.085	9.06	541.8	4.52
351 Scarlet	59.8	68.5	1.240	10.35	390.3	3.26
352 Green	55.6	59.5	1.234	10.30	500.3	4.18
353 Dark Red Oxide	61.6	76.9	1.612	13.46	372.6	3.11
354 Jet Black	53.1	56.7	1.053	8.78	455.5	3.80
355 Red	63.1	66.1	1.187	9.91	402.4	3.36
371 Reduced Yellow Ochre	62.5	68.7	1.161	9.69	363.9	3.04
372 Reduced Black	61.8	65.0	1.059	8.84	370.3	3.09
373 Reduced Green Blue	61.0	64.3	1.060	8.85	378.9	3.16
374 Reduced Scarlet	61.8	66.0	1.093	9.12	371.2	3.10
375 Reduced Green	60.8	63.8	1.092	9.11	395.5	3.30
381 Silver	41.4	54.4	1.171	9.78	533.7	4.45
382 Coarse Silver	42.5	51.4	1.116	9.31	541.4	4.52
399 Flattening Base	35.9	43.2	1.094	9.13	621.5	5.19
322 Quick Dry Enamel Base	46.5	40.2	0.913	7.84	431.4	3.60
804 Enamel Thinner	0.0	0.0	0.802	6.69	802.0	6.69
Retarder Thinner	0.0	0.0	0.884	7.38	884.0	7.38


## Properties

- Superior performance when compared to other similar products
- High gloss
- Quick and easy application

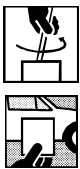








## Substrates

- Mild Steel
- Aluminium
- Galvanised Iron
- Glass reinforced polyester (GRP & general types of fibreglass body parts)
- Previously painted substrates in sound condition

## Substrate Preparation





 <b>Mild Steel</b>	<b>DTM:</b> Sand with 240 Frecut <b>Primer:</b> Concept Zinc Phosphate Primer Sand with P600 wet or dry
<b>Aluminium</b>	Apply Concept 103 Etch Primer or Concept 110 Metal Etch or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
<b>Galvanised Iron</b>	Apply Concept 103 Etch Primer or Concept 110 Metal Etch or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
<b>Glass Reinforced Plastics (GRP)</b>	Apply Concept 103 Etch Primer or Concept 111 Universal Primer(HB) Sand with P600 wet or dry
<b>Previously painted Surfaces</b> (in sound condition)	Sand with P600 wet or dry
<b>Special Notes:</b> <ul style="list-style-type: none"> <li>• All surfaces must be thoroughly sanded and cleaned with Concept Wax &amp; Grease Remover prior to application.</li> <li>• Use white or light coloured primers under bright yellows, oranges and reds, if required.</li> </ul>	

## Product Preparation




	<ul style="list-style-type: none"> <li>• Weigh the concentrates into the required base in accordance with the relevant colour formula.</li> <li>• A maximum of only 10% reduced concentrates is allowed and a maximum of 35% for all concentrates, in total.</li> <li>• Stir or shake for a minimum of 10 minutes.</li> <li>• Never leave the mixture stand for more than 30 minutes before mixing.</li> </ul>			
 <b>Reducer</b>	Up to 15% (v/v) Concept 804 Enamel Thinner, if required 5-10% Concept Retarder Thinner, if required (to minimize blooming)			
 <b>Matting</b> (if required)	<b>Satin Finish:</b> Add 30% of 399 Flattening Base. <b>Matt Finish:</b> Add 45% of 399 Flattening Base. <b>Notes:</b> <ul style="list-style-type: none"> <li>• Never add more than 50% of 399 Flattening Base.</li> <li>• 399 Flattening Base must be added before adding a hardener or thinner.</li> <li>• The addition of 399 Flattening Base will reduce coverage.</li> </ul>			
 <b>Pot life</b> @ 25°C (77°F)	N/A			
 <b>Spray viscosity</b> @ 25°C (77°F)	<b>BSB 4 Cup</b> <b>Ford 4 Cup</b>	18-19 s 16-17 s		
    <b>Spray equipment</b>	<b>Gun type</b>  <b>Gravity Feed</b>  <b>HVLP</b>  <b>Suction feed</b>  <b>Airless, Air Assisted, Electrostatic</b>	<b>Fluid tip</b>  1.3-1.4 mm 0.051-0.055"  1.3-1.4 mm 0.051-0.055"  1.2-1.3 mm 0.047-0.051"	<b>Spray pressure</b>  200-240 kPa 2.0-2.4 bar 30-35 psi  40-70 kPa 0.4-0.7 bar 6-10 psi  200-240 kPa 2.0-2.4 bar 30-35 psi	<b>Spray Distance</b>  15-20 cm 6-8 inch  15-20 cm 6-8 inch  15-20 cm 6-8 inch
		Consult the manufacturer's instructions.		

# Technical Data Sheet

## Product Preparation cont.

	<b>Number of coats</b>	3	Apply one light coat followed by two even full coats. Avoid heavy wet coats.
	<b>DFT Recommended</b>	50 µm 2.0 mils	
	<b>Flash off time @ 25°C (77°F)</b>	5 min between coats	
	<b>Drying</b>	<b>Air Dry @ 25°C (77°F)</b>	Dry to handle: 4 hours
<p>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.</p>			

## Remarks

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

## Equipment Cleaning

Use recommended Concept Paints cleaner such as Concept Gunwash or Multi-Thinner

## Dry Film Properties

After 7 days drying, when compared to similar technology products.

<b>Gloss 60/20°</b>	92/84
<b>Water resistance</b>	Good
<b>Petrol resistance</b>	Good
<b>Durability</b>	Good

# Technical Data Sheet

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

Product Packaging			
Product Code 1	Product Code 2	Product Name	Package Size
G/341-G/355	3410341-3410355	Tinters	1L, 4L
G/381-G/382	3410381-3410382	Metallic Tinters	1L, 4L
G/371-G/375	3410371-3410375	Reduced Tinters	1L
G/399	3410399	399 Flattening Base	1L 4L
G/322	3410322	322 QD Economy Enamel Base	20L
A08C/ENA	8049200	804 Enamel Thinner	1L, 4L, 20L, 60L
A08C/RET	8109200	Retarder Thinner	1L, 4L, 20L

Safety
<p>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.</p> <p>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.</p>

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This Technical Data Sheet supersedes all previous issues.

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