

HD MEL 690

PRODUCT DATA SHEET

Product Description

A single component, quick drying, high gloss industrial alkyd enamel.

Recommended Uses

- As a finish coat system for protecting construction and mining heavy machinery, agricultural equipment, railcars, transportation vehicles, material handling and lifting equipment, pumps, valves, gear units, scaffolding, fencing and many other components.
- HD MEL 690 is particularly suited for use as a rapid drying system or fast handling and turnaround times maximizing production throughput. This Quick Drying enamel will dry rapidly at lower temperatures without the need for baking/heating after application.

Properties

- Easy to use one component product that can be brush applied but is designed for spray application
- Excellent hiding power and yield
- High film builds achievable at higher viscosity
- Quick Drying – 10 minutes
- Single pack
- QD Enamel may be applied at 75 microns dry film thickness where additional corrosion protection may be required.

Product Variation

1. HD MEL 690 HV

- A “High-Viscosity” grade, for higher film build applications
- For the user that want to adjust their own viscosities.

2. HD MEL 690 RFU

- A “Ready-For-Use” grade, for low film build application
- For the user that requires large volumes without having to adjust their own viscosities

3. HD MEL 690 Dipping

A modified grade specially formulation for dipping applications where a fast run off and uniform finish is required

Technical Information

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| • Colour | ALL RAL & IS Shades are available |
| • Finish | Smooth & Glossy (75 - 100 units@ 60°A) |
| • Density | 1.00 $\pm$ 0.05 |
| • Solids Content | 50 $\pm$ 5 % |
| • Typical Film Thickness | 25 - 40 Micron |
| • Method of Application | Spray, Brush, Roller |
| • Flash Point | Above 30°C |
| • Drying Information @ 30°C | Surface Dry 5-10 Minutes
Dry to Handle 3 - 4 Hrs |

Application

- Material is supplied in steel containers. This is a one component product and does not require a hardener.
- Agitate/stir the product well before use to ensure a homogeneous mix and no settlement of pigments
- The temperature of the mixed product should preferably be above 10°C; higher temperatures results in reduced sag resistance and faster cure
- Pot Life - No limitation, if product thickens use thinner to reduce viscosity.
- Thinner- HD QD Thinner-0-20% depending on application & product variation

Work Stoppage

- Thoroughly flush all equipment with Lacquer or HD QD Thinners.
- All unused material should be stored in tightly closed containers.
- Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage.
- Material should be filtered and viscosity re-adjusted before used.

Clean Up

- Clean all equipment immediately after use with Lacquer or QD Thinners.
- It is good working practice to periodically flush out the spray equipment during the course of the working day.
- Frequency of cleaning will depend upon the amount sprayed, temperature and elapsed time, including delays.

Limitation

- This product is not intended for use in aggressive, corrosive environments or on heavily pitted or contaminated steel.
- This product is not recommended for use in immersion conditions.
- Over-application will extend both the minimum over coating periods and handling times, and may be detrimental to long term over coating properties.
- Do not apply if temperature is less than 10°C, relative humidity exceeds 85% or temperature is within 3°C of dew point.
- When applying Enamel by brush or roller it may be necessary to apply multiple coats to achieve the total specified film thickness of 50 microns dft.

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Packing & Storage

Unit Size : 1 Lt, 5 Lt, 20 Lt,

Storage : Store in dry conditions out of direct sunlight away from source of heat or ignition. Store at temperature between 5 and 35°C.

Shelf Life : 12 months at 25°C – from date of manufacture.

Health & Safety Precaution

- Provide sufficient ventilation while working with thinner in confined spaces & stagnant air.
- Keep the material away from heat.
- Avoid inhalation of solvent vapor or paint mist by using facial mask.
- Use goggles & gloves to protect against direct contact of thinner with skin & eyes.
- In case of contamination, rinse with fresh running water & seek medical help at once.

Disclaimer

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