



HMG Coatings (South) Ltd
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PRODUCT NAME

Synergy™ OCF 4

TECHNICAL DATASHEET

PROPERTIES

Specially developed for industries that require a good all round durable finish in one product. Synergy™ OCF is a cost effective coating which provides the corrosion properties of a primer with the gloss levels associated with a top coat paint. This product is available two sheen levels Synergy™ OCF7 (70% s/gloss approx.) and Synergy™ OCF4 (yielding approx 40% satin), both sheens offer good exterior durability and excellent re-over coating properties.

TECHNICAL INFORMATION

Colour

Available in BS 381C, BS 4800, BS 2660, RAL. Some colours may contain lead-chromate pigments, check label for details.

Permanent Volume Solids

Approximately 42% dependent on colour.

Recommended Dry Film Thickness

75-80 microns

Theoretical Coverage

Approximately 5 sq metres per litre at a dry film thickness of 80 microns. NB. The practical coverage rate depends on many factors and will be less than the theoretical figure.

Method of Application

Brush/Roller (thin if necessary).
 Airless spray (15 – 17 thou tip).
 Conventional Spray

Drying Time

Touch Dry..... 15 minutes
 Thorough Dry...1 hour
 Handle Dry.....2-4 hours
 Hard Dry.....10-16 hours
 Full cure.....7 days

Above times are at 20°C, under normal conditions as the drying time depends on air temperature, air movement and relative humidity. Do not apply more than the recommended dry film thickness, as full cure of this coating will be dramatically retarded where there is excessive build or when applied in low temperatures.

Shelf Life

12 months in original unopened containers, stored under cover within the temperature range 10°C - 32°C.

Health & Safety

Familiarise yourself with this product's MSDS before use. If you need to obtain copies, telephone us on: 01264 356296



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APPLICATION

Surface Preparation

Shot blasting is the preferred method of surface preparation. Painting should then be carried out within four hours. If oxidation has occurred before painting the surface should be re-blasted. If shot blasting is not practical, then clean and degrease steel substrate, completely removing dust, burrs and oily residues. Sharp edges at welded seams should be ground down, weld spatter, dust, scale etc. should be removed. The resultant surface should be dry and free from lamination and dust.

Application Temperature

10 - 35°C

Application Conditions

Mix thoroughly before use. Apply a full even coat. Thinning and cleaning equipment 2691 multi purpose thinners. Do not apply or dry when air or surface temperature is below 10°C or in high humidity or where condensation is likely to occur (i.e. Surface temperature must always be a minimum of 3°C above dew point). Painting should only be carried out under good atmospheric conditions and clement weather. Preparation, painting and drying should never be undertaken: when air temperature falls below the minimum temperature for the coating, or during fog, mist, snow or when rain is imminent, or when the surface to be painted is wet with condensation or when condensation may occur during the drying period.

Wet Film Thickness

180 – 190 microns

THINNING AND CLEANING

Thinning

For Airless Spray, supplied ready for use.

For Brush/Roller maximum 5% of above solvent by vol.

Cleaning

Clean all equipment immediately after use with the above solvent. Ensure all lines, tips, etc. are thoroughly flushed out. It is not sufficient to leave equipment filled up with solvent / thinner.

Technical Data Sheets are also available on our website at www.hmgcoatings.co.uk

ALL MATERIALS SHOULD BE STIRRED AND CHECKED FOR COLOUR AND SHEEN BEFORE USE. NO CLAIMS FOR DISCREPANCY OF COLOUR OR GLOSS CAN BE ACCEPTED AFTER USE. INFORMATION CONTAINED ON THIS DATA SHEET IS TO THE BEST OF OUR KNOWLEDGE TRUE AND ACCURATE AND IS GIVEN IN GOOD FAITH, BUT WITHOUT WARRANTY, SINCE THE APPLICATION, USE AND PROCESSING OF THE PRODUCT IS BEYOND OUR CONTROL.