



THOMAS HOWSE LIMITED

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PRODUCT SPECIFICATION SHEET

HIGH BUILD VINYL

INTENDED USE

A rapid drying, non-convertible coating for application for ferrous and non-ferrous, decorative and structural metalwork where a high level of corrosion resistance is required. It may also be used as a primer/finish for most adequately prepared substrates, exhibiting good adhesion to well-prepared galvanised steel surfaces (see suitable substrates and preparation).

SUITABLE SUBSTRATES AND PREPARATION

Surface must be dry, sound and free from dirt, dust, rust and grease. Steel surfaces should be preferably blast cleaned to BS 4232 2ND quality or wire brushed to Swedish standards SIS 05 5900 st2. Galvanised steel should be free of white rust (zinc corrosive deposits) and if previously weathered should be washed with copious quantities of water to remove soluble salts. Galvanised steel that has been oiled should be thoroughly cleaned to remove all traces of oil prior to coating. Heavily chromated galvanised steel should be alkali cleaned to remove the chromate passivation. Bright spangled galvanised steel will require pre-treatment with our P66 T-Wash solution before applying the high build vinyl.

Viscosity	Approximately 180-200 seconds BS 4 Cup@20°C
Thinner	T7001 (T/1)
Spraying viscosity	As supplied or up to 10% thinners
Spraying equipment	Conventional : 1.4 - 1.8mm tip @ 3.5 – 4.2 bar Suction feed HVLP : 1.8mm tip @ 0.7 bar (max) Pressure pot HVLP : 1.0 - 1.4 mm tip @ 0.7 bar Airless : 11 - 21 thou Air assisted airless : 11 - 15 thou Electrostatic : On request to equipment manufacturers recommendations
Surface preparation	Mild steel : Surfaces must be clean, dry and free from dust, grease, oil, millscale, etc. For best results blast clean to SA2 and coat with a suitable blast primer within 4 hours Aluminium & galvanised steel must be pre-treated before application.
Film Thickness	Dry 25µ Wet 65µ conventional spray. Higher thickness using airless spray
Solids	Typically 38%
Volatile Organic Content	Below 680 grams/litre
Covering capacity	Approximately 8-10 sq metres per litre @ min 25µ
Drying times Substrate temp 20°C	Rapid drying time, 10 mins touch dry Dry to handle : typically 2 hours (dependent on conditions and film thickness) Full cure : Typically 2-3 days (dependent on conditions & film thickness)
Overcoating	For exterior application a minimum dry film thickness of 75 microns must be achieved by applying further coats of high build vinyl.
Specific Gravity	Typically 1.0 – 1.4 (dependant on shade)
Shelf life	2 years, in an unopened, original container from date of manufacture. Storage should be in accordance with the instructions in section 7 of the relevant MSDS
Finish	As specified
Colours	As specified
Health & Safety	Before using this product refer to Thomas Howse Ltd MSDS HS1