



## Technical Data Sheet 01.3

October 2016 Revision

# Craftmaster Coach Enamel

Craftmaster Paints Ltd, Academy Works, Norman Way Ind Est, Over, Cambs, CB24 5QE

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[www.craftmasterpaints.co.uk](http://www.craftmasterpaints.co.uk)

**Product:** Craftmaster Coach Enamel  
**Colour:** Full colour spectrum available

**Sizes Available:** 250ml, 500ml, 1 litre & 2.5 litre tins

**Description:** Craftmaster Coach Enamel is a traditional, ultra high quality, high build, high solids, alkyd synthetic enamel. It is formulated primarily for brushing but spray application can also produce excellent results. Craftmaster Coach Enamel offers ultimate gloss, build and scratch filling with an extra long wet edge time. It has excellent water resistance and flexibility with a good exterior durability and toughness.

**Maximum VOC Content (RFU):** 0.390kg/ltr      **Regulations Compliance:** 2004/42 IIA SB (D) 300

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### Technical Information

**Coverage:** 12sq metres per litre

**Flashpoint:** Above 32°C

**Storage:** 12 months in original sealed tin

**Temp Resistance:** 90 Degrees C

**Cleaning:** Ensure surface is clean and free of any contamination

**Environment:** Ensure the area where painting is to take place is suitable in terms of temperature and humidity as well as being free of airborne and surface contamination that may interfere with the successful application of the product

**Durability:** Ensure that a minimum total film thickness of 120 microns is achieved on the substrate. Account should be taken of film thickness removed when rubbing down paintwork between coats. The thorough rubbing down of two coats can result in the loss of the equivalent film thickness of one full coat.

**Health & Safety:** Please refer to Craftmaster Material Data Sheet M01.2 and to tin label prior to use. Suitable respiratory and personal protection equipment should be worn at all times.

**If you are unsure about ANY of the information contained in this or other data sheets, contact Craftmaster for advice before proceeding to use the product(s) in question.**

*This information relates only to the specific material designated and may not be valid for such material when used in combination with any other materials or processes. Such information is to the best of Craftmaster Paints Ltd's knowledge and belief accurate and reliable as of the date indicated. However no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the users responsibility to satisfy themselves as to the suitability and completeness or such information for their own particular use. We recommend this product for professional use only.*



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### Application Methods

#### **Brush Application**

We recommend Purdy Monarch Elite Paint Brushes as those best suited to our range of products.

**Thinner:** Craftmaster PPA Brushing Additive

**Ratio:** A maximum of 5% in difficult conditions

**Number of Coats:** The correct application of two coats of Coach Enamel will usually achieve sufficient film thickness to contribute to the minimum total film thickness of 120 microns as stated in the Paint Specification. Rubbing down, poor application and other factors may contribute to insufficient film thickness being applied and the requirement of additional coats. This should be applied onto a suitable base of Primer & High Build Undercoat as appropriate to your specification.

**Spray Application:** Use Craftmaster Synthetic Thinners at approximately 15% ratio, adjust as conditions dictate. A greater number of coats will be required when compared to brush painting due the thinner nature of the coats applied by spray.

**Touch Dry:** 2hrs at 20'C

**Through Dry:** 16hrs at 20'C

**Overcoat:** 24hrs (minimum)

**Film Thickness:** A Wet Film Thickness of approx 100 microns, will leave a Dry Film Thickness of approx 55 microns.

**DFT Per Coat:** Approx 35/50 microns per coat, less after rubbing down, dependant on Wet Film Thickness achieved.

**Note:** Craftmaster Technical Data Sheets indicate Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film Thickness will vary depending on actual use and specification. Great care should be taken to achieve the DFT stated in the agreed specification and to avoid areas of excessively low or high thickness.

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**Please Note: It is for the end user to ensure that this product is applied in the correct manner and to the correct standard. Craftmaster Paints Ltd can take no responsibility for faults in paint that is applied in conditions unsuited to painting or paint that has been improperly applied (either the method of application, use of unauthorised additives, insufficient paint build, or other practices which are not conducive to the successful application of our products). We strongly advise all users to consult both our Standard Paint Specification before applying any paint.**

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